

TPSiV® Material Range



TPSiV® Material Range _ #09marcom13.V4 (May 2011)

Multibase Group
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TPSiV® RANGE



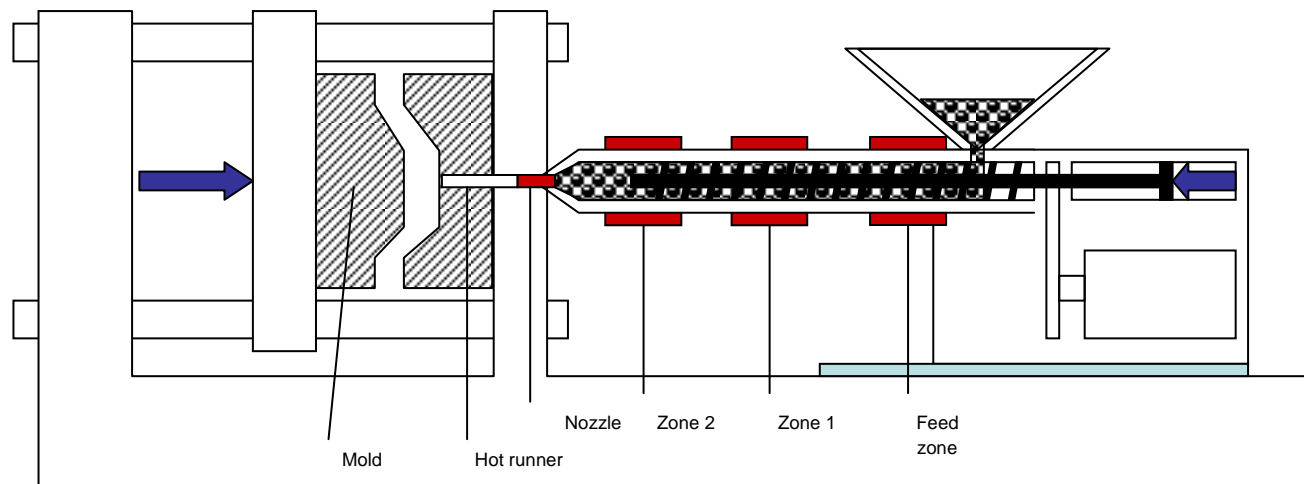
TPSiV® is a registered mark from Dow Corning Corporation

	Density	Hardness	UV Resistance	Elongation @ break (cross) %	Strength @ break (cross) MPa	Tear resistance (cross) kN/m	Compression set 23°C / 24H %	Process and maximum usage temperature	Key benefits
TPSiV® Serie 3100 - Ester TPU Series (Hydrolysis Resistance)									
TPSiV®3111-70A Natural	1.15	66 Sh. A	+	> 600	15	45	20	Injection / Extrusion maximum 110°C	- Bonds without adhesives to PC, ABS, ASA and alloy - Excellent hydrolysis resistance.
TPSiV®3040 Series - Ester TPU Series (Overmolding and sealing)									
TPSiV®3040-70A Natural	1.17	70 Sh. A	+	> 550	15	50	25	Injection / Extrusion maximum 120°C	- Excellent high temperature performance in air, - Excellent mechanical and physical property retention after weathering, - Excellent abrasion resistance, - Bonds without adhesives to PC, ABS, ASA, and alloy, - Good chemical resistance.
TPSiV® 33 and 34 Series – Aliphatic TPU Series (Overmolding, UV resistance)									
TPSiV®3451-60A Natural	1.09	60 Sh. A	++	> 550	5	30	45	Injection / Extrusion maximum 110°C	- Good UV resistance for all colors, - Good processability for molding of thin skin - Excellent abrasion resistance enabling the possibility to eliminate paint and varnish, - Bond without adhesive to PC, ABS, ASA and alloy, - Good chemical resistance to oils.
TPSiV®3345-65A BLK 25565	1.16	69 Sh. A	++	> 550	7	45	35		
TPSiV®3451-80A Natural	1.17	82 Sh. A	++	> 350	8.5	45	NA		
TPSiV® 5300 – Polyolefin Serie									
TPSiV® 5300 A6002 WHT 25848	0.93	60 Sh. A	-	> 800	6	39	NA	Injection / Extrusion maximum 80°C	- Silky feel, - Low odor ,
TPSiV® 5300 A8503 IVRY 25516	0.98	91 Sh. A	+	15	18	45	NA	Injection / Extrusion maximum 100°C	- plasticizer free, - Bond to PP and PE

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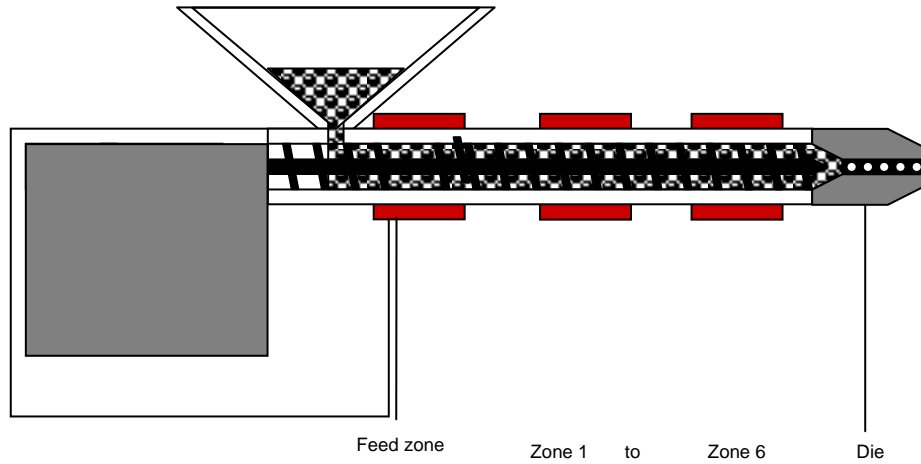
TPSiV® Range Guidelines for Injection



Indications	Units	TPSiV®	TPSiV®
		Hardness from 60 to 70 Sh.A	Hardness from 80 to 90 Sh.A
Feed zone	°C	180 +/- 10	200 +/- 10
Zone 1	°C	190 +/- 10	210 +/- 10
Zone 2	°C	200 +/- 10	220 +/- 10
Nozzle	°C	205 +/- 10	220 +/- 10
Mold temperature	°C	5°C to 60°C Best results at 25-30°C	5°C to 60°C Best results at 25-30°C
Hot Runner	°C	190°C – 210°C	190°C-210°C
Drying	°C	2 to 6h at 80°C to 100°C	2 to 6h at 80°C to 100°C



TPSiV® Range Guidelines for Extrusion



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Shore Hardness	Feed zone	Zone 1	Zone 2	Zone 3	Zone 4	Zone 5	Zone 6	Die
TPSiV® from 55 to 85 Sh.A	170°C ±10°C	170°C ±10°C	185°C ±10°C	190°C ±10°C	185°C ±10°C	185°C ±10°C	185°C ±10°C	190°C ±10°C

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