



EZPRENE® 9585A PA

ENPLAST Americas, a Ravago Group Company - Thermoplastic Vulcanizate

Wednesday, November 6, 2019

General Information

Product Description

85 Shore A TPE (Thermoplastic Vulcanizate) boundable to nylon. Available in black, natural for injection molding applications with long flow lengths or requires highly cosmetic surface. This soft, easy to color material is non-hygroscopic and offers excellent chemical resistance and physical properties. EZPrene 9500 series materials are polyolefin based and 100% recyclable. .

General

Material Status	• Commercial: Active		
Availability	• North America		
Features	• Chemical Resistant • Fatigue Resistant • Good Adhesion	• Good Colorability • Low to No Water Absorption • Ozone Resistant	• Recyclable Material • Soft • UV Resistant
Appearance	• Black	• Natural Color	
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.922		ASTM D792
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (100% Strain)	392	psi	ASTM D412
Tensile Strength (Break)	1230	psi	ASTM D412
Tensile Elongation (Break)	410	%	ASTM D412
Tear Strength	200	lbf/in	ASTM D624
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 5 sec, Extruded	85		
Shore A, 5 sec, Injection Molded	87		
Thermal	Nominal Value	Unit	Test Method
Brittleness Temperature	-58.0	°F	ASTM D746
Dynamic Service Temperature	266	°F	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	376 to 399	°F
Middle Temperature	385 to 410	°F
Front Temperature	385 to 410	°F
Nozzle Temperature	410 to 430	°F
Processing (Melt) Temp	392 to 428	°F
Mold Temperature	75 to 125	°F
Injection Pressure	750 to 1300	psi
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

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Injection Notes

Holding Time: 5 to 7 Sec.
Cooling Time: 30 to 50 Sec.

Extrusion	Nominal Value	Unit
Hopper Temperature	331 to 356	°F
Cylinder Zone 1 Temp.	338 to 374	°F
Cylinder Zone 2 Temp.	338 to 374	°F
Cylinder Zone 3 Temp.	338 to 374	°F
Cylinder Zone 4 Temp.	338 to 374	°F
Cylinder Zone 5 Temp.	338 to 374	°F
Adapter Temperature	374 to 410	°F
Melt Temperature	374 to 392	°F
Die Temperature	374 to 410	°F
Screw L/D Ratio	24.0:1.0	

Extrusion Notes

Metering Zone: 375 to 410 °F (190 to 210 °C)
Screw Speed: 30 to 80 rpm
Screen Pack: 20/40/60

Notes

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