

FLEXITEQ™ F70A060

Thermoplastic Vulcanizate

Marplex Australia Pty. Ltd.

Message:

FLEXITEQ™ F70A060 is a formulation based on Santoprene™ rubber technology. It is formulated for extrudability, grain retention and incorporates soft-touch and good tear resistance in a pre-coloured material. This material can be processed on conventional thermoplastic equipment for extrusion or injection moulding. It is polyolefin based and is completely recyclable.

| General Information | |
|---------------------|----------------------|
| Features | Recyclable materials |
| | Good tear strength |
| | Soft |

| | |
|-------------------|-------------------|
| Processing Method | Extrusion |
| | Injection molding |

| Physical | Nominal Value | Unit | Test Method |
|----------|---------------|------|-------------|
|----------|---------------|------|-------------|

| | | | |
|------------------|-------|-------------------|-----------|
| Specific Gravity | 0.958 | g/cm ³ | ASTM D792 |
|------------------|-------|-------------------|-----------|

| Hardness | Nominal Value | Unit | Test Method |
|----------|---------------|------|-------------|
|----------|---------------|------|-------------|

| | | | |
|--------------------------------------|----|--|------------|
| Durometer Hardness (Shore A, 15 sec) | 70 | | ASTM D2240 |
|--------------------------------------|----|--|------------|

| Elastomers | Nominal Value | Unit | Test Method |
|------------|---------------|------|-------------|
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|---------------------------------------|------|-----|-----------|
| Tensile Strength ¹ (Break) | 6.20 | MPa | ASTM D412 |
|---------------------------------------|------|-----|-----------|

| | | | |
|---|-----|---|-----------|
| Tensile Elongation ² (Break) | 480 | % | ASTM D412 |
|---|-----|---|-----------|

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|-----------------------------------|------|------|-----------|
| Tear Strength ³ (23°C) | 31.0 | kN/m | ASTM D624 |
|-----------------------------------|------|------|-----------|

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|--|----|---|------------|
| Compression Set ⁴ (23°C, 70 hr) | 29 | % | ASTM D395B |
|--|----|---|------------|

| Injection | Nominal Value | Unit |
|-----------|---------------|------|
|-----------|---------------|------|

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|--------------------|--------|----|
| Drying Temperature | < 60.0 | °C |
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|-------------|-----------|----|
| Drying Time | 3.0 - 4.0 | hr |
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| | | |
|------------------|-----------|----|
| Rear Temperature | 160 - 180 | °C |
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| | | |
|--------------------|-----------|----|
| Middle Temperature | 170 - 200 | °C |
|--------------------|-----------|----|

| | | |
|-------------------|-----------|----|
| Front Temperature | 190 - 210 | °C |
|-------------------|-----------|----|

| | | |
|------------------------|-----------|----|
| Processing (Melt) Temp | 190 - 210 | °C |
|------------------------|-----------|----|

| | | |
|------------------|-------------|----|
| Mold Temperature | 10.0 - 50.0 | °C |
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| | | |
|---------------|-------------|-----|
| Back Pressure | 5.00 - 20.0 | MPa |
|---------------|-------------|-----|

| Injection instructions |
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|------------------------|

Typical Mesh Screen Combination: 20/40/60

| NOTE |
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| | |
|----|--------------------|
| 1. | C mold, 500 mm/min |
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| | |
|----|-------------------------|
| 2. | Mouth die C, 500 mm/min |
|----|-------------------------|

| | |
|----|--------------------|
| 3. | C mold, 500 mm/min |
|----|--------------------|

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|----|--------|
| 4. | Type 2 |
|----|--------|

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