Viprene™ P60A-22U-BLK

Alliance Polymers & Services - Thermoplastic Vulcanizate

General Information

Product Description

Viprene™ P60A-22U-BLK is a UV and Heat Stabilized TPV (thermoplastic vulcanizate elastomer). This material can be easily procesed by extrusion or injection molding. It exhibits easy flowing characteristics.

General

Additive	• Heat Stabilizer	• UV Stabilizer	
Features	• Good Flow	• Heat Stabilized	• UV Resistant
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	0.970	g/cm³	ISO 2781
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress (100% Strain)	319	psi	ISO 37
Tensile Stress (300% Strain)	522	psi	ISO 37
Tensile Stress (Break)	986	psi	ISO 37
Tensile Elongation (Break)	550	%	ISO 37
Tear Strength	217	lbf/in	ISO 34-1
Compression Set (158°F, 22 hr)	20	%	ASTM D395B
Hardness	**Nominal Value**	**Unit**	**Test Method**
Shore Hardness (Shore A)	60		ISO 868
Thermal	**Nominal Value**	**Unit**	**Test Method**
Brittleness Temperature	-76.0	°F	ASTM D746
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating			UL 94
0.04 in	HB		
0.06 in	HB		
0.12 in	HB		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	176	°F
Drying Time	3.0	hr
Rear Temperature	356	°F
Middle Temperature	365	°F
Front Temperature	365	°F
Nozzle Temperature	365 to 428	°F
Processing (Melt) Temp	374 to 446	°F
Mold Temperature	50 to 122	°F
Back Pressure	72.5 to 123	psi
Screw Speed	100 to 200	rpm
Clamp Tonnage	2.9 to 5.1	tons/in²

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Injection Notes
Injection Speed: 50 mm/sec or more

Extrusion	Nominal Value	Unit
Drying Temperature	176	°F
Drying Time	3.0	hr
Cylinder Zone 1 Temp.	356	°F
Cylinder Zone 2 Temp.	365	°F
Cylinder Zone 3 Temp.	365	°F
Die Temperature	383	°F

Extrusion Notes
Gate Temperature: 190°C (374°F)
Die Pressure: 4.8 to 17 MPa (696 to 2465 psi)