



# 8138B

Elastocon® 8138B is a black thermoplastic elastomer compound formulated for applications that require rubber-like properties and a good surface finish. Elastocon® 8138B is well suited for consumer goods and industrial applications requiring U.V. stability. Elastocon® 8138B can be overmolded to polypropylene.

Elastocon® 8138B 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	40
Specific Gravity	ASTM D792	g/cc	1.11
Tensile Properties	ASTM D412		
Tensile Strength	ASTM D412	Mpa (psi)	3.7 (543)
100% Modulus	ASTM D412	Mpa (psi)	1.07 (156)
Elongation	ASTM D412	%	478
Tear Strength	ASTM D624	pli	75

For additional technical, sales, and order assistance:

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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	290-320F
Front	320-360F
Nozzle	370-400F
<b>Mold Temperature</b>	70-100F
<b>Back Pressure</b>	50-100 psi
<b>Injection Rate</b>	Fast

**Elastocon® 8138B thermoplastic elastomer compound does not require drying.**

Elastocon® concentrates 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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