# MULTIFLEX™ A1004 Z4141

THERMOPLASTIC ELASTOMER ALLOY

## Rheological properties

| | | | |
|---|---|---|---|
| Melt volume-flow rate | 44 | cm³/10min | ISO 1133 |
| Temperature | 190 | °C | ISO 1133 |
| Load | 5 | kg | ISO 1133 |
| Moulding shrinkage, parallel | 1.0 | % | ISO 294-4, 2577 |
| Flow length | 290 | mm | |
| Flow length - pressure | 8 | MPa | |

## Typical mechanical properties

| | | | |
|---|---|---|---|
| Stress at 100% elongation | 2.4 | MPa | ISO 527-1/-2 or ISO 37 |
| Stress at 300% elongation | 4.8 | MPa | ISO 527-1/-2 or ISO 37 |
| Stress at break | 12.5 | MPa | ISO 527-1/-2 or ISO 37 |
| Elongation at break | >300 | % | ISO 527-1/-2 or ISO 37 |
| Shore A hardness, 15s | 65 | | ISO 48-4 / ISO 868 |
| Tear strength, parallel | 46 | kN/m | ISO 34-1 |

[1]: Cross direction

## Other properties

| | | | |
|---|---|---|---|
| Density | 1020 | kg/m³ | ISO 1183 |

## Injection

| | | |
|---|---|---|
| Drying Recommended | yes | |
| Drying Temperature | 95 | °C |
| Drying Time, Dehumidified Dryer | 4 - 6 | h |
| Melt Temperature Optimum | 190 | °C |
| Mold Temperature Optimum | 30 | °C |
| Min. mould temperature | 10 | °C |
| Max. mould temperature | 50 | °C |
| Hold pressure range | as low as possible | MPa |
| Back pressure | 1.5 | MPa |
| Injection speed | Medium-High | mm/s |

## Extrusion

| | | |
|---|---|---|
| Drying Temperature | 90 - 100 | °C |
| Drying Time, Dehumidified Dryer | 4 - 6 | h |
| Melt Temperature Optimum | 190 | °C |
| Melt Temperature Range | 180 - 200 | °C |

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## THERMOPLASTIC ELASTOMER ALLOY

### Characteristics

| | |
|---|---|
| Compatibility | Polycarbonate, Styrenics, Acrylic Polymers |



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