

Technical Data Sheet

❖ **Alfater XL[®]****MOCOM****ALFATER XL A85I 4PA0010**

Base Polymer	Thermoplastic Vulcanisate (PP+EPDM)
Colour	black
Service Temperature	max. range (depending on load, geometry, etc.) -40-125 °C
Special Features	adhesion-modified to polyamide,easy flow,good weathering resistance,good chemical resistance,good ozone resistance,good hot air resistance,good hydrolysis resistant
Market Segment	Automotive,building and construction,do-it-yourself,electrical and electronic,Machinery,Furniture
Application Area	injection moulded parts
Typical Applications	seals,sealing lip,handles,soft touch elements,impact protection / shock absorber,functional components,casters,2K components
Adhesion to	Polyamide,Polyamide 6,Polyamide 66

Pre-Drying Conditions	in a dry air (dessiccant) dryer 70-80 °C for 2-4 h max. moisture content <0,10 %
Processing Injection Moulding	melt temperature 215-260 °C mould temperature <70 °C injection speed high back pressure (hydraulic) >3 bar holding pressure 50-70% of injection pressure
Storage	dry, protected from light not above 30°C tightly sealed

Properties	Value	Dimension	Test Norm
Mechanical Properties			
Tensile Stress at 100% Elongation (Type 2)	4.6	MPa	ISO 37
Tensile Strength (Type 2)	6.9	MPa	ISO 37
Tear Strength (Method Ba)	40	kN/m	ISO 34-1
Elongation at Break (Type 2)	400	%	ISO 37
Shore Hardness A (15s)	85	-	ISO 868
Thermal Properties			
Compression Set (22h / 100°C / 25% / Type A)	60	%	ISO 815
Compression Set (22h / 70°C / 25% / Type A)	50	%	ISO 815
Compression Set (72h / 22°C / 25% / Type A)	35	%	ISO 815
Compression Set (72h / 125°C / 25% / Type A)	72	%	ISO 815
Electrical Properties			
Tracking Resistance (CTI)	600	-	IEC 60112

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Rheological Properties

Shrinkage (lengthwise, 24h)	1.4 - 1.8	%	ISO 294-4
Shrinkage (lateral, 24h)	1.1 - 1.5	%	ISO 294-4
Spiral Flow (2 mm wall thickness)	60	cm	-

Physical Properties

Density	930	kg/m ³	ISO 1183
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Ageing Properties

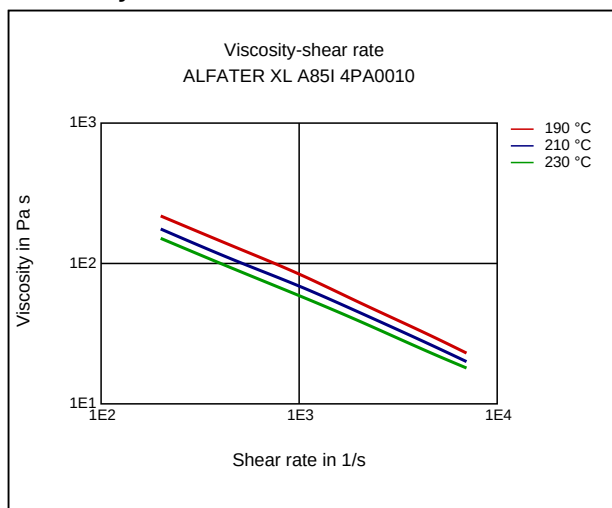
Ozone resistance (method A)	passed	-	ISO 1431-1A
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Flammability

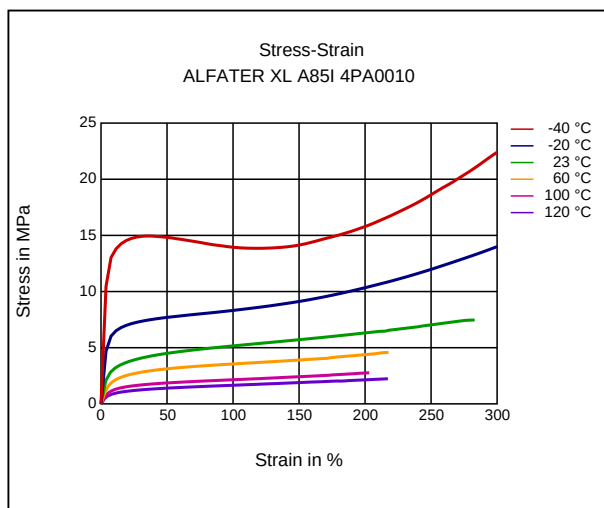
Flammability (1.5 mm)	HB	class	UL 94
Flammability (3.0 mm)	HB	class	UL 94
Glow Wire (GWFI, 650 °C, 2.0mm)	passed	-	DIN EN 60695

Diagrams

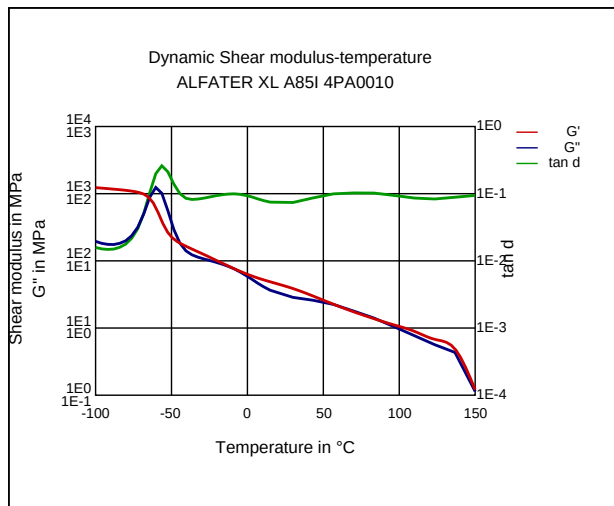
Viscosity-shear rate



Stress-Strain



Dynamic Shear modulus-temperature



Specific volume-temperature (pvT)

