

ENFLEX EA3555A

Thermoplastic Elastomer

ENPLAST Americas, a Ravago Group Company

Message:

55 Shore A TPE (Styrenic Block Copolymer based) for injection molding and extrusion applications. This grade offers soft/tactile feel and adhesion (overmolding) to Nylon.

General Information			
Features	High elasticity		
	Solvent resistance		
	Good UV resistance		
	Recyclable materials		
	Workability, good		
	Good coloring		
	Good adhesion		
	Ozone resistance		
	alkali resistance		
	Alcohol resistance		
	acid resistance		
	Detergent resistance		
	Oil resistance		
	Soft		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.948	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	8.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A, 10 seconds, extruded	55		ASTM D2240
Shore A, 10 seconds, injection molding	58		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (100% Strain)	1.48	MPa	ASTM D412
Tensile Strength (Break)	4.81	MPa	ASTM D412
Tensile Elongation (Break)	570	%	ASTM D412
Tear Strength	26.3	kN/m	ASTM D624
Compression Set			ASTM D395B
23°C, 22 hr	20	%	ASTM D395B

70°C, 22 hr	45	%	ASTM D395B
Thermal	Nominal Value	Unit	Test Method
Brittleness Temperature	-55.0	°C	ASTM D746
Dynamic Service Temperature	90	°C	
Injection	Nominal Value	Unit	
Drying Temperature	60.0 - 70.0	°C	
Drying Time	2.0 - 3.0	hr	
Rear Temperature	171 - 199	°C	
Middle Temperature	229 - 241	°C	
Front Temperature	241 - 249	°C	
Nozzle Temperature	221 - 241	°C	
Processing (Melt) Temp	229 - 249	°C	
Mold Temperature	10.0 - 48.9	°C	
Injection Pressure	5.17 - 8.96	MPa	
Injection Rate	Fast		
Screw Speed	50 - 200	rpm	
Clamp Tonnage	3.4 - 4.8	kN/cm ²	
Cushion	5.08 - 12.7	mm	

Injection instructions

Holding Time: 5 to 7 Sec.

Extrusion	Nominal Value	Unit
Drying Temperature	60.0 - 70.0	°C
Drying Time	2.0 - 3.0	hr
Hopper Temperature	160 - 179	°C
Cylinder Zone 1 Temp.	229 - 241	°C
Cylinder Zone 3 Temp.	241 - 249	°C
Cylinder Zone 5 Temp.	241 - 249	°C
Adapter Temperature	229 - 249	°C
Melt Temperature	229 - 249	°C
Die Temperature	229 - 249	°C

Extrusion instructions

Screw: L/D 20:1 or greater (L/D 24:1 preferred) Cooling Water: 60 - 85°F (15-30°C) Screw Speed: 100 - 200 rpm Screen Pack: 20/40/60

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