

## TECHNICAL DATA SHEET

### SPERENE KPS-6814003 Natural TPE Compound

Properties	Method (ASTM)	Unit	Nominal Value
Specific Gravity	D-792		1.10±0.02
Hardness (on sheet)	D-2240	Shore A	68±3
Tensile strength	D-412	Kg/cm <sup>2</sup>	>30
Elongation	D-412	%	>250
Tear strength	D-624	N/mm	>25

#### Processing Guide-Injection Molding

Sperene TPE Compounds can be processed on conventional reciprocating screw injection molding machines.

**Screw L/D ratio:** >20.

**Screw Compression ratio:** 2.5:1 to 3.5:1

**Injection Speed:** Medium-high

**Injection Pressure:** Medium

**Screw speed:** 25 to 75 rpm

**Back pressure:** Normally low back pressures are suggested. When using master batches higher back pressure is beneficial.

#### Temperature (°C)

Feeding Zone	Compression Zone	Metering Zone	Nozzle	Mold
160°C	170°C	175°C	180°C	15-40°C

This information has been provided as a general guide and we suggest that you carry out your own specific test to be sure that this material is suitable for your application.