

Viprene™ P65A-22U-NAT

Thermoplastic Vulcanizate
Alliance Polymers & Services

Message:

Viprene™ P65A-22U-NAT is a UV and Heat Stabilized TPV (thermoplastic vulcanizate elastomer). This material can be easily procesed by extrusion or injection molding. It exhibits easy flowing characteristics.

General Information	
Additive	heat stabilizer
	UV stabilizer
Features	Good UV resistance
	Good liquidity
	Thermal Stability
Appearance	Natural color
Forms	Particle
Processing Method	Extrusion
	Injection molding

Physical	Nominal Value	Unit	Test Method
Density	0.970	g/cm³	ISO 2781
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	65		ISO 868
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ISO 37
100% strain	2.50	MPa	ISO 37
300% strain	3.80	MPa	ISO 37
Tensile Stress (Break)	7.20	MPa	ISO 37
Tensile Elongation (Break)	550	%	ISO 37
Tear Strength	40	kN/m	ISO 34-1
Compression Set (70°C, 22 hr)	22	%	ASTM D395B
Thermal	Nominal Value	Unit	Test Method
Brittleness Temperature	-60.0	°C	ASTM D746
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.00 mm	HB		UL 94
1.50 mm	HB		UL 94
3.00 mm	HB		UL 94
Injection	Nominal Value	Unit	

Drying Temperature	80.0	°C
Drying Time	3.0	hr
Rear Temperature	180	°C
Middle Temperature	185	°C
Front Temperature	185	°C
Nozzle Temperature	185 - 220	°C
Processing (Melt) Temp	190 - 230	°C
Mold Temperature	10.0 - 50.0	°C
Back Pressure	0.500 - 0.850	MPa
Screw Speed	100 - 200	rpm
Clamp Tonnage	4.0 - 7.0	kN/cm ²

Injection instructions

Injection Speed: 50 mm/sec or more

Extrusion	Nominal Value	Unit
Drying Temperature	80.0	°C
Drying Time	3.0	hr
Cylinder Zone 1 Temp.	180	°C
Cylinder Zone 2 Temp.	185	°C
Cylinder Zone 3 Temp.	185	°C
Die Temperature	195	°C

Extrusion instructions

Gate Temperature: 190°C (374°F) Die Pressure: 4.8 to 17 MPa (696 to 2465 psi)

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Recommended distributors for this material

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