



PRODUCT INFORMATION

## TAROPRENE 1A60 M1M

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 1043: PP-EPDM Pellets

### Key Features

- Designed for injection moulding applications
- Good flowability
- Good adhesion to polyolefinic substrate

### Availability

- All colours

### Process

- INJECTION MOULDING

### Application

- General purpose applications
- Furniture
- Consumer
- Building
- Covering
- Tubing
- Automotive

| Property                           | Method      | Unit              | Value | Condition    | State |
|------------------------------------|-------------|-------------------|-------|--------------|-------|
| <b>PHYSICAL</b>                    |             |                   |       |              |       |
| Density (+23°C)                    | ISO 1183    | g/cm <sup>3</sup> | 0,97  |              |       |
| Melt Flow Rate (MFR)               | ISO 1133    | g/10 min          | 12    | 190°C - 5 kg |       |
| <b>MECHANICAL</b>                  |             |                   |       |              |       |
| Hardness SHORE A                   | ASTM D2240  | Shore A           | 60    | 3 sec        |       |
| Tensile Break Strength             | ASTM D412/C | MPa               | 4,2   |              |       |
| Elongation at Break                | ASTM D412/C | %                 | 485   |              |       |
| Tensile Modulus at 100% elongation | ASTM D412/C | MPa               | 1,83  |              |       |
| Tensile Modulus at 300% Elongation | ASTM D412/C | MPa               | 3,2   |              |       |

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.

Under the recommended processing conditions small quantities of decomposition product may be given off during processing. To preclude any risk to both the health and the well-being of the machine operatives, tolerance limits for the work environment must be ensured by the provision of efficient exhaust ventilation systems and fresh air at the workplace in accordance with the product Safety Data Sheet. In order to prevent the partial decomposition of the polymer and the generation of volatile decomposition products, the prescribed processing temperatures and conditions should not be substantially exceeded.

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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|                 |             |      |      |               |
|-----------------|-------------|------|------|---------------|
| Tear Strength   | ASTM D624/C | N/mm | 16,8 |               |
| Compression Set | ASTM D395/B | %    | 36   | 22 h - 70 °C  |
| Compression Set | ASTM D395/B | %    | 41   | 22 h - 100 °C |

| <b>INJECTION MOULDING</b>                 | <b>Value</b> |
|---|--------------|
| Drying Temperature (Circulating Air Oven) | 80°C         |
| Drying Time (Circulating Air Oven)        | 3h           |
| Melt Temperature                          | 180 - 220°C  |
| Rear Temperature                          | 160-180°C    |
| Middle Temperature                        | 180-220°C    |
| Front Temperature                         | 190-230°C    |
| Nozzle Temperature                        | 200-230°C    |
| Mould Temperature                         | 25 - 40°C    |
| Injection Rate                            | MEDIUM-HIGH  |

**Notes** All TAROPRENE compounds must be stored indoors at a temperature below 40°C avoiding humidity and direct sunlight as well.  
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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