



Faraprene 401-50A

50 Shore A TPE for injection molding applications.

Preliminary Material Properties

Typical Properties			
MECHANICAL	Value	Unit	Method
Tensile Stress, break ¹	>800	Psi	ASTM D412
100% Modulus (stress at 100% strain) ¹	160	Psi	ASTM D412
Elongation at break ¹	>1000	%	ASTM D412
Tear Strength ¹	110	Lb/in.	ASTM D624
<small>¹ tested in the cross flow direction</small>			
PHYSICAL/RHEOLOGICAL	Value	Unit	Method
Specific Gravity	0.89	-	ASTM D792
Melt Flow Rate, 230°C, 2.16 kgf	5.0	g/cm ³	ASTM D1238
Hardness, Shore A (10 sec. Delay)	50	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	390-420	°F
Head	390-420	°F