

ENFLEX EA3770A

Thermoplastic Elastomer

ENPLAST Americas, a Ravago Group Company

Message:

70 Shore A TPE (Styrenic Block Copolymer based) available in black and natural for injection molding and extrusion applications. This grade offers soft/tactile feel and adhesion (overmolding or co-extrusion) to ABS, PC and HIPS/PS.

General Information			
Features	High elasticity		
	Solvent resistance		
	Good UV resistance		
	Recyclable materials		
	Workability, good		
	Good coloring		
	Good adhesion		
	Ozone resistance		
	alkali resistance		
	Alcohol resistance		
	acid resistance		
	Detergent resistance		
	Oil resistance		
	Soft		
Appearance	Black		
	Natural color		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.988	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	7.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A, 10 seconds, extruded	67		ASTM D2240
Shore A, 10 seconds, injection molding	70		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (100% Strain)	1.90	MPa	ASTM D412
Tensile Strength (Break)	6.00	MPa	ASTM D412
Tensile Elongation (Break)	550	%	ASTM D412

Tear Strength	33.3	kN/m	ASTM D624
Compression Set			ASTM D395B
23°C, 22 hr	25	%	ASTM D395B
70°C, 22 hr	65	%	ASTM D395B

Thermal	Nominal Value	Unit	Test Method
Brittleness Temperature	-40.0	°C	ASTM D746
Dynamic Service Temperature	90	°C	

Injection	Nominal Value	Unit
Drying Temperature	54.4 - 71.1	°C
Rear Temperature	149 - 171	°C
Middle Temperature	171 - 191	°C
Front Temperature	199 - 221	°C
Nozzle Temperature	199 - 221	°C
Processing (Melt) Temp	191 - 210	°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	3.4 - 4.8	kN/cm ²
Cushion	5.08 - 12.7	mm

Injection instructions
Holding Time: 5 to 7 Sec.

Extrusion	Nominal Value	Unit
Drying Temperature	54.4 - 71.1	°C
Hopper Temperature	149 - 171	°C
Cylinder Zone 1 Temp.	171 - 191	°C
Cylinder Zone 3 Temp.	171 - 191	°C
Cylinder Zone 5 Temp.	179 - 199	°C
Adapter Temperature	179 - 210	°C
Melt Temperature	191 - 221	°C
Die Temperature	179 - 210	°C

Extrusion instructions

Screw: L/D 20:1 or greater (L/D 24:1 preferred) Cooling Water: 60 - 85°F (15-30°C) Screw Speed: 100 - 200 rpm Screen Pack: 20/40/60

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