

ENFLEX EA5360A

Thermoplastic Elastomer

ENPLAST Americas, a Ravago Group Company

Message:

60 Shore A TPE available in black and natural designed for injection molding and co-extrusion applications. This grade offers soft/tactile feel and adhesion (overmolding and co-extrusion) to Polycarbonate, ABS, Polyester, POM (specific impact modified POM grades) and Acrylics.

General Information			
Features	Low compressive deformability		
	High elasticity		
	Solvent resistance		
	Good UV resistance		
	Recyclable materials		
	Workability, good		
	Good coloring		
	Good adhesion		
	Ozone resistance		
	Alcohol resistance		
	Detergent resistance		
	Oil resistance		
	Soft		
Appearance	Black		
	Natural color		
Processing Method	Co-extrusion molding		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.03	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/5.0 kg)	5.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A, 10 seconds, extruded	60		ASTM D2240
Shore A, 10 seconds, injection molding	63		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (100% Strain)	1.86	MPa	ASTM D412
Tensile Strength (Break)	5.34	MPa	ASTM D412
Tensile Elongation (Break)	680	%	ASTM D412
Tear Strength	28.9	kN/m	ASTM D624

Compression Set			ASTM D395B
23°C, 22 hr	22	%	ASTM D395B
70°C, 22 hr	72	%	ASTM D395B
Thermal	Nominal Value	Unit	Test Method
Brittleness Temperature	-60.0	°C	ASTM D746
Dynamic Service Temperature	90	°C	
Injection	Nominal Value	Unit	
Drying Temperature	65.6 - 71.1	°C	
Drying Time	2.0 - 3.0	hr	
Rear Temperature	171 - 199	°C	
Middle Temperature	177 - 210	°C	
Front Temperature	191 - 221	°C	
Nozzle Temperature	199 - 229	°C	
Processing (Melt) Temp	199 - 221	°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	2.8 - 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	65.6 - 71.1	°C	
Drying Time	2.0 - 3.0	hr	
Hopper Temperature	160 - 177	°C	
Cylinder Zone 1 Temp.	171 - 191	°C	
Cylinder Zone 3 Temp.	179 - 199	°C	
Cylinder Zone 5 Temp.	191 - 210	°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)Cooling Water: 60 - 85°F (15-30°C)Screw Speed: 100 - 200 rpmScreen Pack: 20/40/60			

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