



# Multiflex<sup>®</sup> TES A6008 SVZ1 NAT Thermoplastic Elastomer

## FEATURES & BENEFITS

- Low compression set at 70°C
- Standards approvals: CSTB
- UV stabilized
- Natural color
- Compatibility: PP/PE

## APPLICATIONS

- Multiflex<sup>®</sup> TES A6008 SVZ1 NAT is designed for use in injection molding/extrusion

## TYPICAL PROPERTIES

Specification Writers: These values are not intended for use in preparing specifications. Please contact your local Dow Corning sales office or your Global Dow Corning Connection before writing specifications on this product.

Test*	Property	Unit	Result
ISO 868	Hardness	Sh.A	60
ISO 1183/A	Density	g/cm <sup>3</sup>	1.17
MDA 179	Spiral flow condition A	cm	73
ISO 37 Type 1 v = 500 mm/min	Tensile strength at 100% elongation cross direction	MPa	1.5
ISO 37 Type 1 v = 500 mm/min	Tensile strength at break cross direction	MPa	6.5
ISO 37 Type 1 v = 500 mm/min	Elongation at break cross direction	%	790
ISO 34	Tear strength cross direction	kN/m	25
MDA 129	Compression set 24h/23°C without annealing	%	21
MDA 129	Compression set 24h/70°C without annealing	%	41
MDA 129	Compression set 24h/100°C without annealing	%	64

\*ISO: International Standardization Organization  
MDA (Méthode d'Analyse): Issued from ISO Standards

## GUIDELINES FOR INJECTION MOLDING

**Drying:** Multiflex<sup>®</sup> TES A6008 SVZ1 NAT is not moisture sensitive, therefore drying is not needed. However, if this material is stored in high humidity conditions, it is recommended to dry for two hours at maximum 80°C.

Barrel temperature °C	Feed Zone	150 +/- 10
	Transition	170 +/- 10
	Front	190 +/- 10
	Nozzle	200 +/- 10
Melt temperature °C		200 +/- 10
Back Pressure Bars		10 +/- 5
Injection Speed		70 +/- 10% max
Holding Pressure		30 +/- 10% of Max Injection Pressure
Mold Temperature °C		40 +/- 20
Hot runner °C		180 +/- 10

## GUIDELINES FOR EXTRUSION

Drying	Not needed	
Temperature °C	Feed Zone	150 +/- 10
	Zone 1	170 +/- 10
	Zone 2	180 +/- 10
	Adaptator/Die	190 +/- 10
Melt temperature °C	190 +/- 10	

### PROCESSING GUIDE

*Multiflex*<sup>®</sup> brand TES SV series are styrenics thermoplastic elastomers, designed for medium/high compression set applications. Compatibility with polyolefin enables bi-material parts (continuous process or cold insert).

Please find below some indications to follow to transform the product. This does not replace molder experience, every mold having its own specificity, but this document is useful for initial parameter choice.

#### Background

*Multiflex*<sup>®</sup> TES SV series can be transformed between 190°C to 220–230°C. In this temperature range, materials are stable, above, thermal degradation occurs, resulting in yellowing and significant odor emanation.

#### Pre-drying

As *Multiflex*<sup>®</sup> TES SV are not humidity sensitive, Pre-drying is not needed. In case of “incident”, pre-drying at 80–90°C during 1 to 2 hours is sufficient.

#### Machinery cleaning

High flow thermoplastic must be used, PEHD, PELD or PP.

#### Coloring

*Multiflex*<sup>®</sup> TES SV are easily colorable by using color masterbatch based on PP, PE or ethylene copolymers (EVA).

#### Recycling

*Multiflex*<sup>®</sup> TES SV are 100% recyclable without properties loss. We recommend a maximum level of 10%

of recycling material in virgin material.

### INJECTION

On a general point of view, viscosity of SEBS based material is principally dependent of applied shear, so *Multiflex*<sup>®</sup> TES SV must be injected with high injection speed. Due to their high fluidity, easy mold feeding for single or multiple cavities geometries are possible.

#### Processing parameters

Screw:

Geometry: standard injection machine, L/D > 20, compression rate 2:1 to 3:1 (if higher, risk of thermal degradation). Screw speed between 100 to 150 rpm ensures thorough melting of the material without excessive temperature generation. Start with 120 rpm.

#### Back pressure

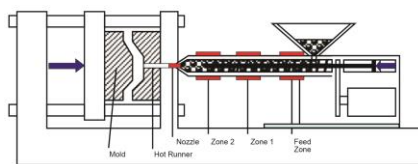
Must be between 7 and 15 bars. This will ensure a uniform melt without severe shear heating.

#### Temperatures (°C)

See Figure 1.

- Feed Zone: 150 +/- 10
- Zone 1: 170 +/- 10
- Zone 2: 190 +/- 10
- Nozzle: 200 +/- 10

**Figure 1:**



#### Injection speed

Injection speed and fill time are highly dependent on part geometry,

complexity and gate design. Faster speeds typically result in easier mold filling while lower speeds result in better surface in better surface appearance. High injection speed, around 70% of maximum injection speed should be used initially.

#### Holding pressure

Start with a pressure equivalent to 30% of maximum injection pressure. Excessive holding pressure can result in distortion in the area of the gate due to elastomeric characteristics of the material.

#### Holding time

Three seconds can be used to start to ensure sufficient time for gate freeze off. Holding time can be slowly reduced until changes in part appearance or weight occur.

#### Mold

Use conventional mold design (venting, finish, draft) with temperatures from 10 to 60°C, but typically chosen in the range of 40°C gives good results.

#### Hot Runners

Apply a temperature of 180°C +/- 10.

### EXTRUSION

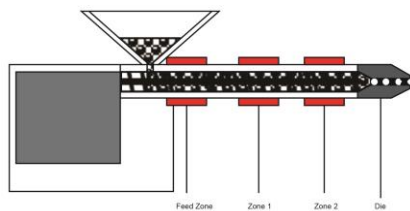
*Multiflex*<sup>®</sup> TES SV series can be processed on all extrusion machines for PVC, polyolefin. A screw, with a compression ratio of 3 is recommended.

#### Temperatures (°C)

See Figure 2.

- Feed Zone: 150 +/- 10
- Zone 1: 170 +/- 10
- Zone 2: 180 +/- 10
- Die: 190 +/- 10

**Figure 2:**



**HANDLING  
PRECAUTIONS  
PRODUCT SAFETY  
INFORMATION REQUIRED FOR  
SAFE USE IS NOT INCLUDED IN  
THIS DOCUMENT. BEFORE  
HANDLING, READ PRODUCT  
AND SAFETY DATA SHEETS  
AND CONTAINER LABELS FOR  
SAFE USE, PHYSICAL AND  
HEALTH HAZARD  
INFORMATION. THE SAFETY  
DATA SHEET IS AVAILABLE ON  
THE DOW CORNING WEBSITE  
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SALES APPLICATION  
ENGINEER, OR DISTRIBUTOR,  
OR BY CALLING  
DOW CORNING CUSTOMER  
SERVICE.**

### **USABLE LIFE AND STORAGE**

Refer to product label for storage temperature conditions. Containers should be kept tightly closed and kept in cold storage at all times to extend shelf life. Shelf life is indicated by the "Use Before" date found on the product label.

### **PACKAGING INFORMATION**

This product is available in a variety of container sizes. Contact your local Dow Corning sales representative for information about container sizes available in your area.

### **LIMITATIONS**

This product is neither tested nor represented as suitable for medical or pharmaceutical uses.

### **HEALTH AND ENVIRONMENTAL INFORMATION**

To support customers in their product safety needs, Dow Corning has an extensive Product Stewardship organization and a team of Product Safety and Regulatory Compliance (PS&RC) specialists available in each area.

For further information, please see our website, [dowcorning.com](http://dowcorning.com) or consult your local Dow Corning representative.

### **LIMITED WARRANTY INFORMATION – PLEASE READ CAREFULLY**

The information contained herein is offered in good faith and is believed to be accurate. However, because conditions and methods of use of our products are beyond our control, this information should not be used in substitution for customer's tests to ensure that our products are safe, effective, and fully satisfactory for the intended end use. Suggestions of use shall not be taken as inducements to infringe any patent.

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