HIPEX® HX6ICN (Series: HTR/OR)

Thermoplastic Elastomer

KRAIBURG TPE

Message:

The HTR/OR Series is your material solution for applications requiring high temperature and oil resistance.
Typical applications
Closures
Fastenings
Flexible Connections
Seals
Material advantages
Excellent heat resistance up to 150 °C
Excellent resistance againstmotor and gearbox oil
For injection molding
Recyclable

General Information			
Features	Recyclable materials Heat resistance, high Oil resistance		
Uses	Fasteners Connector Seals Shell		
Appearance	Natural color		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.10	g/cm³	ISO 1183
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness (Shore A)	58		ISO 7619
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress [1] (Yield)	5.00	MPa	ISO 37
Tensile Elongation [2] (Break)	300	%	ISO 37
Tear Strength	14	kN/m	ISO 34-1
Compression Set			ISO 815
23°C, 72 hr	30	%	ISO 815
70°C, 24 hr	54	%	ISO 815
100°C, 24 hr	58	%	ISO 815
120°C, 24 hr	64	%	ISO 815
Injection	**Nominal Value**	**Unit**	
Drying Temperature	105	°C	

Drying Time	2.0	hr
Suggested Max Moisture	0.050	%
Rear Temperature	210	°C
Middle Temperature	220	°C
Front Temperature	230	°C
Mold Temperature	40.0 - 60.0	°C
Injection Pressure	120 - 200	MPa
Back Pressure	2.00 - 5.00	MPa

Injection instructions
Hot Runner Temperature: 180 - 220°CThe runner should be empty after a maximum of 2 - 3 shots.

NOTE	
1.	Type S2, 200 mm/min
2.	Type S2, 200 mm/min

Recommended distributors for this material

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