

tivilon® H70 Dx 6

Thermoplastic Vulcanizate

API SpA

Message:

tivilon®H70 Dx 6 is a thermoplastic vulcanized rubber (TPV) product. It can be processed by extrusion or injection molding and is available in Europe.
Features include:
environmental protection/green
Heat resistance

General Information			
Features	Recyclable materials		
	Heat resistance, high		
Appearance	Available colors		
Processing Method	Extrusion		
	Injection molding		

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.14	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	3.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 15 sec)	70		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
--	6.00	MPa	ASTM D638
100% strain	2.50	MPa	ASTM D638
300% strain	4.00	MPa	ASTM D638
Tensile Elongation (Break)	500	%	ASTM D638
Elastomers	Nominal Value	Unit	Test Method
Tear Strength ¹	24.0	kN/m	ASTM D624
Compression Set (70°C, 24 hr)	45	%	ASTM D395

Additional Information			
Dx = UV Resistance Level			
DE = standard UV resistance level			
DI = medium UV resistance level			
DR = high UV resistance level			

Injection	Nominal Value	Unit
Drying Temperature	75.0 - 80.0	°C
Drying Time	1.5 - 2.0	hr
Rear Temperature	170 - 180	°C
Middle Temperature	180 - 190	°C

Front Temperature	185 - 200	°C
Nozzle Temperature	190 - 210	°C
Mold Temperature	35.0 - 50.0	°C

Injection instructions

Injection Pressure: Medium Back Pressure: Low to Medium Locking Pressure: Medium to Fast

Extrusion	Nominal Value	Unit
Drying Temperature	75.0 - 80.0	°C
Drying Time	1.5 - 2.0	hr
Cylinder Zone 1 Temp.	160 - 170	°C
Cylinder Zone 2 Temp.	170 - 180	°C
Cylinder Zone 3 Temp.	175 - 185	°C
Cylinder Zone 4 Temp.	180 - 190	°C
Die Temperature	190 - 200	°C

Extrusion instructions

L/D Ratio: >20:1 Compression Ratio: 1:2.5

NOTE

- Without Notch

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Recommended distributors for this material

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