

ENFLEX V1050D

Thermoplastic Vulcanizate

ENPLAST Americas, a Ravago Group Company

Message:

Enflex V1050D TPV (thermoplastic vulcanizate) is a general purpose rigid black EPDM/PP compound available in both natural and black. This grade is design for injection molding, extrusion and blow molding applications requiring high rigidity with high heat resistance.

General Information			
Features	Low compressive deformability		
	Rigidity, high		
	Solvent resistance		
	Good UV resistance		
	Recyclable materials		
	Workability, good		
	Ozone resistance		
	alkali resistance		
	Alcohol resistance		
	Heat resistance, high		
	acid resistance		
	Detergent resistance		
	Oil resistance		
	General		
Appearance	Black		
	Natural color		
Processing Method	Blow molding		
	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.950	g/cm ³	ASTM D792
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw D, 5 seconds, extruded	50		ASTM D2240
Shore D, 5 seconds, injection molding	51		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (100% Strain)	11.0	MPa	ASTM D412
Tensile Strength (Break)	25.0	MPa	ASTM D412
Tensile Elongation (Break)	720	%	ASTM D412

Tear Strength ¹	102	kN/m	ASTM D624
Compression Set			ASTM D395
70°C, 22 hr	70	%	ASTM D395
125°C, 70 hr	90	%	ASTM D395
Thermal	Nominal Value	Unit	Test Method
Brittleness Temperature	-30.0	°C	ASTM D746
Melting Temperature	158	°C	ASTM D1238
Dynamic Service Temperature	130	°C	
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.080	%	
Rear Temperature	177 - 188	°C	
Middle Temperature	182 - 193	°C	
Front Temperature	188 - 199	°C	
Nozzle Temperature	199 - 221	°C	
Processing (Melt) Temp	199 - 232	°C	
Mold Temperature	10.0 - 48.9	°C	
Injection Pressure	5.17 - 8.96	MPa	
Injection Rate	Fast		
Screw Speed	50 - 200	rpm	
Clamp Tonnage	4.1 - 6.9	kN/cm ²	
Cushion	5.08 - 12.7	mm	
Injection instructions			
Holding Time: 5 to 7 Sec.Cooling Time: 30 to 50 Sec.			
Extrusion	Nominal Value	Unit	
Hopper Temperature	160 - 177	°C	
Cylinder Zone 1 Temp.	171 - 191	°C	
Cylinder Zone 2 Temp.	171 - 191	°C	
Cylinder Zone 3 Temp.	171 - 191	°C	
Cylinder Zone 4 Temp.	171 - 191	°C	
Cylinder Zone 5 Temp.	171 - 191	°C	
Adapter Temperature	191 - 210	°C	
Melt Temperature	191 - 199	°C	
Die Temperature	191 - 210	°C	
Extrusion instructions			
Screw: L/D 20:1 or greater (L/D 24:1 preferred)Compression Zone: 355 - 390°F (180 - 200°C)Metering Zone: 375 to 410°F (190 to 210°C)Cooling Water: 60 - 85°F (15 - 30°C)Screw Speed: 100 - 200 rpmScreen Pack: 20/40/60			
NOTE			
1.	C mould		

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