

**TECHNICAL DATA AND PROCESS SHEET**

**TPE 45A SHORE HARDNESS FOR CHEMICAL BOND OVERMOLD OF ABS, PC, PC/ABS, PROPIONATE, ACRYLIC AND NYLONS**

**INCOLOR TPE45AOM**

**TYPICAL PROPERTIES**

<b>PROPERTY</b>	<b>VALUE</b>	<b>UNIT</b>	<b>METHOD</b>
<b>PHYSICAL</b>			
SPECIFIC GRAVITY	0.98	-	ASTM D792
<b>MECHANICAL</b>			
TENSILE STRENGTH, BRK	600	psi	ASTM D638
TENSILE ELONGATION	750	%	ASTM D638
TEAR STRENGTH	140	pli	ASTM D624
HARDNESS SHORE A	45	A	ASTM D2240
<b>PROCESSING</b>			
DRYING TEMPERATURE	155-160	°F	
DRYING TIME	4	hrs	
BARREL TEMP FRONT ZONE	385-395	°F	
BARREL TEMP FRONT ZONE	380-390	°F	
BARREL TEMP FRONT ZONE	365-375	°F	
MOLD TEMPERATURE	WARM AS POSSIBLE		
BACK PRESSURE	50-100	psi	
SCREW SPEED	MEDIUM TO FAST		
L/D MINIMUM	20/1		

TSC 6/18/12

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