FARAPRENE C101-60A

PRIMEX COLOR, COMPOUNDING & ADDITIVES

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A subsidiary of Primex Plastics Corporation

Faraprene C101-60A is a 60 Shore A Highly elastic, scratch resistant, TPE for injection and extrusion, can be made clear, pre-colored or black.

MECHANICAL PROPERTIES

Mechanical	Value	Unit	Method
Tensile Stress, break[1,2]	1350	PSI	ASTM D412
100% Modulus (stress at 100% strain)[1]	300	PSI	ASTM D412
Elongation at break[1,2]	1000	%	ASTM D412
Tear Strength[1]	175	lbs/in	ASTM D624

1 tested in cross flow direction, 2 Samples did not break

Physical / Rheological	Value	Unit	Method
Specific Gravity	0.89	-	ASTM D792
Melt Flow Rate, 230ºC, 2.16 kg. load	20	g/10 min	ASTM D1238
Hardness, Shore A (10 second)	60	-	ASTM D2240

PROCESSING DATA

Processing Parameter

Injection Molding	Value	Unit
Melt Temperature	340-420	ºF
Rear - Zone 1 Temperature	300-360	ºF
Middle - Zone 2 Temperature	320-390	ºF
Front - Zone 3 Temperature	330-420	ºF
Nozzle Temperature	330-420	ºF
Mold Temperature	70-100	ºF
Backpressure	15-50	PSI
Screw Speed	50-130	RPM
Shot to Cylinder Size	50-80	%

Extrusion	Value	Unit
Melt Temperature	340-420	ºF
Rear Zone 1 Temperature	280-360	ºF
Middle Zone 2 Temperature	320-390	ºF
Front Zone 3 Temperature	330-410	ºF
Adapter	330-420	ºF
Head	330-420	ºF
Die	330-420	ºF

The process conditions listed are suggested starting points and some deviations may be needed depending on the process / part design.

THESE VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES

(1) Typical values only. Variations within normal tolerances are possible.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

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