AUDIA ELASTOMERS
An AUDIA Company

TPE-60IN500 UV BLK

Injection Molding Grade Styrenic Based TPE

Features and Options:

- Custom colors available upon request
- Easy Processing
- High Flow
- Adhesion to PP or TPO substrates
- Available in lower specific gravity

Overview:
TPE-60IN500 is designed for automotive injection molding applications requiring exterior UV

Applications: Cowl Seals, Roof Rack Gaskets, Cut Line Seals, Fascia Extensions, Water Deflectors

Physical Properties	Typical Values*	Units	Test Method
Durometer Hardness – 15 second delay	60	Shore A	ASTM D 2240/ ISO 868 / ISO 7619
Tensile Strength – Perpendicular	8.0	MPa	ASTM D412/ ISO 37
Tensile Strength @ 100% – Perpendicular	1.6	Mpa	ASTM D412/ ISO 37
Elongation @ Break – Perpendicular	825	%	ASTM D412/ ISO 37
Tear Strength – Perpendicular	24	kN/m	ASTM D624/ ISO 34
Specific Gravity (Relative Density)	1.15		ASTM D792 / ISO 1183

*Values given are typical and should not be interpreted as product specification. All properties tested at 23°± 2°C (73.4 ± 3.6°F) and 50 ± 10% relative humidity unless otherwise noted. To obtain values for specific application purposes, contact your Audia Elastomers representative.

The results reported are typical and based on reliable testing procedures. However, due to variable processing methods and conditions, no guarantees or warranties are expressed or implied, including expressions of fitness for purpose or merchantability. No recommendations are made to infringe on patents

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Processing Guide for TPE – (Injection Molding)

Pre-drying	Not Necessary
Drying Time	N/A
Barrel Zone 1	180 - 190°C (360°F – 380°F)
Barrel Zone 2	190 - 200°C (380°F – 400°F)
Barrel Zone 3	190 - 200°C (380°F – 400°F)
Barrel Zone 4	200 - 220°C (400°F – 430°F)
Max Melt Temperature	250°C (480°F)
Mold Temperature	25 - 50°C (80°F – 120°F)
Injection Pressure	60-80% Max Pressure
Injection Speed	60-80% Max Speed
Hold Pressure	40-60% Max Pressure
Screw Speed (RPM)	40-80 RPM
Back Pressure	10-30% Max Pressure

Processing Notes:

Immediately before and after processing purge thoroughly with a fractional melt polyethylene (PE) or polypropylene (PP) or a purge compound optimized for polyolefins.

Regrind levels of up to 20% in injection molding can be used with minimal property loss, however final regrind level should be determined based on end product performance.

Material should not be left in the barrel for extended periods of time (>10 minutes) without purging the equipment.

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