

FORPRENE® 665901A60 NERO - TPV
Description

Forprene 665901A60 Nero (Black) is a high melt flow injection molding thermoplastic vulcanizate (TPV) that is stabilized for heat aging and UV/weathering resistance in automotive exterior components, including glass encapsulation seals, wiper spoilers, body plugs, etc.

Physical properties	Value	Unit	Test Standard
Density	57.7	lb/ft ³	ISO 1183
Mechanical properties (TPE)	Value	Unit	Test Standard
Tensile stress at 100%, perpendicular	305	psi	ISO 37
Compression set, 70 °C, 22h, Type A	39	%	ISO 815
Tensile strain at break, perpendicular	480	%	ISO 37
Tensile stress at break, perpendicular	783	psi	ISO 37
Shore A hardness-TPE, 3s	64	-	ISO 868
Shore A hardness-TPE, 15s	62	-	ISO 868
Tear strength, Method Ba, perpendicular	189	lb/in	ISO 34-1

Typical injection moulding processing conditions

Pre Drying	Value	Unit
Necessary low maximum residual moisture content	0.08	%
Drying time	3	h
Drying temperature	176	°F
Temperature	Value	Unit
Feeding zone temperature	338 - 356	°F
Zone1 temperature	347 - 365	°F
Zone2 temperature	365 - 383	°F
Zone3 temperature	374 - 392	°F
Nozzle temperature	383 - 401	°F
Melt temperature	392 - 428	°F
Mold temperature	68 - 104	°F

Other text information
Pre-drying

3h@80C

Longer pre-drying times/storage

Forprene must be stored indoors in the original, unopened and undamaged packaging, away from direct sunlight, moisture and heat.

Characteristics

Special Characteristics	High flow, UV resistant
Processing	Injection molding
Delivery Form	Pellets