



PRODUCT INFORMATION

**TAROPRENE 1D40 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 Form** ISO 1043: TPV-(EPDM+PP)  
Pellets

**Key Features**

- Designed for injection moulding applications

**Availability**

- All colours

**Process**

- INJECTION MOULDING

**Application**

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

Property	Method	Unit	Value	Condition	State
<b>PHYSICAL</b>					
Density (+23°C)	ISO 1183	g/cm <sup>3</sup>	0,96		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	3,5	190°C - 5 kg	
<b>MECHANICAL</b>					
Hardness SHORE D	ASTM D2240	Shore D	40	3 sec	
Tensile Break Strength	ASTM D412/C	MPa	15,8		
Elongation at Break	ASTM D412/C	%	600		
Tensile Modulus at 100% elongation	ASTM D412/C	MPa	9,1		
Tensile Modulus at 300% Elongation	ASTM D412/C	MPa	10,2		
Tear Strength	ASTM D624/C	N/mm	68		
Compression Set	ASTM D395/B	%	50	70°C - 22h	
Compression Set	ASTM D395/B	%	62	100°C - 22h	



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<b>INJECTION MOULDING</b>	<b>Value</b>
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.