



ENFLEX® S3040AE

ENPLAST Americas, a Ravago Group Company - Thermoplastic Elastomer

Tuesday, November 5, 2019

General Information

Product Description

40 Shore A TPE (Styrenic Block Copolymer based) for extrusion applications, offering soft/tactile feel, grippiness, and adhesion (Co-Extrusion) to Polypropylene.

General

Material Status	• Commercial: Active		
Availability	• North America		
Features	• Acid Resistant • Alcohol Resistant • Base Resistant • Detergent Resistant • Good Adhesion	• Good Colorability • Good Processability • High Elasticity • Low Compression Set • Oil Resistant	• Ozone Resistant • Recyclable Material • Soft • Solvent Resistant • UV Resistant
Processing Method	• Extrusion	• Injection Molding	
ASTM & ISO Properties¹			

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.910		ASTM D792
Melt Mass-Flow Rate (230°C/2.16 kg)	0.70	g/10 min	ASTM D1238
Elastomers			
Tensile Stress (100% Strain)	110	psi	ASTM D412
Tensile Strength (Break)	601	psi	ASTM D412
Tensile Elongation (Break)	800	%	ASTM D412
Tear Strength	115	lbf/in	ASTM D624
Compression Set			ASTM D395B
73°F, 22 hr	16	%	
158°F, 22 hr	55	%	
Hardness			
Durometer Hardness			ASTM D2240
Shore A, 10 sec, Extruded	36		
Shore A, 10 sec, Injection Molded	38		
Thermal			
Brittleness Temperature	-85.0	°F	ASTM D746
Dynamic Service Temperature	194	°F	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	150 to 160	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	340 to 390	°F
Middle Temperature	350 to 410	°F
Front Temperature	375 to 430	°F
Nozzle Temperature	390 to 445	°F
Processing (Melt) Temp	390 to 430	°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	2.0 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	150 to 160	°F
Drying Time	2.0 to 3.0	hr
Hopper Temperature	320 to 350	°F
Cylinder Zone 1 Temp.	340 to 375	°F
Cylinder Zone 3 Temp.	355 to 390	°F
Cylinder Zone 5 Temp.	375 to 410	°F
Adapter Temperature	375 to 410	°F
Melt Temperature	375 to 390	°F
Die Temperature	375 to 410	°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.