



### HA 9165W TPE (Thermoplastic Elastomer) Material - Natural 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 and PC.
- High tensile strength resistance and low compression deformed.
- Non-toxic,non-polluting in production processes, eco-friendly material.
- Application: Stationery,Hand tools,Consumables,Medical equipment,3C products.

ASE POLYTECH Co.,LTD

#### Properties

| Item                          | Test Method | Value                          | Unit               |
|-------------------------------|-------------|--------------------------------|--------------------|
| Hardness                      | ASTM D2240  | 60 ±2                          | Shore A            |
| Specific Gravity              | ASTM D792   | 1.1                            | g/cm <sup>3</sup>  |
| Tensile Elongation            | ASTM 412C   | 541.8                          | %                  |
| Tensile Strength              | ASTM 412C   | 69                             | Kg/cm <sup>2</sup> |
| Tear Strength                 | ASTM 624C   | 55.8                           | Kg/cm              |
| Heat Deflection Temperature   | ASTM D648   | 110                            | °C                 |
| Brittle Temperature           | ASTM D476   | -50                            | °C                 |
| Compression Set (22 hrs/23°C) | ASTM D395   | 31                             | %                  |
| Melt Flow Index               | ASTM D1238  | 9.6 E                          | g/10min            |
|                               |             | B: 125°C/2.16kg C:150°C/2.16kg |                    |
|                               |             | E: 190°C/2.16kg G: 200°C/5kg   |                    |

#### Processing Information

| Injection              | Nominal Value | Unit   |
|------------------------|---------------|--------|
| Shrinkage rate         | 0.8-1         | %      |
| Drying Temperature     | 80            | °C     |
| Drying Time            | 2.0~4.0       | hr     |
| Rear Temperature       | 180~195       | °C     |
| Middle Temperature     | 180~195       | °C     |
| Front Temperature      | 190~205       | °C     |
| Processing (Melt) Temp | 190~210       | °C     |
| Mold Temperature       | 16~66         | °C     |
| 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 80°C

### **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/Regrinding**

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](mailto:hhc.tpe.sales@hhc-tpe.com)