

# EZPrene 9065A

Thermoplastic Vulcanizate

ENPLAST Americas, a Ravago Group Company

Message:

65 Shore A TPE (Thermoplastic Vulcanizate). Available in black, natural or pre-colored for injection molding and extrusion applications. This material is non-hygroscopic and offers excellent chemical resistance and physical properties. EZPrene is polyolefin based and is 100% recyclable.

| General Information                   |                            |                   |             |
|---------------------------------------|----------------------------|-------------------|-------------|
| Features                              | Lower die-out expansion    |                   |             |
|                                       | Good UV resistance         |                   |             |
|                                       | Recyclable materials       |                   |             |
|                                       | Good coloring              |                   |             |
|                                       | Good adhesion              |                   |             |
|                                       | Ozone resistance           |                   |             |
|                                       | Good chemical resistance   |                   |             |
|                                       | Low or no water absorption |                   |             |
| Appearance                            | Black                      |                   |             |
|                                       | Available colors           |                   |             |
|                                       | Natural color              |                   |             |
| Processing Method                     | Extrusion                  |                   |             |
|                                       | Injection molding          |                   |             |
| Physical                              | Nominal Value              | Unit              | Test Method |
| Specific Gravity                      | 0.930                      | g/cm <sup>3</sup> | ASTM D792   |
| Hardness                              | Nominal Value              | Unit              | Test Method |
| Durometer Hardness                    |                            |                   | ASTM D2240  |
| Shaw A, 5 seconds, extruded           | 65                         |                   | ASTM D2240  |
| Shore A, 5 seconds, injection molding | 67                         |                   | ASTM D2240  |
| Elastomers                            | Nominal Value              | Unit              | Test Method |
| Tensile Stress (100% Strain)          | 2.70                       | MPa               | ASTM D412   |
| Tensile Strength (Break)              | 5.00                       | MPa               | ASTM D412   |
| Tensile Elongation (Break)            | 490                        | %                 | ASTM D412   |
| Tear Strength                         | 24.0                       | kN/m              | ASTM D624   |
| Compression Set                       |                            |                   | ASTM D395   |
| 23°C, 22 hr                           | 30                         | %                 | ASTM D395   |
| 125°C, 70 hr                          | 53                         | %                 | ASTM D395   |
| Thermal                               | Nominal Value              | Unit              | Test Method |
| Brittleness Temperature               | -60.0                      | °C                | ASTM D746   |

| Dynamic Service Temperature | 130           | °C                 |
|-----------------------------|---------------|--------------------|
| Ozone Resistance            | Excellent     | ASTM D1149         |
| Injection                   | Nominal Value | Unit               |
| Drying Temperature          | 82.2          | °C                 |
| Drying Time                 | 2.0 - 3.0     | hr                 |
| Rear Temperature            | 191 - 204     | °C                 |
| Middle Temperature          | 196 - 210     | °C                 |
| Front Temperature           | 196 - 210     | °C                 |
| Nozzle Temperature          | 210 - 221     | °C                 |
| Processing (Melt) Temp      | 199 - 221     | °C                 |
| Mold Temperature            | 23.9 - 51.7   | °C                 |
| Injection Pressure          | 5.17 - 8.96   | MPa                |
| Injection Rate              | Fast          |                    |
| Screw Speed                 | 50 - 200      | rpm                |
| Clamp Tonnage               | 2.8 - 4.8     | kN/cm <sup>2</sup> |
| Cushion                     | 5.08 - 12.7   | mm                 |

#### Injection instructions

Holding Time: 5 to 7 Sec.Cooling Time: 30 to 50 Sec.

| Extrusion             | Nominal Value | Unit |
|-----------------------|---------------|------|
| Hopper Temperature    | 166 - 177     | °C   |
| Cylinder Zone 1 Temp. | 171 - 191     | °C   |
| Cylinder Zone 2 Temp. | 171 - 191     | °C   |
| Cylinder Zone 3 Temp. | 171 - 191     | °C   |
| Cylinder Zone 4 Temp. | 171 - 191     | °C   |
| Cylinder Zone 5 Temp. | 171 - 191     | °C   |
| Adapter Temperature   | 191 - 210     | °C   |
| Melt Temperature      | 191 - 199     | °C   |
| Die Temperature       | 191 - 210     | °C   |

#### Extrusion instructions

Screw: L/D 24:1 minimumCompression Zone: 355 - 390°F (180 - 200°C)Metering Zone: 375 to 410°F (190 to 210°C)Screw Speed: 30 - 80 rpmScreen Pack: 20/40/60

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#### Recommended distributors for this material

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