

RAVATECH RO-249-50A

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Product Description :	This polar thermoplastic elastomer compound is specifically designed for overmolding with different polar substrates and their blends. RAVATECH® series can be processed with conventional thermoplastics machineries and is fully recyclable.
Additive Packages :	T / Heat and UV stabilizer /
Key Features :	Adhesion to various polar substrates and their blends Rubberlike elasticity in a wide temperature range Easy colorability with proper MB Good chemical and oil resistance
Process Method :	Injection, multi-injection, co-injection molding
Uses :	Soft touch grips, handles, consumer goods, home&kitchen appliances, automotive

	Value	Unit	Standard
Physical			
Hardness	50	SHORE A	ISO 868 (3 second)
Density	1,10	gr / cm3	ISO 1183 1-A
Mechanical			
100% Modulus	1,3	Mpa	ISO 37(S1,500 mm/min)
300% Modulus	2,5	Mpa	ISO 37(S1,500 mm/min)
Tensile Strength At Break	4,5	Mpa	ISO 37(S1,500 mm/min)
Elongation at Break	530	%	ISO 37(S1,500 mm/min)
Tear Strength (Perpendicular to flow)	20	N/mm	ISO 34-1 Method B
Adhesion to ABS	4 (B/D)	N/mm	VDI 2019
Adhesion to PC	4,5 (B/D)	N/mm	VDI 2019

Drying Condition

Drying Time(hr)	2-3
Drying Temperature(°C)	60-80

Molding Condition (°C)

1st Zone (hopper)(°C)	190 - 200
2nd Zone(°C)	190 - 210



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3rd Zone(°C)	200 - 220
Nozzle(°C)	210 - 220
Melt Temperature(°C)	200 - 220
Mold Temperature(°C)	30-70
Max Allowable Melt Temperature(°C)	230

