



2825PE

Elastocon® 2825PE thermoplastic elastomer has been developed for applications that require rubber-like properties and a good surface finish. Elastocon® 2825PE is FDA compliant and well suited for consumer goods and industrial applications requiring U.V. stability. Elastocon® 2825PE can be overmolded and coextruded with polyethylene.

Elastocon® 2825PE 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	25
Specific Gravity	ASTM D792	g/cc	.88
Tensile Properties	ASTM D412		
Tensile Strength	ASTM D412	Mpa (psi)	2.4 (347)
100% Modulus	ASTM D412	Mpa (psi)	.74 (108)
Elongation	ASTM D412	%	543
Tear Strength	ASTM D642	pli	70

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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.

Suggested Processing Conditions		
Barrel Temperatures	English	SI
Rear	280-320F	138-160C
Front	330-360F	166-182C
Nozzle	360-400F	188-204C
Mold Temperature	60F-120F	15.6-48.9C
Back Pressure	50-100 psi	.345-.689 MPa
Injection Rate	Fast	Fast

Elastocon® 2825PE 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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