

PRODUCT INFORMATION

TAROPRENE 1A90 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 ISO 1043: TPV-(EPDM+PP)

Form Pellets

Key Features

Designed for injection moulding applications

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- All colours

Process

INJECTION MOULDING

Application

- Household
- General purpose applications
- Furniture
- Electrical
- Consumer
- Automotive

Property	Method	Unit	Value	Condition	State
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm^3	0,96		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	3	190°C - 5 kg	
MECHANICAL					
Hardness SHORE A	ASTM D2240	Shore A	90	3 sec	
Tensile Break Strength	ASTM D412/C	MPa	12,8		
Elongation at Break	ASTM D412/C	%	580		
Tensile Modulus at 100% elongation	ASTM D412/C	MPa	6,7		
Tensile Modulus at 300% Elongation	ASTM D412/C	MPa	8,7		
Tear Strength	ASTM D624/C	N/mm	48		
Compression Set	ASTM D395/B	%	48	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.

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

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not be substantially exceeded.



100°C - 22h

PRODUCT INFORMATION

Compression Set

Nozzle Temperature

Mould Temperature
Injection Rate

Screw Revolving Speed

Screw Compression Ratio

Back Pressure

Clamp Tonnage

Screw L/D Ratio

Cushion

Vent Depth

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ASTM D395/B

INJECTION MOULDING	Value	
Drying Temperature (Desiccant Dryer)	80°C	
Drying Time (Desiccant Dryer)	3 hours	
Suggested Max Moisture	0,08%	
Suggested Max Regrind	20%	
Melt Temperature	215 - 230°C	
Feed Temperature	170°C	
Rear Temperature	195°C	
Middle Temperature	200°C	
Front Temperature	205°C	

%

58

200 - 220°C 10 - 50°C

Fast

0,3 - 0,7 Mpa

100 - 200 rpm

70 - 70 Mpa

3 - 7 mm

16 - 20

2:1 - 2,5:1

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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