

FARAPRENE C100-75A

PRIMEX COLOR, COMPOUNDING & ADDITIVES



Faraprene C100-75A is a light weight 75 Shore A clear TPE for injection molding and extrusion applications. This material has excellent physical properties, good scratch resistant, and high elasticity. In addition to clear compounds, this material can be made pre-colored or black providing a high or low gloss depending on the grain.

MECHANICAL PROPERTIES

Mechanical	Value	Unit	Method
Tensile Stress, break ^{1,2}	2250	PSI	ASTM D412
100% Modulus (stress at 100% strain) ¹	485	PSI	ASTM D412
Elongation at break ^{1,2}	1000	%	ASTM D412
Tear Strength ¹	275	lbs/in	ASTM D624

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

Physical / Rheological	Value	Unit	Method
Specific Gravity	0.90	-	ASTM D792
Melt Flow Rate, 230°C, 2.16 kg. load	20	g/10 min	ASTM D1238
Hardness, Shore A (10 second)	75	-	ASTM D2240

PROCESSING DATA

Processing Parameter

Injection Molding	Value	Unit
Melt Temperature	340-420	°F
Rear - Zone 1 Temperature	300-360	°F
Middle - Zone 2 Temperature	320-390	°F
Front - Zone 3 Temperature	330-420	°F
Nozzle Temperature	330-420	°F
Mold Temperature	70-100	°F
Backpressure	15-50	PSI
Screw Speed	50-130	RPM
Shot to Cylinder Size	50-80	%

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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Extrusion	Value	Unit
Melt Temperature	340-420	°F
Rear Zone 1 Temperature	280-360	°F
Middle Zone 2 Temperature	320-390	°F
Front Zone 3 Temperature	330-410	°F
Adapter	330-420	°F
Head	330-420	°F
Die	330-420	°F

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

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