



# OF65

Elastocon® OF65 is a natural thermoplastic elastomer that has been developed for applications that require oil/plasticizer free, non-blooming high strength properties and a reduced coefficient of friction. Elastocon® OF65 is FDA compliant and well suited for consumer goods and industrial applications requiring U.V. stability. Elastocon® OF65 can be overmolded onto polypropylene.

Elastocon® OF65 is supplied as ready to use pellets in 50 lb. bag quantities.

Typical Physical Properties			
Property	Referenced ASTM Test Method	Test Unit	Typical Value
Hardness	ASTM D2240	Shore A	75
Specific Gravity	ASTM D792	g/cc	.93
Tensile Properties	ASTM D412		
Tensile Strength	ASTM D412	Mpa (psi)	12.7 (1850)
100% Modulus	ASTM D412	Mpa (psi)	4.4 (642)
Elongation	ASTM D412	%	564
Tear Strength	ASTM D642	pli	318

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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. We generally suggest increasing the zone temperatures along the extruder barrel from about 300F/149C at the zone next to the feed zone, to about 350F/177C 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® OF65 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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