



PRODUCT INFORMATION

## TAROPRENE 1A85 B1N

Thermoplastic Elastomer Vulcanized. This TPE-V compound combines the typical performance of a vulcanized elastomer with the easy processing of a thermoplastic compound. Taroprene is totally recyclable and it can be produced in standard grades and in tailor-made grades.

**ISO short Form** ISO 18064: TPV-(EPDM+PP)  
Pellets

### Key Features

- Excellent ozone resistance
- Good oil and grease resistance
- Good ageing resistance
- Excellent flex-fatigue properties
- Designed for blow moulding applications
- Designed for automotive applications
- Good adhesion to polyolefinic substrate

### Availability

- All colours

### Process

- BLOW MOULDING

### Application

- Rack and pinion bellows
- Automotive air ducts
- Shock absorber
- Covering
- Tubing
- Automotive exterior
- Automotive

Property	Method	Unit	Value	Condition	State
<b>PHYSICAL</b>					
Density (+23°C)	ISO 1183	g/cm <sup>3</sup>	0,96		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	3,0	190°C - 5 kg	
<b>MECHANICAL</b>					
Hardness SHORE A	ASTM D2240	Shore A	85	3 sec	

The listed data are in the normal range of product properties, they should not be used to establish specification nor as the basis of design. Values are valid for natural coloured version only.

Unless specified to the contrary, the given values have been established on standardized test specimens at room temperature. These values are for natural colour only. The figures should be regarded as guide values only and not as binding minimum values. Please note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mold/die, the processing conditions, pigments and any other additives.

All information, recommendation or technical advice provided by TARO PLAST S.p.A. are given in good faith but without warranty, to the best of its knowledge and based on current procedures in effect. Our advice does not release you from the obligation to check its validity and to test our products as to their suitability for the intended processes and uses. The application, use and processing methods and conditions of our products and the products manufactured by you on the basis of our technical advice are beyond our control and, therefore, entirely under your own responsibility.

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Tensile Break Strength	ASTM D412/C	MPa	8,5
Elongation at Break	ASTM D412/C	%	650
Tensile Modulus at 100% elongation	ASTM D412/C	MPa	4,5
Tensile Modulus at 300% Elongation	ASTM D412/C	MPa	5,5
Tear Strength	ASTM D624/C	N/mm	45,0

**THERMAL**

Brittle point	ASTM D746	°C	-50
Continuous service temperature	UL746 B	°C	130

<b>BLOW MOULDING</b>	<b>Value</b>
Drying Temperature (Circulating Air Oven)	80 - 90°C
Drying Temperature (Desiccant Dryer)	80°C
Drying Time (Circulating Air Oven)	3 h
Drying Time (Desiccant Dryer)	2 - 3 h
Suggested Max Moisture	0,05
Suggested Max Re grind	10%
Melt Temperature	205 - 210°C
Feed Temperature	195°C
Rear Temperature	200°C
Middle Temperature	205°C
Front Temperature	210°C
Die Temperature	215°C
Blow Speed	Fast
Blow Pressure	0,3 - 0,7 Mpa
Blow Ratio	3,5
Die Swell	5 - 10 %
Screw Revolving Speed	50 - 150 rpm
Screw L/D Ratio	24:1 / 30:1
Screw Compression Ratio	min 2,5:1 - max 3,0:1

**Notes** TAROPRENE is incompatible with POM and PVC. All TAROPRENE compounds must be stored indoors at a temperature below 40°C avoiding humidity and direct sunlight as well. We recommend that all TAROPRENE products are always dried prior to use at the specified drying conditions. Despite a longer shelf storage life without loss of properties, we recommend to use the material within 6 months from the production date.

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