Product Information
Automotive and Transportation

**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.

<table>
<thead>
<tr>
<th>Test*</th>
<th>Property</th>
<th>Unit</th>
<th>Result</th>
</tr>
</thead>
<tbody>
<tr>
<td>ISO 868</td>
<td>Hardness</td>
<td>Sh.A</td>
<td>65</td>
</tr>
<tr>
<td>ISO R1183</td>
<td>Density</td>
<td></td>
<td>0.98</td>
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<tr>
<td>MDA 179</td>
<td>Spiral flow condition C</td>
<td>cm</td>
<td>&gt; 85</td>
</tr>
<tr>
<td>MDA 179</td>
<td>Spiral flow condition D</td>
<td>cm</td>
<td>57</td>
</tr>
<tr>
<td>ISO 37 Type 1</td>
<td>Tensile strength at 100% elongation cross direction</td>
<td>MPa</td>
<td>1.8</td>
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<tr>
<td>ISO 37 Type 1</td>
<td>Tensile strength at break cross direction</td>
<td>MPa</td>
<td>5.6</td>
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<tr>
<td>ISO 37 Type 1</td>
<td>Elongation at break cross direction</td>
<td>%</td>
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<td>ISO 34</td>
<td>Tear strength cross direction</td>
<td>kN/m</td>
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<td>ISO 815</td>
<td>Compression set 24h/23°C</td>
<td>%</td>
<td>27</td>
</tr>
</tbody>
</table>

*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.

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Specifications</th>
</tr>
</thead>
<tbody>
<tr>
<td>Barrel temperature °C</td>
<td>Feed Zone 150 +/- 10</td>
</tr>
<tr>
<td></td>
<td>Transition 170 +/- 10</td>
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<tr>
<td></td>
<td>Front 190 +/- 10</td>
</tr>
<tr>
<td></td>
<td>Nozzle 200 +/- 10</td>
</tr>
<tr>
<td>Melt Temperature °C</td>
<td>200 +/- 10</td>
</tr>
<tr>
<td>Back Pressure Bars</td>
<td>10 +/- 5</td>
</tr>
<tr>
<td>Injection Speed</td>
<td>70 +/- 10% max</td>
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<tr>
<td>Holding Pressure</td>
<td>30 +/- 10% of max injection pressure</td>
</tr>
<tr>
<td>Mold Temperature °C</td>
<td>40 +/- 20</td>
</tr>
<tr>
<td>Hot Runner °C</td>
<td>180 +/- 10</td>
</tr>
</tbody>
</table>
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, PEld 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 Engineers.
(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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