



ENFLEX® EA3575A

ENPLAST Americas, a Ravago Group Company - Thermoplastic Elastomer

Tuesday, November 5, 2019

General Information

Product Description

75 Shore A TPE (Styrenic Block Copolymer based) for injection molding and extrusion applications. This grade offers soft/tactile feel and adhesion (overmolding) to Nylon.

General

Material Status	<ul style="list-style-type: none"> Commercial: Active 			
Availability	<ul style="list-style-type: none"> North America 			
Features	<ul style="list-style-type: none"> Acid Resistant Alcohol Resistant Base Resistant Detergent Resistant Good Adhesion Good Colorability Good Processability High Elasticity Oil Resistant Ozone Resistant Recyclable Material Soft Solvent Resistant UV Resistant 			
Processing Method	<ul style="list-style-type: none"> Extrusion Injection Molding 			

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.950		ASTM D792
Melt Mass-Flow Rate (230°C/2.16 kg)	6.5	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (100% Strain)	390	psi	ASTM D412
Tensile Strength (Break)	875	psi	ASTM D412
Tensile Elongation (Break)	400	%	ASTM D412
Tear Strength	200	lbf/in	ASTM D624
Compression Set			ASTM D395B
73°F, 22 hr	27	%	
158°F, 22 hr	48	%	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 10 sec, Extruded	71		
Shore A, 10 sec, Injection Molded	75		
Thermal	Nominal Value	Unit	Test Method
Brittleness Temperature	-61.6	°F	ASTM D746
Dynamic Service Temperature	194	°F	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	140 to 158	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	340 to 390	°F
Middle Temperature	445 to 465	°F
Front Temperature	465 to 480	°F
Nozzle Temperature	430 to 465	°F
Processing (Melt) Temp	445 to 480	°F
Mold Temperature	50 to 120	°F
Injection Pressure	750 to 1300	psi

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Injection	Nominal Value	Unit
Injection Rate	Fast	
Screw Speed	50 to 200	rpm
Clamp Tonnage	2.5 to 3.5	tons/in ²
Cushion	0.200 to 0.500	in

Injection Notes

Holding Time: 5 to 7 Sec.

Extrusion	Nominal Value	Unit
Drying Temperature	140 to 158	°F
Drying Time	2.0 to 3.0	hr
Hopper Temperature	320 to 355	°F
Cylinder Zone 1 Temp.	445 to 465	°F
Cylinder Zone 3 Temp.	465 to 480	°F
Cylinder Zone 5 Temp.	465 to 480	°F
Adapter Temperature	445 to 480	°F
Melt Temperature	445 to 480	°F
Die Temperature	445 to 480	°F
Screw L/D Ratio	24.0:1.0	

Extrusion Notes

Screw: L/D 20:1 or greater (L/D 24:1 preferred)

Cooling Water: 60 - 85°F (15-30°C)

Screw Speed: 100 - 200 rpm

Screen Pack: 20/40/60

Notes

¹ Typical properties: these are not to be construed as specifications.