

FARAPRENE C350-65A

PRIMEX COLOR, COMPOUNDING & ADDITIVES



Faraprene C350-65A is a low extractable high strength 65 Shore A TPE for injection molding and extrusion applications. This material has excellent physical properties, good scratch resistant, and high elasticity. This material can be made in natural, pre-colored, or black.

MECHANICAL PROPERTIES

Mechanical	Value	Unit	Method
Tensile Stress, break ^{1,2}	1450	PSI	ASTM D412
100% Modulus (stress at 100% strain) ¹	230	PSI	ASTM D412
Elongation at break ^{1,2}	1000	%	ASTM D412
Tear Strength ¹	160	lbs/in	ASTM D624

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

Physical / Rheological	Value	Unit	Method
Specific Gravity	1.02	-	ASTM D792
Melt Flow Rate, 230°C, 2.16 kg. load	25	g/10 min	ASTM D1238
Hardness, Shore A (10 second)	65	-	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

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