



# 2865PE

Elastocon® 2865PE thermoplastic elastomer has been developed for applications that require rubber-like properties and a good surface finish. Elastocon® 2865PE is FDA compliant and well suited for consumer goods and industrial applications requiring U.V. stability. Elastocon® 2865PE can be overmolded and coextruded with polyethylene.

Elastocon® 2865PE is supplied as ready to use pellets in 50 lb. quantities.

Typical Physical Properties			
Property	Referenced ASTM Test Method	Test Unit	Typical Value
Hardness	ASTM D2240	Shore A	62
Specific Gravity	ASTM D792	g/cc	.89
Tensile Properties	ASTM D412		
Tensile Strength	ASTM D412	Mpa (psi)	7.7 (1118)
100% Modulus	ASTM D412	Mpa (psi)	2.4 (352)
Elongation	ASTM D412	%	588
Tear Strength	ASTM D624	pli	N/A

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For additional technical, sales, and order assistance:

Elastocon TPE Technologies  
PO Box 463  
Rochester, IL 62563 USA

Sales and Technical Assistance:

Office +1 217 498 8500  
Fax +1 888 231 8332  
orders@etpe.com  
sales@etpe.com  
techsupport@etpe.com  
www.etpe.com

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## **Processing**

Elastocon® thermoplastic elastomers are shear dependent and have been formulated to process on conventional thermoplastic equipment for injection molding, extrusion or blow molding.

For extrusion, a general purpose screw with a compression ratio of 2.5 to 3.0 is suggested. The feed zone temperature should be no higher than 175F. Increasing the zone temperatures along the extruder barrel from about 375F at the zone next to the feed zone, to about 450F at the die body. Typical injection molding conditions for a reciprocating screw machine are listed in the chart below. These values are intended only as guidelines, and optimum conditions will vary from machine, material being modified, and mold configuration.

<b>Suggested Processing Conditions</b>	
<b>Barrel Temperatures</b>	
Rear	330-350F
Front	360-370F
Nozzle	380-400F
<b>Mold Temperature</b>	70F-100F
<b>Back Pressure</b>	100-200 psi
<b>Injection Rate</b>	Fast

**Elastocon® 2865PE thermoplastic elastomer compound does not require drying.**

Elastocon® thermoplastic elastomers are not compatible with flexible PVC and should not be blended with or used in an application where direct contact is intended.

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