PRODUCT INFORMATION

TAROPRENE 1A65 M1N

Thermoplastic Elastomer Vulcanized. This TPE-V compound combines the typical performance of a vulcanized elastomer with the easy processing of a thermoplastic compound. Taroprene is totally recyclable and it can be produced in standard grades and in tailor-made grades. Available in natural (00), black (99) and colored grade (..).

ISO short	ISO 1043: TPV-(EPDM+PP)
Form	Pellets

Key Features

- Excellent ozone resistance
- Designed for injection moulding applications
- Good flowability
- High elastic performances
- Low compression set
- Excellent surface smoothness
- Good adhesion to polyolefinic substrate

Availability

- All colours

Process

- INJECTION MOULDING

Application

- Household
- General purpose applications
- Furniture
- Electrical
- Consumer
- Automotive

Property	Method	Unit	Value	Condition	State
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm^3	0,96		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	5,0	190°C - 5 kg	
MECHANICAL					
Hardness SHORE A	ASTM D2240	Shore A	65	3 sec	

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Tensile Break Strength	ASTM D412/C	MPa	6,0	
Elongation at Break	ASTM D412/C	%	500	
Tensile Modulus at 100% elongation	ASTM D412/C	MPa	2,2	
Tensile Modulus at 300% Elongation	ASTM D412/C	MPa	3,4	
Tear Strength	ASTM D624/C	N/mm	20	
Compression Set	ASTM D395/B	%	30	70°C - 22 h
Compression Set	ASTM D395/B	%	38	100°C - 22 h

INJECTION MOULDING	**Value**
Drying Temperature (Desiccant Dryer)	80°C
Drying Time (Desiccant Dryer)	3 hours
Suggested Max Moisture	0,08%
Suggested Max Regrind	20%
Melt Temperature	215 - 230°C
Feed Temperature	170°C
Rear Temperature	195°C
Middle Temperature	200°C
Front Temperature	205°C
Nozzle Temperature	200 - 220°C
Mould Temperature	10 - 50°C
Injection Rate	Fast
Back Pressure	0,3 - 0,7 Mpa
Screw Revolving Speed	100 - 200 rpm
Clamp Tonnage	70 - 70 Mpa
Cushion	3 - 7 mm
Screw L/D Ratio	16 - 20
Screw Compression Ratio	2:1 - 2,5:1
Vent Depth	0,025 mm

Notes TAROPRENE is incompatible with POM and PVC. We recommend that all TAROPRENE products are always dried prior to use at the specified drying conditions. The processing parameters like processing temperatures are a recommendation and can be adjusted in function of injection machine or extruder size, part geometry and design.