

April 2012

# 4855

**Product Advantages:** Low Die Drool. Recyclable TPV that processes like a Thermoplastic and acts like a Rubber

| Nominal Physical Properties              | Test Method                   | Unit              | 4855 |
|------------------------------------------|-------------------------------|-------------------|------|
| Density                                  | ISO 1183                      | g/cm <sup>3</sup> | 0.88 |
| Melt Flow (230°C/10Kg)                   | ISO 1133                      | g/10min           | 20   |
| Durometer Hardness<br>(10 second delay)  | ISO 868                       | Shore A           | 68   |
| Tensile Modulus (M100 /<br>100% Modulus) | ISO 37<br>(500mm/min, Die C)  | MPa               | 3.4  |
| Tensile Strength                         | ISO 37<br>(500mm/min, Die C)  | MPa               | 8.2  |
| Tensile Elongation                       | ISO 37<br>(500 mm/min, Die C) | %                 | 700  |
| Compression Set<br>(22 hrs at 23 °C)     | ASTM D395                     | %                 | 32   |
| Compression Set<br>(22 hrs at 70 °C)     | ASTM D395                     | %                 | 48   |
| Notched Izod Impact at -30 °C            | ISO 180                       | ---               | NB   |

### Typical Applications:

- Opening Trim
- Body Seals / Weather Stripping
- Hoses, Tubes, and Profile Extrusion

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# ESPOLEX®

## THERMOPLASTIC ELASTOMER

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### Extrusion Equipment Recommendations

|                   |                                                                           |
|-------------------|---------------------------------------------------------------------------|
| Extruder Type     | Twin Screw or Single Screw with Mixing Zone                               |
| Single Screw Type | Full Flight General Purpose with L/D Ratio > 20:1 & 3:1 Compression Ratio |

### Processing Guidelines

|               |                 |
|---------------|-----------------|
| Feed Zone     | 90 °F – 210 °F  |
| Kneading Zone | 360 °F – 395 °F |
| Die           | 395 °F – 430 °F |

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