reSound™ R VX0100-0001 AR I 80A Black

Thermoplastic Elastomer

Key Characteristics

Product Description	
reSound™ R VX0100-0001 AR I 80A Black is an 80A TPE compound made with post industrial recycled content that overmolds onto PC, ABS, PC/ABS.	
General	
Material Status	• Commercial: Active
Regional Availability	• North America
Recycled Content	• Post-Industrial (PIR)/Pre-Consumer, 30%
RoHS Compliance	• RoHS Compliant
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.05	1.05	ASTM D792
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Strength [2, 3] (Yield, 73°F (23°C))	1060 psi	7.33 MPa	ASTM D412
Tensile Elongation [2, 3] (Break, 73°F (23°C))	590 %	590 %	ASTM D412
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	79	79	ASTM D2240
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec^-1	21.2 Pa·s	21.2 Pa·s	

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	120 to 140 °F	49 to 60 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.020 to 0.030 %	0.020 to 0.030 %
Suggested Max Regrind	20 %	20 %
Rear Temperature	330 to 370 °F	166 to 188 °C
Middle Temperature	360 to 390 °F	182 to 199 °C
Front Temperature	370 to 430 °F	188 to 221 °C
Nozzle Temperature	370 to 430 °F	188 to 221 °C
Processing (Melt) Temp	370 to 430 °F	188 to 221 °C
Mold Temperature	60 to 120 °F	16 to 49 °C

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Injection Notes

Purge thoroughly before and after use of this product with a low flow (0.5 - 2.5 MFR) polyethylene (PE) or polypropylene (PP).

Regrind levels up to 20% can be used with reSound™ R VX0100-0001 AR I 80A Black with minimal property losses, provided that the regrind is free of contamination. To minimize losses during molding, the melt temperature should be as low as possible. The final determination of regrind effectiveness should be determined by the customer.

reSound™ R VX0100-0001 AR I 80A Black should not be left in the barrel for extended idle periods (greater than 5 minutes).

Suggested Dewpoint: -40°F

Notes

[1] Typical values are not to be construed as specifications.

[2] Die C

[3] 2 hr

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