



# 8068N

Elastocon® 8068N is a colorable thermoplastic elastomer formulated for applications that require rubber-like properties and a good surface finish. Elastocon® 8068N is FDA compliant and well suited for consumer goods and industrial applications requiring U.V. stability. Elastocon® 8068N can be overmolded to polypropylene.

Elastocon® 8068N is supplied as ready to use pellets in 50 lb. bag and 1000 lb. box quantities.

Typical Physical Properties			
Property	Referenced ASTM Test Method	Test Unit	Typical Value
Hardness	ASTM D2240	Shore A	73
Specific Gravity	ASTM D792	g/cc	1.03
Tensile Properties	ASTM D412		
Tensile Strength	ASTM D412	Mpa (psi)	7.85 (1139)
100% Modulus	ASTM D412	Mpa (psi)	2.79 (405)
Elongation	ASTM D412	%	652
Tear Strength	ASTM D624	pli	157

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

## **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/79C. Increasing the zone temperatures along the extruder barrel from about 375F/191C at the zone next to the feed zone, to about 450F/232C 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>	<b>English</b>	<b>SI</b>
Rear	345-375F	174-191C
Front	355-385F	179-196C
Nozzle	365-400F	185-204C
<b>Mold Temperature</b>	70F-100F	21.1-37.8C
<b>Back Pressure</b>	50-100 psi	.345-.689 MPa
<b>Injection Rate</b>	Fast	Fast

**Elastocon® 8068N thermoplastic elastomer compound does not require drying.**

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

---

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

---

**DISCLAIMER OF WARRANTY AND LIABILITY:** Although the information and recommendations set forth herein ("Information") are believed to be correct. Elastocon, Inc., makes no representations or warranties, express or implied, as to the accuracy or completeness thereof, or of merchantability, fitness for a particular purpose, or of any other nature regarding information, or any product, process or equipment of Elastocon, Inc., or of any other manufacturer or supplier mentioned herein. Nothing contained herein is to be construed as a recommendation to use any product, process, equipment or formulation in conflict with any patent. Elastocon, Inc. makes no representation or warranty, express or implied, that the use thereof will not infringe any patent. Persons receiving information must make their own determination as to its suitability to their purposes prior to use. In no event will Elastocon, Inc. be responsible for damages of any nature whatsoever resulting from the use of or reliance upon Information or the products, processes or equipment to which the Information refers.