

RTP 6004-45A

Thermoplastic Elastomer

RTP Company

Message:

A 45 Shore A thermoplastic elastomer designed for overmolding onto nylon 6 substrates.

General Information			
Uses	overmolding		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.980	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	1.3 - 1.7	%	ASTM D955
Moisture Content		%	
Peel strength-Nylon 6 ¹	3.2	kN/m	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 10 sec)	51		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength ² (Break, 3.20 mm)	2.76	MPa	ASTM D412
Tensile Elongation ³ (Break)	300	%	ASTM D412
Tear Strength ⁴	14.0	kN/m	ASTM D624
Injection	Nominal Value	Unit	
Drying Temperature	79.4	°C	
Drying Time	2.0 - 3.0	hr	
Processing (Melt) Temp	216 - 249	°C	
Mold Temperature	48.9 - 65.6	°C	
Injection instructions			
Desiccant Type Dryer Required.			
NOTE			
1.	90°, 20 in/min, RTP 55, Interface Failure		
2.	C mold, 500 mm/min		
3.	Mouth die C, 500 mm/min		
4.	C mould		

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Recommended distributors for this material

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