



8068B

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

Elastocon® 8068B is supplied as ready to use pellets in 50 lb. bags 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	1.04
Tensile Properties	ASTM D412		
Tensile Strength	ASTM D412	Mpa (psi)	7.85 (1139)
100% Modulus	ASTM D412	Mpa (psi)	2.8 (406)
Elongation	ASTM D412	%	662
Tear Strength	ASTM D624	pli	174

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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/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.

Suggested Processing Conditions		
Barrel Temperatures	English	SI
Rear	345-375F	174-191C
Front	355-385F	179-196C
Nozzle	365-400F	185-204C
Mold Temperature	70F-100F	21.1-37.8C
Back Pressure	50-100 psi	.345-.689 MPa
Injection Rate	Fast	Fast

Elastocon® 8068B 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.

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