

FARAPRENE C100-30A

PRIMEX COLOR, COMPOUNDING & ADDITIVES



Faraprene C100-30A is a light weight **water clear 30A TPE** for injection molding and overmolding onto PP/TPO applications. In addition to clear, this material can be made black, and pre-colored as needed.

MECHANICAL PROPERTIES

Mechanical

| | Value | Unit | Method |
|--------------------------------------|-------|--------|-----------|
| Tensile Stress, break ^{1,2} | 620 | PSI | ASTM D412 |
| 100% Tensile modulus ¹ | 75 | PSI | ASTM D412 |
| Elongation at break ^{1,2} | 1000 | % | ASTM D412 |
| Tear Strength ¹ | 100 | lbs/in | ASTM D624 |

1 tested in cross flow direction, 2 Samples did not break

Physical / Rheological

| | Value | Unit | Method |
|--------------------------------------|-------|----------|------------|
| Specific Gravity | 0.89 | - | ASTM D792 |
| Melt Flow Rate, 190°C, 2.16 kg. load | 12.5 | g/10 min | ASTM D1238 |
| Hardness, Shore A (10 second) | 30 | - | ASTM D2240 |

PROCESSING DATA

Processing Parameter

Injection Molding

| | Value | Unit |
|-----------------------------|---------|------|
| Melt Temperature | 350-420 | °F |
| Rear - Zone 1 Temperature | 335-360 | °F |
| Middle - Zone 2 Temperature | 340-390 | °F |
| Front - Zone 3 Temperature | 350-420 | °F |
| Nozzle Temperature | 350-420 | °F |
| Mold Temperature | 70-100 | °F |
| Backpressure | 15-50 | PSI |
| Screw Speed | 50-130 | RPM |
| Shot to Cylinder Size | 50-80 | % |

The process conditions listed are suggested starting points and some deviations may be needed depending on the process / part design.

THESE VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES

- (1) Typical values only. Variations within normal tolerances are possible.
- (2) Only typical data for selection purposes. Not to be used for part or tool design.
- (3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

Extrusion

| | Value | Unit |
|---------------------------|---------|------|
| Melt Temperature | 350-420 | °F |
| Rear Zone 1 Temperature | 235-360 | °F |
| Middle Zone 2 Temperature | 340-390 | °F |
| Front Zone 3 Temperature | 350-410 | °F |
| Adapter | 350-420 | °F |
| Head | 350-420 | °F |
| Die | 350-420 | °F |
| Screw Speed | 30-60 | RMP |



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