

Dryflex® V 60A101

Thermoplastic Vulcanizate

ELASTO

Message:

Dryflex V 60A001: Thermoplastic Elastomer

Base Material: TPV

Hardness: 60 Shore A

Service Temperature: -50°C to +135°C

Colour: Black, but available in any colour shade

Presentation: Free flowing pellets. May require pre-drying before processing.

Weather Resistance: Excellent

Ozone-/UV- Resistance: Excellent

Chemical Resistance: Excellent

Recycling: 100% recyclable

Mould Shrinkage (linear): Approx. 0.75 - 2% depending on e.g. shape of the detail and placement of gate

General Information			
Features	Good Chemical Resistance		
	Good Processability		
	Good UV Resistance		
	Good Weather Resistance		
	Ozone Resistant		
	Recyclable Material		
Appearance	Black		
	Colors Available		
Forms	Pellets		
Processing Method	Extrusion		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	0.930	g/cm ³	ISO 2781
Molding Shrinkage ¹	0.75 to 2.0	%	
Hardness	Nominal Value	Unit	Test Method
Shore Hardness (Shore A, 15 sec)	60		ISO 868
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ISO 37
Across Flow : 100% Strain	2.00	MPa	
Flow : 100% Strain	3.50	MPa	
Tensile Stress			ISO 37
Across Flow : Yield	5.50	MPa	
Flow : Yield	3.50	MPa	

Tensile Elongation			ISO 37
Across Flow : Break	520	%	
Flow : Break	120	%	
Tear Strength ²			ISO 34-1
Across Flow	19	kN/m	
Flow	20	kN/m	
Compression Set ³			ISO 815
23°C, 24 hr	20	%	
70°C, 24 hr	30	%	
100°C, 24 hr	37	%	
125°C, 70 hr	55	%	
Aging	Nominal Value	Unit	Test Method
Change in Tensile Strength in Air (150°C, 168 hr)	3.0	%	ISO 37
Change in Tensile Strain at Break in Air (150°C, 168 hr)	-9.0	%	ISO 37
Change in Shore Hardness in Air (Shore A, 150°C, 168 hr)	4.0		ISO 37
Change in Tensile Stress			ISO 37
125°C, 168 hr, in ASTM #1 Oil	-30	%	
125°C, 168 hr, in IRM 903 Oil	-49	%	
Change in Tensile Strain at Break			ISO 37
125°C, 168 hr, in ASTM #1 Oil	-55	%	
125°C, 168 hr, in IRM 903 Oil	-67	%	
Change in Shore Hardness			ISO 37
Shore A, 125°C, 168 hr, in ASTM #1 Oil	-14		
Shore A, 125°C, 168 hr, in IRM 903 Oil	-29		
Change in Volume			ASTM D471
125°C, 168 hr, in ASTM Oil #1	40	%	
125°C, 168 hr, in IRM 903 Oil	96	%	
Thermal	Nominal Value	Unit	
Service Temperature	-50 to 135	°C	
Fill Analysis	Nominal Value	Unit	Test Method
Melt Viscosity			ASTM D3835
250 sec ⁻¹	210	Pa · s	
1000 sec ⁻¹	66.0	Pa · s	
5000 sec ⁻¹	17.0	Pa · s	
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0 to 4.0	hr	
Rear Temperature	180 to 220	°C	
Middle Temperature	180 to 220	°C	
Front Temperature	180 to 220	°C	

Mold Temperature	15.0 to 50.0	°C
Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	200 to 220	°C
Cylinder Zone 2 Temp.	200 to 220	°C
Cylinder Zone 3 Temp.	200 to 220	°C
Cylinder Zone 4 Temp.	200 to 220	°C
Cylinder Zone 5 Temp.	200 to 220	°C

NOTE

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| 1. | Depending on shape of the detail and placement of gate |
| 2. | Method C, Crescent |
| 3. | Type B |

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