



Faraprene 402-15A (9929875C)

15 Shore A TPE for injection molding and extrusion applications, with maximum heat resistance. This product is also FDA compliant.

Preliminary Material Properties

Typical Properties			
MECHANICAL	Value	Unit	Method
Tensile Stress, break	250	Psi	ASTM D412
100% Modulus (stress at 100% strain)	15	Psi	ASTM D412
Elongation at break	1840	%	ASTM D412
Toughness (Tensile stress X Elongation/100)	4600	Psi	ASTM D412
PHYSICAL/RHEOLOGICAL	Value	Unit	Method
Specific Gravity	0.89	-	ASTM D792
Melt Flow Rate, 230°C, 5.0 kgf	5.0	Dg/min	ASTM D1238
Hardness, Shore A (5 sec. Delay)	14	A	ASTM D2240
Linear Mold Shrinkage, inches/inch	0.018 – 0.020		ASTM D955

Processing Data

Processing Parameter		
INJECTION MOLDING	Value	Unit
Melt Temperature	375-420 (190-215)	°F (°C)
Rear- Zone 1 Temperature	340-360 (170-180)	°F (°C)
Middle-Zone 2 Temperature	370-390 (190-200)	°F (°C)
Front- Zone 3 Temperature	380-420 (195-215)	°F (°C)
Nozzle Temperature	380-410 (195-210)	°F (°C)
Mold Temperature	80-100 (25 – 40)	°F (°C)
Backpressure	15-50	Psi
Screw Speed	50-80	Rpm
Shot to Cylinder Size	50-80	%
EXTRUSION	Value	Unit
Melt Temperature	370-400 (190-205)	°F (°C)
Rear Zone 1 Temperature	330-350 (165-175)	°F (°C)
Middle Zone 2 Temperature	370-390 (190-200)	°F (°C)
Front Zone 3 Temperature	380-400 (195-205)	°F (°C)
Adapter	390-410 (200-210)	°F (°C)
Head	390-410 (200-210)	°F (°C)
Die	380-395 (195-205)	°F (°C)