

# EnLast 28317



TPE

Product Description			
Easy processing TPE 93 Shore A with UV			
General Properties			
Appearance	Black, Natural, All Colors		
Processing Methods	Injection Molding and Extrusion		
Applications	Automotive, Appliance, General Industrial		
Mechanical Properties	Test Method	English Units	S.I. Units
Shore Hardness, 10 second delay	ASTM D2240	93 A	93 A
Specific Gravity	ASTM D792	0.89 sp gr	0.89 sp gr
Tensile Strength	ASTM D412A	1,400 psi	14,203 kPa
Tensile Elongation at Break	ASTM D412A	500 %	664 %
300% Modulus	ASTM D412A	1,100 psi	8,005 kPa
Tear Strength	ASTM D624	854 pli	181 kN/m
Thermal Properties	Test Method	English Units	S.I. Units
Viscosity at 210 °C, 10,994 sec-1	ASTM D3835	11,100 cPs	11.9 Pa·sec
Injection Molding	English Value	SI Value	
Suggested Maximum Moisture	0.05%	0.05%	
Rear Barrel Temperatures	350 - 380 °F	177 - 193 °C	
Middle Barrel Temperatures	360 - 390 °F	182 - 199 °C	
Front Barrel Temperatures	370 - 420 °F	188 - 216 °C	
Nozzle Temperature	370 - 430 °F	188 - 221 °C	
Melt (processing) Temperatures	380 - 420 °F	193 - 216 °C	
Injection Rate	Fast	Fast	
Back Pressure	25 - 180 psi	172 - 1,241 kPa	
Screw Speed	100 to 200 rpm	100 to 200 rpm	
Screw L/D Ratio	15:1 - 20:1	15:1 - 20:1	
Screw Compression Ratio	1.5:1 - 2.5:1	1.5:1 - 2.5:1	
Mold Temperature	60 80 °F	16 - 27 °C	
Clamp Tonnage	3 to 5 tons/in <sup>2</sup>	34 to 69 MPa	
Cushion	0.125 to 0.250 in	3.18 to 6.35 mm	
Vent Depth	0.0010 in	0.03 mm	

These Data Sheet Values are Typical Values and are not intended for specification purposes. These values should only be used as a guide and no assurances by EnCom, Inc. can be granted that all molded articles will exhibit duplicate properties as those listed above. Each material user should perform their own testing for suitability.