EZPrene 9065A

Product Description:
65 Shore A TPE (Thermoplastic Vulcanizate). Available in black, natural or pre-colored for injection molding and extrusion applications. This material is non-hygroscopic and offers excellent chemical resistance and physical properties. EZPrene is polyolefin based and is 100% recyclable.

Properties	Value	Unit	Standard
Physical			
Hardness - Injection Molded, 5 sec	67	Shore A	ASTM D2240
Hardness - Extruded, 5 sec	65	Shore A	ASTM D2240
Density	0.93	g/cm3	ASTM D792
Mechanical			
Tensile Strength at Break	725 (5.0)	psi (MPa)	ASTM D412
Elongation at Break	490	%	ASTM D412
100% Modulus	392 (2.7)	psi (MPa)	ASTM D412
Tear Strength	24.0	(kN/m)	ASTM D624
Compression Set			
22h / 23 ◦C	30	%	ASTM D395B
70h / 125 ◦C	53	%	ASTM D395B
Service Temperatures			
Brittleness Point	-60	°C	ASTM D746
Dynamic Service Temperature	130	°C	
Environmental			
Ozone Resistance	Excellent		ASTM D-1149

Features
Overmolded and Co-extrusion adhesion to Polypropylene
Excellent Adhesion to Polypropylene and SEBS
Easy to Color
Recyclability
Non Hygroscopic
Low Die Swell

Environmental Resistance
Ozone – excellent
UV – Excellent
Water – Excellent (Non Hygroscopic)

Plant Location:
616 111th St.
Arlington, TX 76011
Ph # (817) 635-4770

Headquarters:
1900 Summit Tower Blvd
Suite 900
Orlando, FL 32810
Ph # (407) 875-9595

www.ravago.com
www.enplastamericas.com

ISO 9001-2008

Processing Parameters

Drying Conditions

It is not necessary to pre-dry this material but in the event of moisture accumulation or evidence of splay, the material can be dried for 2-3 hours at 180°F (82°C).

Injection Molding Conditions

Temperatures:

Rear: 375 – 400°F (191 - 204°C)
Middle: 385 – 410°F (196 – 210°C)
Front: 385 – 410°F (196 – 210°C)
Nozzle: 410 – 430°F (210 – 221°C)
Melt Temperature 390 – 430°F (200– 220°C)
Mold Temperature: 75 – 125°F (24 – 52°C)

Injection Pressure: 750 – 1300psi
Injection Speed: Fast (0.5 – 2.0 Seconds)
Screw Speed: 50 – 200 rpm
Hold Times: 5-7 seconds
Cushion: 0.2 - 0.5 inch
Cooling Times: 30 – 50sec
Clamp Tonnage: 2.0 to 3.5 tons/in^2

Extrusion Conditions

Screw: L/D 24:1 minimum
Temperatures:

Feed Throat: 330-350°F (166 – 180°C)
Feed Zone: 340 – 375°F (170 – 190°C)
Compression Zone: 355 – 390°F (180 – 200°C)
Metering Zone: 375 – 410°F (190 – 210°C)
Die/Adapter: 375 – 410°F (190 – 210°C)
Melt Temperature: 375 – 390°F (190 – 200°C)

Screw Speed: 30 -80 rpm
Screen Pack: 20/40/60

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