MULTIFLEX™ A1004 65A 520

THERMOPLASTIC ELASTOMER ALLOY

MULTIFLEX® A1004 65A 520 is part of MULTIFLEX® TEA range, Thermoplastic Elastomer Alloys, compatible with ABS / ASA / ABS-PC.

Rheological properties

Flow length	300	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 break	5.2	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, normal	31	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	20 to 40% of max injection pressure	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

Characteristics

Compatibility	Polycarbonate, Styrenics, Acrylic Polymers

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DuPont

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