FARAPRENE C100-30A

PRIMEX COLOR, COMPOUNDING & ADDITIVES

PRIMEX
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A subsidiary of Primex Plastics Corporation

Faraprene C100-30A is a light weight **water clear 30A TPE** for injection molding and overmolding onto PP/TPO applications. In addition to clear, this material can be made black, and pre-colored as needed.

MECHANICAL PROPERTIES

Mechanical	Value	Unit	Method
Tensile Stress, break[1,2]	620	PSI	ASTM D412
100% Tensile modulus[1]	75	PSI	ASTM D412
Elongation at break[1,2]	1000	%	ASTM D412
Tear Strength[1]	100	lbs/in	ASTM D624

1 tested in cross flow direction, 2 Samples did not break

Physical / Rheological	Value	Unit	Method
Specific Gravity	0.89	-	ASTM D792
Melt Flow Rate, 190ºC, 2.16 kg. load	12.5	g/10 min	ASTM D1238
Hardness, Shore A (10 second)	30	-	ASTM D2240

PROCESSING DATA

Processing Parameter

Injection Molding	Value	Unit
Melt Temperature	350-420	ºF
Rear - Zone 1 Temperature	335-360	ºF
Middle - Zone 2 Temperature	340-390	ºF
Front - Zone 3 Temperature	350-420	ºF
Nozzle Temperature	350-420	ºF
Mold Temperature	70-100	ºF
Backpressure	15-50	PSI
Screw Speed	50-130	RPM
Shot to Cylinder Size	50-80	%

Extrusion	Value	Unit
Melt Temperature	350-420	ºF
Rear Zone 1 Temperature	235-360	ºF
Middle Zone 2 Temperature	340-390	ºF
Front Zone 3 Temperature	350-410	ºF
Adapter	350-420	ºF
Head	350-420	ºF
Die	350-420	ºF
Screw Speed	30-60	RMP

The process conditions listed are suggested starting points and some deviations may be needed depending on the process / part design.

THESE VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES

(1) Typical values only. Variations within normal tolerances are possible.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

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For further information, please contact: Anthony Montalvo at amontalvo@oneilcolor.com

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Garfield, NJ 800.282.7933 **Jasper, TN** 800.234.6159 primexcolor.com

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