



# 2855

Elastocon® 2855 thermoplastic elastomer has been developed for applications that require rubber-like properties and a good surface finish. Elastocon® 2855 is FDA compliant and well suited for consumer products and medical applications. Elastocon® 2855 can be overmolded onto polypropylene.

Elastocon® 2855 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	55
Specific Gravity	ASTM D792	g/cc	.89
Tensile Properties	ASTM D412		
Tensile Strength	ASTM D412	Mpa (psi)	4.7 (678)
100% Modulus	ASTM D412	Mpa (psi)	3.0 (436)
Elongation	ASTM D412	%	411
Tear Strength	ASTM D624	pli	122
Compression Set	ASTM D395B	22 hrs/70°C	25

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For additional technical, sales, and order assistance:

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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. 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>	<b>English</b>	<b>SI</b>
Rear	300-330F	149-166C
Front	330-360F	166-182C
Nozzle	370-420F	188-216C
<b>Mold Temperature</b>	70F-100F	21.1-37.8C
<b>Back Pressure</b>	100-200 psi	.689-1.38 MPa
<b>Injection Rate</b>	Fast	Fast

**Elastocon® 2855 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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