

# DIAMALLOY ENGINEERED ALLOYS TPE/ABS

## ST4600

Thermoplastic Elastomer Alloy  
Network Polymers, Inc.

Message:

DIAMALLOY ENGINEERED ALLOYS TPE/ABS ST4600 is a Thermoplastic Elastomer Alloy (TPE Alloy) product. It can be processed by injection molding and is available in North America.

Characteristics include:

- REACH Compliant
- RoHS Compliant
- WEEE Compliant
- Good Weather Resistance

General Information			
Features	Good Weather Resistance		
Agency Ratings	EC 1907/2006 (REACH)		
	EU 2002/96/EC (WEEE)		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Melt Mass-Flow Rate (MFR) <sup>1</sup> (230°C/3.8 kg)	15	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D, 23°C, 3.18 mm, Injection Molded)	46		ASTM D2240
Impact	Nominal Value	Unit	Test Method
Instrumented Dart Impact			ASTM D3763
23°C, 3.18 mm, Injection Molded, Maximum Energy	6.00	J	
23°C, 3.18 mm, Injection Molded, Total Energy	8.00	J	
Flammability	Nominal Value	Unit	Test Method
Burning Rate (3.18 mm)	42	mm/min	ISO 3795
Optical	Nominal Value		Test Method
Gardner Gloss (60°, 3.18 µm, Extruded Sheet)	10		ASTM D523
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 85.0	°C	
Drying Time	4.0 to 6.0	hr	
Suggested Max Moisture	0.10	%	

Suggested Shot Size	40 to 70	%
Suggested Max Regrind	25	%
Rear Temperature	230 to 260	°C
Middle Temperature	232 to 260	°C
Front Temperature	235 to 260	°C
Nozzle Temperature	220 to 260	°C
Processing (Melt) Temp	220 to 260	°C
Mold Temperature	71.1 to 82.2	°C
Injection Rate	Fast	
Back Pressure	0.517 to 1.03	MPa
NOTE		

1. Procedure A

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Recommended distributors for this material

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