MULTIFLEX™ TES 2604 MI1 NAT PL23502

STYRENIC THERMOPLASTIC ELASTOMER

Rheological properties

Melt volume-flow rate	8	cm³/10min	ISO 1133
Temperature	230	°C	ISO 1133
Load	5	kg	ISO 1133
Moulding shrinkage, parallel	1.7	%	ISO 294-4, 2577
Flow length	290	mm	

Typical mechanical properties

Stress at break	17	MPa	ISO 527-1/-2 or ISO 37
Elongation at break	>300	%	ISO 527-1/-2 or ISO 37
Flexural Modulus	255	MPa	ISO 178
Izod notched impact strength, -30°C	74	kJ/m²	ISO 180/1A
Shore D hardness, 15s	41		ISO 48-4 / ISO 868
Tear strength, parallel	90	kN/m	ISO 34-1

Other properties

Density	900	kg/m³	ISO 1183

Injection

Drying Recommended	no	
Melt Temperature Optimum	280	°C
Mold Temperature Optimum	40	°C
Min. mould temperature	30	°C
Max. mould temperature	50	°C
Hold pressure range	as low as possible	MPa
Back pressure	1	MPa
Injection speed	Medium-High	mm/s

Storage and stability

Shelf life	1800	days

Characteristics

Compatibility	Polyolefins

Additional information

Injection molding	Drying before moulding is normally not required, but may be needed if the product is stored in a high humidity environment. Lower temperature on the moving part of the mould is prefered.

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