

# FLEXITEQ™ F55A910

Thermoplastic Vulcanizate

Marplex Australia Pty. Ltd.

## Message:

FLEXITEQ™ F55A910 is a formulation based on Santoprene™ rubber technology. It is formulated to incorporate soft-touch and good mouldability or extrusion, and formulated to bond to ABS, PS, PC, PMMA, ASA, PET & PPO/PS blends. FLEXITEQ™ F55A910 can be processed on conventional thermoplastic equipment for injection moulding or extrusion. It is polyolefin based and completely recyclable.

| General Information  |                         |       |             |
|--|-------------------------|-------|-------------|
| Features   | Good formability        |       |             |
|  | High liquidity          |       |             |
|  | Soft                    |       |             |
| Processing Method  | Extrusion               |       |             |
|  | Injection molding       |       |             |
| Physical   | Nominal Value           | Unit  | Test Method |
| Specific Gravity   | 1.04                    | g/cm³ | ASTM D792   |
| Hardness   | Nominal Value           | Unit  | Test Method |
| Durometer Hardness (Shore A, 15 sec)   | 55                      |       | ASTM D2240  |
| Elastomers   | Nominal Value           | Unit  | Test Method |
| Tensile Strength <sup>1</sup> (Break)  | 4.50                    | MPa   | ASTM D412   |
| Tensile Elongation <sup>2</sup> (Break)  | 600                     | %     | ASTM D412   |
| Tear Strength <sup>3</sup> (23°C)  | 22.0                    | kN/m  | ASTM D624   |
| Compression Set <sup>4</sup> (23°C, 70 hr)   | 45                      | %     | ASTM D395B  |
| Injection  | Nominal Value           | Unit  |             |
| Drying Temperature   | 70.0                    | °C    |             |
| Drying Time  | 3.0 - 4.0               | hr    |             |
| Rear Temperature   | 160 - 210               | °C    |             |
| Middle Temperature   | 180 - 230               | °C    |             |
| Front Temperature  | 190 - 240               | °C    |             |
| Mold Temperature   | 25.0 - 50.0             | °C    |             |
| Injection Rate   | Moderate-Fast           |       |             |
| Injection instructions   |                         |       |             |
| Melt Temperature: 210 - 230°C for two shot mouldingMelt Temperature: 230 - 250°C for insert moulding |                         |       |             |
| Extrusion instructions   |                         |       |             |
| Melting Temperature: 190 - 205°C for extrusion   |                         |       |             |
| NOTE   |                         |       |             |
| 1.   | C mold, 500 mm/min      |       |             |
| 2.   | Mouth die C, 500 mm/min |       |             |
| 3.   | C mold, 500 mm/min      |       |             |

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