

## RAVATECH RO24980A

### RAVATECH



|                              |                                                                                                                                                                                                                                                |
|------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Product Description :</b> | 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. |
| <b>Additive Packages :</b>   | T / Heat and UV stabilizer<br>/                                                                                                                                                                                                                |
| <b>Key Features :</b>        | Adhesion to various polar substrates and their blends<br>Rubberlike elasticity in a wide temperature range<br>Easy colorability with proper MB<br>Good chemical and oil resistance                                                             |
| <b>Process Method :</b>      | Injection, multi-injection, co-injection molding                                                                                                                                                                                               |
| <b>Uses :</b>                | Soft touch grips, handles, consumer goods, home&kitchen appliances, automotive                                                                                                                                                                 |

|                                       | Value   | Unit     | Standard              |
|---------------------------------------|---------|----------|-----------------------|
| <b>Physical</b>                       |         |          |                       |
| Hardness                              | 80      | SHORE A  | ISO 868 (3 second)    |
| Density                               | 1,10    | gr / cm3 | ISO 1183 1-A          |
| <b>Mechanical</b>                     |         |          |                       |
| 100% Modulus                          | 3,2     | Mpa      | ISO 37(S1,500 mm/min) |
| 300% Modulus                          | 5       | Mpa      | ISO 37(S1,500 mm/min) |
| Tensile Strength At Break             | 15      | Mpa      | ISO 37(S1,500 mm/min) |
| Elongation at Break                   | 740     | %        | ISO 37(S1,500 mm/min) |
| Tear Strength (Perpendicular to flow) | 54      | N/mm     | ISO 34-1 Method B     |
| Adhesion to ABS                       | 4 (B)   | N/mm     | VDI 2019              |
| Adhesion to PC                        | 6,8 (B) | 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       |

