



PRODUCT INFORMATION

**TAROPRENE 1A30 M1N**

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. Available in natural (00), black (99) and colored grade (..).

**ISO short Form** ISO 1043: TPV-(EPDM+PP)  
Pellets

**Key Features**

- Designed for injection moulding applications

**Availability**

- All colours

**Process**

- INJECTION MOULDING

**Application**

- Household
- General purpose applications
- Furniture
- Electrical
- Consumer
- 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	2,5	190°C - 5 kg	
<b>MECHANICAL</b>					
Hardness SHORE A	ASTM D2240	Shore A	30	3 sec	
Tensile Break Strength	ASTM D412/C	MPa	3,0		
Elongation at Break	ASTM D412/C	%	500		
Tensile Modulus at 100% elongation	ASTM D412/C	MPa	0,75		
Tensile Modulus at 300% Elongation	ASTM D412/C	MPa	1,6		
Tear Strength	ASTM D624/C	N/mm	12,8		
Compression Set	ASTM D395/B	%	24	70°C - 22h	

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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Compression Set                                      ASTM D395/B                                      %                                      29                                      100°C - 22h

<b>INJECTION MOULDING</b>	<b>Value</b>
Drying Temperature (Desiccant Dryer)	80°C
Drying Time (Desiccant Dryer)	3 hours
Suggested Max Moisture	0,08%
Suggested Max Re grind	20%
Melt Temperature	215 - 230°C
Feed Temperature	170°C
Rear Temperature	195°C
Middle Temperature	200°C
Front Temperature	205°C
Nozzle Temperature	200 - 220°C
Mould Temperature	10 - 50°C
Injection Rate	Fast
Back Pressure	0,3 - 0,7 Mpa
Screw Revolving Speed	100 - 200 rpm
Clamp Tonnage	70 - 70 Mpa
Cushion	3 - 7 mm
Screw L/D Ratio	16 - 20
Screw Compression Ratio	2:1 - 2,5:1
Vent Depth	0,025 mm

**Notes**      TAROPRENE is incompatible with POM and PVC. We recommend that all TAROPRENE products are always dried prior to use at the specified drying conditions.

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