



2860L

Elastocon® 2860L is a translucent lubricated thermoplastic elastomer that has been developed for applications that require rubber-like properties, a good surface finish, and a reduced coefficient of friction. Elastocon® 2860L is FDA compliant and well suited for consumer products and medical applications. Elastocon® 2860L can be overmolded onto polypropylene.

Elastocon® 2860L 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	60
Specific Gravity	ASTM D792	g/cc	.88
Tensile Properties	ASTM D412		
Tensile Strength	ASTM D412	Mpa (psi)	4.9 (713)
100% Modulus	ASTM D412	Mpa (psi)	2.3 (336)
Elongation	ASTM D412	%	610
Tear Strength	ASTM D624	pli	124
Compression Set	ASTM D395B	22 hrs/70°C	17

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. 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.

Suggested Processing Conditions		
Barrel Temperatures	English	SI
Rear	300-330F	149-166C
Front	330-360F	166-182C
Nozzle	370-420F	188-216C
Mold Temperature	70F-100F	21.1-37.8C
Back Pressure	100-200 psi	.689-1.38 MPa
Injection Rate	Fast	Fast

Elastocon® 2860L 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.

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.