

September 2013

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Product Advantages: TPV with Excellent Color-ability & Appearance. Strong adhesion to EPDM, Polypropylene Compounds and Polyethylene. Processes like a Thermoplastic and acts like a Rubber

Nominal Physical Properties	Test Method	Unit	3485
Density	ISO 1183	g/cm ³	0.88
Melt Flow (230°C/5 kg)	ISO 1133	g/10min	13
Compression Set (70 hrs @ 100 °C)	ASTM D395	MPa	30
Tensile Strength	ISO 37 (500mm/min, Die C)	MPa	3.4
Tensile Elongation	ISO 37 (500 mm/min, Die C)	%	430
Durometer Hardness (15 second delay)	ASTM D2240	Shore A	35
Brittle Point	ASTM D2137	°C	< -60

Typical Applications:

- Corner Mold for Weatherseals
- Over-molding
- Injection Molded Parts

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Tool Design Guidelines*

Wall Thickness (WT)	2 – 4 mm
Gate Type	Fan Gate
Gate Thickness (GT)	0.6 – 0.9 x WT
Gate Width (GW)	> 2 x GT
Gate Land (GL)	< 0.75 mm
Runner Type	Round
Sprue “O” Diameter	3.5 x WT
Main-Runner (SR)	2.5 x WT
Secondary-Runner (MR)	1.5 x WT
Draft	3 – 6 ° per side
Inside Radius (IR)	WT / 2
Outside Radius (OR)	WT + IR
Surface Texture	Light Stipple
Surface Coating	Nickel / Teflon
Vent Quantity	1 Every Inch
Vent Depth	0.013 – 0.025 mm
Vent Width	5 mm

Processing Guidelines

Nozzle Temp. (°F)	390 – 470
Front Zone (°F)	390 – 470
Middle Zone (°F)	370 – 450
Rear Zone (°F)	350 – 430
Mold Temp. (°F)	70 – 120
Injection Speed	Fast
Screw RPM	Slow
Injection Pressure (%)	20% more than actual transfer pressure
Back Pressure (psi)	50 – 100
Pack/Hold Pressure	40 – 80% of Injection Pressure

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