禾祥禎有限公司
Ho Hsiang Ching Co.,LTD.

ISO 9001,14001 Certified

HA 700B-1 TPE (Thermoplastic Elastomer) Material - Black color

- Conforming to EU REACH-SVHC,PAHs,RoHS and US California Proposition specifications.
- Pleasing appearance and feel, easy to add color, good stability.
- Good insulation and weather resistant.
- Good two color combinations and be adhesion to ABS, PC
- High tensile strength resistance and low compression deformed.
- Non-toxic,non-polluting in production processes, eco-friendly material.
- Application: Stationery,Hand tools,Consumables,Toys

ASE POLYTECH Co.,LTD

Properties

Item	Test Method	Value	Unit
Hardness	ASTM D2240	70+/-2	Shore A
Specific Gravity	ASTM D792	1.06	g/cm^3
Tesnsile Elongation	ASTM 412C	459.2	%
Tensile Strength	ASTM 412C	43.3	Kg/cm^2
Tear Strength	ASTM 624C	41.2	Kg/cm
Melt Flow Index	ASTM D1238	8.3 E	g/10min
	B: 125℃/2.16kg C:150℃/2.16kg E: 190℃/2.16kg G: 200℃/5kg		

Processing Information

Injection	Nominal Value	Unit
Shrinkage rate	0.8-1	%
Drying Temperature	60	℃
Drying Time	2.0~4.0	hr
Rear Temperature	170~187	℃
Middle Temperature	176~192	℃
Front Temperature	187~201	℃
Processing (Melt) Temp	185~210	℃
Mold Temperature	16~66	℃
Injection Pressure	34~69	Mpa
Back Pressure	0.34~0.69	Mpa
Screw Speed	50~70	rpm
Injection Speed	13~25	mm/sec

Injection Notes:

The values quoted here are typical of the grade,however,it is important to recognize that some variation around these values is to be expected as a result of uncertainties associated with measurement of the specific property and due to the normal variations encountered during the manufacturing process.

Moisture can degrade the material.Drying is suggested.This can be accomplished by placing the material in a desiccant dryer for 2 to 4 hours at 60℃

Purging

HHC TPE has excellent melt stability. Empty the barrel for idle periods of 30 minutes or longer.Purge thoroughly before and after use of this product with polyethylene or polypropylene.

Coloring

The use of polyolefin based colour concentrates is recommended. Apply back pressure in injection moulding to disperse color.

Recycling/Regring

This product can be reprocessed. Physical properties are generally not degraded. Dry regrind prior to reprocessing.

Bonding/Assembly

Thermal bonding techniques can be used to form high strength bonds. Adhesive bonding can be achieved with specialized adhesives. Adhesive bond strength is limited due to the polypropylene base of this material.

Storage & Handling

HHC TPE is available in 25 kg polyethylene bags (up to 1000 kg per pallet). It has a storage life at normal temperatures of several years. Please refer to the Material Safety Data Sheet for this grade prior to first time handling.

Ho Hsiang Ching Co.,LTD.
No.116-1, Qingguang Rd., Wuri Dist., Taichung City 414,Taiwan (R.O.C.)
TEL:+886-4-2335-8891 E-mail:hhc.tpe.sales@hhc-tpe.com