

Faraprene 400-70A

70 Shore A translucent TPE for injection molding and extrusion applications requiring high elasticity and recovery, and good wear properties.

Preliminary Material Properties

Typical Properties			
MECHANICAL	Value	Unit	Method
Tensile Stress, break ¹	1400	Psi	ASTM D412
100% Modulus (stress at 100% strain) ¹	350	Psi	ASTM D412
Elongation at break ¹	990	%	ASTM D412
Tear Strength	169	Lb/in.	ASTM D642
¹ tested in the cross flow direction			
PHYSICAL/RHEOLOGICAL	Value	Unit	Method
Specific Gravity	0.89	-	ASTM D792
Melt Flow Rate, 230°C, 2.16 kgf	24	g/cm ³	ASTM D1238
Hardness, Shore A (5 sec. Delay)	70	A	ASTM D2240

Processing Data

Processing Parameter		
INJECTION MOLDING	Value	Unit
Melt Temperature	380-420	°F
Rear- Zone 1 Temperature	340-360	°F
Middle-Zone 2 Temperature	350-390	°F
Front- Zone 3 Temperature	390-420	°F
Nozzle Temperature	380-420	°F
Mold Temperature	80-100	°F
Backpressure	15-50	Psi
Screw Speed	50-80	Rpm
Shot to Cylinder Size	50-80	%
EXTRUSION	Value	Unit
Melt Temperature	370-420	°F
Rear Zone 1 Temperature	335-360	°F
Middle Zone 2 Temperature	350-390	°F
Front Zone 3 Temperature	380-410	°F
Adapter	380-420	°F
Head	380-420	°F
Die	380-420	°F