

tivilon® M 65 DX 4

Thermoplastic Vulcanizate

API SpA

Message:

tivilon®M 65 DX 4 is a thermoplastic vulcanized rubber (TPV) product. It can be processed by extrusion or profile extrusion molding and is available in Europe. Typical application areas are: engineering/industrial accessories. The main features are: environmental protection/green.

General Information	
Features	Recyclable materials
Uses	Washer
	Profile
Appearance	Available colors
Processing Method	Extrusion
	Profile extrusion molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.07	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	6.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 15 sec)	65		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
--	6.50	MPa	ASTM D638
100% strain	1.80	MPa	ASTM D638
300% strain	3.00	MPa	ASTM D638
Tensile Elongation (Break)	650	%	ASTM D638
Elastomers	Nominal Value	Unit	Test Method
Tear Strength ¹	27.0	kN/m	ASTM D624
Compression Set (70°C, 24 hr)	43	%	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: MediumBack Pressure: Low to MediumLocking 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: >20:1Compression Ratio: 1:2.5		
NOTE		
1.	Without Notch	

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