

EZPrene 9585A PA

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.

Properties	Value	Unit	Standard
Physical			
Hardness - Injection Molded, 5 sec	87	Shore A	ASTM D2240
Hardness - Extruded, 5 sec	85	Shore A	ASTM D2240
Density	0.92	g/cm3	ASTM D792
Mechanical			
Tensile Strength at Break	1232 (8.5)	psi (MPa)	ASTM D412
Elongation at Break	410	%	ASTM D412
100% Modulus	391 (2.7)	psi (MPa)	ASTM D412
Tear Strength	35	(kN/m)	ASTM D624
Service Temperatures			
Brittleness Point	-50	°C	ASTM D746
Dynamic Service Temperature	130	°C	
Environmental			
Ozone Resistance	Excellent		ASTM D-1149

Features

Excellent Flex Fatigue
Good Adhesion to Nylon 6, 66
Recyclability

Environmental Resistance

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



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/in²

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

†The data listed here fall within the normal range of product properties, but they should not be used to establish specification limits or used alone as a basis for design. This information is not intended as a warranty of any kind. Buyers must make their own representative test and assume all risks of use, whether used alone or in combination with other products. Ravago Manufacturing Americas, LLC assumes no obligation or liability of any advice furnished by it or results obtained with respect to these products. All warranties expressed or implied including warranties of merchantability for a particular purpose or use are excluded and disclaimed. Ravago Manufacturing Americas, LLC assumes no liability for use of products in infringement of any patent. The foregoing limitation of remedy and exclusion of liability is reflected in and is part of the consideration for the price, at which the products are sold by Ravago Manufacturing Americas, LLC. All data displayed herein has been obtained via testing of injected molded specimens of natural color. Pigmentation may affect certain properties to various degrees.

*This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

‡ Shrinkage data are general guidelines and are only intended to allow comparison to other materials. They should not be used as the sole source of information for generating core and cavity mold dimensions.

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