

Technical Data Sheet
INVISION™ TX 5264U
Thermoplastic Vulcanizate
Engineering Plastics



Product Description

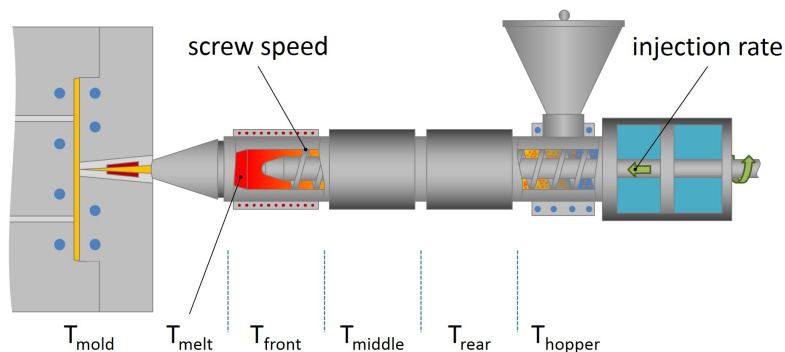
Invision TX 5264U is a multi-purpose, polyolefin based, fully-cured thermoplastic vulcanizate (TPV) that offers good processability, excellent compression set, high temperature performance and UV resistance. It can be provided in natural, black, and custom matched colors. It is recommended for applications requiring a material with the following properties:

General

Processing Method	• Blow Molding • Coextrusion	• Injection Molding • Profile Extrusion
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Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	0.962	0.960 g/cm³	ASTM D792
Elastomers	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Stress (100% Strain)	334 psi	2.30 MPa	ASTM D412
Tensile Strength (Break)	740 psi	5.10 MPa	ASTM D412
Tensile Elongation (Break)	> 320 %	> 320 %	ASTM D412
Tear Strength	194 lbf/in	34.0 kN/m	ASTM D624
Compression Set			ASTM D395B
73°F (23°C), 22 hr	17 %	17 %	
158°F (70°C), 22 hr	27 %	27 %	
257°F (125°C), 70 hr	42 %	42 %	
Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Durometer Hardness (Shore A, 5 sec)	65	65	ASTM D2240
Aging	Nominal Value (English)	Nominal Value (SI)	Test Method
Change in Tensile Strength in Air			ASTM D573
302°F (150°C), 168 hr	-11 %	-11 %	
Change in Tensile Modulus in Air			ASTM D573
302°F (150°C), 168 hr	0.0 %	0.0 %	
Change in Ultimate Elongation in Air			ASTM D573
302°F (150°C), 168 hr	-11 %	-11 %	
Change in Durometer Hardness in Air			ASTM D573
Shore A, 302°F (150°C), 168 hr	2.0	2.0	
Change in Volume			ASTM D471
257°F (125°C), 70 hr, in ASTM #3 Oil	77 %	77 %	

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature - Desiccant Dryer	180 °F	82 °C
Drying Time - Desiccant Dryer	2.0 to 4.0 hr	2.0 to 4.0 hr
Dew Point	-40 °F	-40 °C
Suggested Max Moisture	0.08 %	0.08 %
Rear Temperature	347 to 383 °F	175 to 195 °C
Middle Temperature	374 to 392 °F	190 to 200 °C
Front Temperature	374 to 401 °F	190 to 205 °C
Nozzle Temperature	383 to 410 °F	195 to 210 °C
Processing (Melt) Temp	356 to 392 °F	180 to 200 °C
Mold Temperature	59 to 122 °F	15 to 50 °C
Injection Pressure	5950 to 14900 psi	41.0 to 103 MPa
Holding Pressure	4790 to 10000 psi	33.0 to 69.0 MPa
Back Pressure	580 to 1450 psi	4.00 to 10.0 MPa
Screw Speed	50 to 150 rpm	50 to 150 rpm
Clamp Tonnage	2.0 to 4.0 tons/in ²	2.7 to 5.5 kN/cm ²
Cushion	0.118 to 0.236 in	3.00 to 6.00 mm
Screw L/D Ratio	16.0:1.0 to 22.0:1.0	16.0:1.0 to 22.0:1.0

Notes

These are typical property values not to be construed as specification limits.