Enflex S3025A

Product Description:
25 Shore A TPE (Styrenic Block Copolymer based) available in both black and natural for injection molding and extrusion applications, with low compression set and good heat resistance.

Properties	Value	Unit	Standard
Physical			
Hardness - Injection Molded, 10 sec	25	Shore A	ASTM D2240
Hardness - Extruded, 10 sec	23	Shore A	ASTM D2240
Density	0.89	g/cm3	ASTM D792
Mechanical			
Tensile Strength at Break	525 (3.6)	psi (MPa)	ASTM D412
Elongation at Break	750	%	ASTM D412
100% Modulus	125 (0.86)	psi (MPa)	ASTM D412
Tear Strength	105 (18.4)	lbs/in (kN/m)	ASTM D624
Compression Set			
22h / 23 ◦C	17	%	ASTM D395B
22h / 70 ◦C	59	%	ASTM D395B
Service Temperatures			
Brittleness Point	-60	°C	ASTM D746
Dynamic Service Temperature	90	°C	
Rheology			
Melt Flow Rate, 230°C / 2.16kg load	8.0	g/cm3	ASTM D1238

Features
Overmolded and Co-extrusion adhesion to Polypropylene
Rubberlike elasticity, low compression set
Ease of Coloring by proper masterbatch (PP/PE preferred)
Ease of processing
Recyclability

Environmental Resistance
Ozone – excellent
UV – Good (Can be enhanced with UV stabilizer)
Water – Excellent
Alcohol – Excellent
Oils and solvents – Good
Detergent – Good
Weak Acids and Bases – Good to excellent

Plant Location:
616 111th St.
Arlington, TX 76011
Ph # (817) 635-4770

Headquarters:
1900 Summit Tower Blvd
Suite 900
Orlando, FL 32810
Ph # (407) 875-9595

www.ravago.com
www.enplastamericas.com

ISO 9001-2008

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Processing Parameters

Drying Conditions

It is not necessary to pre-dry this material but in the event of moisture accumulation or evidence of splay, the material can be dried for 2-3 hours at 150 -160°F (66 – 71°C).

Injection Molding Conditions

Temperatures:

Rear: 340 – 390°F (171 - 200°C)
Middle: 350 – 410°F (177 – 210°C)
Front: 375 – 430°F (191 – 221°C)
Nozzle: 390 – 445°F (200 – 230°C)
Melt Temperature: 390 – 430°F (200– 220°C)
Mold Temperature: 50 – 120°F (10 – 50°C)

Injection Pressure: 750 – 1300psi
Injection Speed: Fast (0.5 – 2.0 Seconds)
Screw Speed: 50 – 200 rpm
Hold Times: 5-7 seconds
Cushion: 0.2 - 0.5 inch
Cooling Times: 30 – 50
Clamp Tonnage: 2.0 to 3.5 tons/in^2

Extrusion Conditions

Screw: L/D 20:1 or greater (L/D 24:1 preferred)
Temperatures:

Feed Throat: 320-350°F (160 – 180°C)
Feed Zone: 340 – 375°F (170 – 190°C)
Compression Zone: 355 – 390°F (180 – 200°C)
Metering Zone: 375 – 410°F (190 – 210°C)
Die/Adapter: 375 – 410°F (190 – 210°C)
Melt Temperature: 375 – 390°F (190 – 200°C)
Cooling Water: 60 – 85°F (15-30°C)

Screw Speed: 100 - 200 rpm
Screen Pack: 20/40/60

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