

Sunprene® FA 65014-
High Quality Extrusion/Injection Elastomer
Automotive Exterior Seals
 GM: GMW 16048 Type 1 Class (formerly GMP PVC .059)


PRODUCT BULLETIN

Sunprene® FA 65014-

Flexible PVC elastomer extrusion/injection formulation used for profiles and parts requiring ease of processing, excellent weathering, abrasion resistance and a Class "A" surface appearance.
 Gloss: Nominal 5 – 10 gloss surface.

Property	Test Method	Value - English		Value - Metric (SI)	
Hardness, Shore A	ASTM D2240 15 sec. Delay	50		50	
Specific Gravity	ASTM D792	1.19		1.19	
Tensile Strength	ASTM D638 20 in/min (500 mm/min), Type IV	1439	psi	9.9	MPa
Elongation	ASTM D638 20 in/min (500 mm/min), Type IV	424	%	424	%
100% Modulus	ASTM D638 20 in/min (500 mm/min), Type IV	419	psi	2.89	MPa
Tear Strength	ASTM D1004 2 in/min (50 mm/min) Die C	120	ppi	21.0	kN/m
Compression Set	ASTM D395 22 hrs. @ 158°F (70°C)	50	%	50	%



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Process Parameters - Extrusion

Barrel Temperatures

Zone - Rear	300 ℉
Zone - Center	305 ℉
Zone - Center	315 ℉
Zone - Front	320 ℉
Adaptor	325 ℉
Dies	330 ℉

Melt Temperature 325 ℉

Screen Pack 20/40/20

Process Parameters – Injection Molding

Barrel Temperatures

Zone - Rear	335 ℉
Zone - Center	335 ℉
Zone - Front	345 ℉
Zone - Nozzle	340 ℉

Melt Temperature 340 ℉

Mold Temperatures

Stationary	70 - 90 ℉
Moveable	70 - 90 ℉

Injection Pressures

High	450 - 800 psi
Low	100 - 250 psi
Back	min. psi
Cushion	.25"

Injection Timers

Initial Speed	2 – 4 secs.
Hold	3 – 7 secs.
Cooling	15 – 30 secs.

Screw Speed 40 – 70 RPM



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