

apinat® A 65

Thermoplastic Elastomer

API SpA

Message:

apinat® A 65 is a thermoplastic elastomer (TPE) product. It can be processed by extrusion or injection molding and is available in Europe. Typical application areas are: engineering/industrial accessories.

Features include:
environmental protection/green
good weather resistance

General Information			
Features	Good weather resistance		
	Biodegradable		
Uses	overmolding		
Agency Ratings	EN 13432		
	EN 14046		
	ISO 14855		
Appearance	Natural color		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.18	g/cm ³	ASTM D792
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 15 sec)	65		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
--	10.0	MPa	ASTM D638
100% strain	2.00	MPa	ASTM D638
300% strain	3.50	MPa	ASTM D638
Tensile Elongation (Break)	800	%	ASTM D638
Abrasion Resistance	150	mm ³	DIN 53516
Ozone Resistance ¹ (40°C)	Good		
Elastomers	Nominal Value	Unit	Test Method
Tear Strength	40.0	kN/m	ASTM D624
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0	hr	
Suggested Max Moisture	0.10	%	

Rear Temperature	120 - 140	°C
Middle Temperature	130 - 150	°C
Front Temperature	140 - 160	°C
Nozzle Temperature	150 - 170	°C
Mold Temperature	25.0 - 35.0	°C
Injection Rate	Moderate-Fast	

Injection instructions

Injection Pressure: Medium Back Pressure: Low to Medium

Extrusion	Nominal Value	Unit
Drying Temperature	80.0	°C
Drying Time	2.0	hr
Suggested Max Moisture	0.10	%
Cylinder Zone 1 Temp.	110 - 130	°C
Cylinder Zone 2 Temp.	130 - 140	°C
Cylinder Zone 3 Temp.	135 - 145	°C
Cylinder Zone 4 Temp.	140 - 150	°C
Die Temperature	140 - 150	°C

Extrusion instructions

L/D Ratio: >20 Compression Ratio: 1:2.5

NOTE

1. 72 hr, 200 ppcm, Tension = 20%

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