

**LTP Series**
**THERMOLAST® V**

The LTP Series is your material solution for sealings requiring high temperature resistance. The compounds are characterized by an excellent adhesion to PP.

**Typical applications**

- Fastenings
- Grommets
- Seals

**Material advantages**

- Adhesion to PP
- Excellent heat resistance up to 140 °C
- Excellent hysteresis behaviour
- Excellent mechanical properties
- Exceptional long-term compression set

**Processing Method:** Injection Molding

	Color / RAL DESIGN	Hardness DIN ISO 7619-1 ShoreA	Density DIN EN ISO 1183-1 g/cm <sup>3</sup>	Tensile Strength <sup>1</sup> DIN 53504/ISO 37 MPa	Elongation at Break <sup>1</sup> DIN 53504/ISO 37 %	Tear Resistance ISO 34-1 Methode B (b)(Graves) N/mm	CS 72 h/23 °C DIN ISO 815-1 Method A %	CS 24 h/70 °C DIN ISO 815-1 Method A %	CS 24 h/100 °C DIN ISO 815-1 Method A %	CS 24 h/120 °C DIN ISO 815-1 Method A %
TV5LVN	natural	50	1.050	4.0	400	12.0	12	33	43	45
TV5LVZ	black	50	1.050	4.0	400	9.0	15	24	39	46
TV6LVN	natural	58	1.050	5.0	400	15.0	13	35	38	42
TV6LVZ	black	60	1.050	5.0	400	15.0	13	35	38	41
TV7LVN	natural	68	1.050	7.5	450	15.0	14	36	37	43
TV7LVZ	black	68	1.050	6.5	400	15.0	14	36	37	41
TV8LVN	natural	79	1.050	10.0	450	21.0	22	42	44	52
TV8LVZ	black	79	1.050	9.5	450	23.0	19	37	41	51
TV9LVN	natural	89	1.050	13.5	450	30.0	33	52	60	67
TV9LVZ	black	89	1.050	12.5	450	27.0	26	52	52	60

This datasheet is an extract of the KRAIBURG TPE program. Please contact KRAIBURG TPE to select the compound suitable for the requirements.



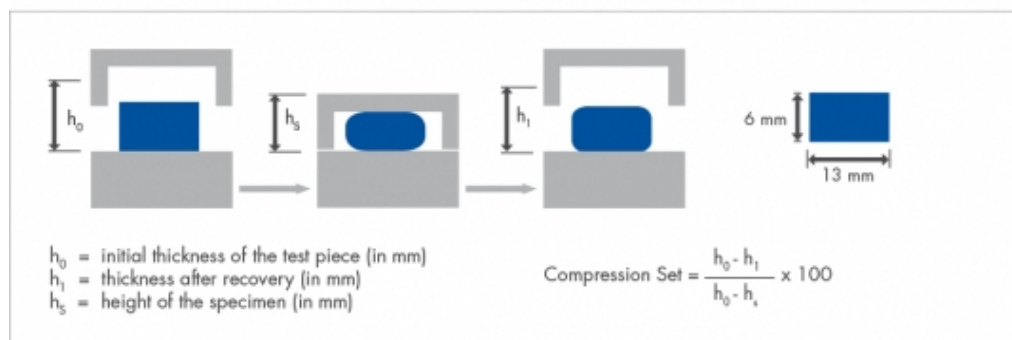
<sup>1</sup> Deviating from ISO 37 standard test piece S2 is tested with a traverse speed of 200 mm/min.

All values published in this data sheet are rounded average values.

## Compression Set

### Compression Set (acc. DIN ISO 815)

For the compression set testing the following specimen is used:  
The specimen is a cylindrical disk shaped 6 mm thick and 13 mm in diameter.



The specimen is compressed by 25%. The compressed specimen is heated to the test temperature. DIN ISO 815 describes two methods.

**Method A:** The specimen is allowed to recover immediately after its aging in the oven and then cooled down to room temperature. After 30 minutes the thickness of the specimen is measured and the compression set calculated.

**Method B:** The specimen is cooled down to room temperature after its aging in the oven and then allowed to recover.

Test results gained from method B are in general higher than from method A.



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**Processing Guideline Injection Molding**

Cylinder temperature	180 - 200 - 220 °C, max. 250 °C (360 - 390 - 430 °F, max. 480 °F)
Hotrunner	Hot runner temperatures: 200 -250 °C (390 - 480 °F). The runner should be empty after a maximum of 2 - 3 shots.
Injection pressure	200 - 1000 bar (2900 - 14504 psi) (depending on the size and weight of the part).
Injection rate	In general, the fill time should not be more than 1–2 seconds.
Hold pressure	We recommend to derive the optimum hold pressure from determining the solidification point, starting with 40 % - 60 % of the required injection pressure.
Back pressure	20 - 100 bar; if color batches are used, higher back pressure is necessary.
Screw retraction	If an open nozzle is used processing with screw retraction is advisable.
Mold temperature	25 - 40 °C (77 - 104 °F)
Predrying	Pre drying of the material is not necessary; if surface moisture forms as a result of changes in temperature, the material should be dried for 2 - 4 hours at 60 - 80 °C (140 - 175 °F).
Needle valve	With materials < 50 Shore A the use of a needle valve is advisable.
Screw geometry	Standard 3-zone polyolefine screw.
Residence time	The residence time is to be set as short as possible with a maximum of 10 minutes.
Cleaning recommendation	For cleaning and purging of the machine it is appropriate to use polypropylene or polyethylene. Machine must be PVC-free.

