

Product Information

Automotive and Transportation



DOW CORNING

Multiflex[®] TES A6511 EV1 FXT PL23509 Thermoplastic Elastomer

FEATURES & BENEFITS

- Aesthetics
- Very high flow
- UV stabilized
- Black
- Compatibility: PP

APPLICATIONS

- Multiflex[®] TES A6511 EV1 FXT PL23509 is designed for use in injection molding

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	65
ISO R1183	Density		0.98
MDA 179	Spiral flow condition C	cm	> 85
MDA 179	Spiral flow condition D	cm	57
ISO 37 Type 1 v = 500 mm/min	Tensile strength at 100% elongation cross direction	MPa	1.8
ISO 37 Type 1 v = 500 mm/min	Tensile strength at break cross direction	MPa	5.6
ISO 37 Type 1 v = 500 mm/min	Elongation at break cross direction	%	730
ISO 34	Tear strength cross direction	kN/m	27
ISO 815	Compression set 24h/23°C	%	27

*ISO: International Standardization Organization

MDA (Méthode d'Analyse): Issued from ISO Standards

GUIDELINES FOR INJECTION MOLDING

Drying: Multiflex[®] TES A6511 EV1 FXT PL23509 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

INJECTION MOLDING GUIDE

Multiflex[®] brand Automotive EV Range is designed for injected application: easy mold feeding, for single or multiple cavities geometries are possible due to high fluidity.

Compatibility with polyolefin enables bi-injected, overmolded (continuous process or cold insert) parts molding. Please find below some indications to follow for injection process. This does not replace molder experience, every mold having its own specificity, but this document is useful for initial parameter choice.

Multiflex[®] Automotive EV Range can be injected between their melting temperatures 170°C to 230–240°C. In this temperature range, materials are stable, above, thermal degradation occurs, resulting in yellowing and significant odor emanation.

On a general point of view, viscosity of SEBS based material is principally dependent of applied shear, so *Multiflex*[®] Automotive EV must be injected with high injection speed.

Multiflex[®] Automotive EV Range has been designed to enlarge process window, and can be injected at medium speed.

Pre-drying

As *Multiflex*[®] Automotive EV Range is not humidity sensitive, Pre-drying is not needed. In case of “incident”, pre-drying is not necessary.

Machinery Cleaning

High flow thermoplastic must be used, PEhd, PEId or PP.

Coloring

Multiflex[®] Automotive EV Range is easily colorable by using color masterbatch based on PP, PE or ethylene copolymers (EVA).

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

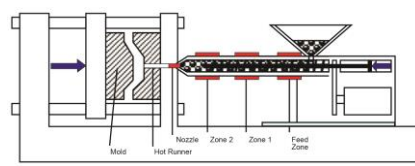
Must be between 7 and 15 bars: This will ensure a uniform melt without severe shear heating

Temperatures (°C)

See Figure 1.

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

Figure 1: Injection molding processing temperatures



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. Start with an injection speed around 70% of maximum speed.

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

3 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) Temperature: from 10 to 60°C, but typically chosen in the range 25-30°C gives good results.

Hot Runners

Apply a temperature of 190°C +/- 10.

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 AT DOWCORNING.COM, OR FROM YOUR DOW CORNING 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 or consult your local Dow Corning representative.

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