

## Technical Data Sheet

### SIPOLPRENE® 35195 W

#### DESCRIPTION

SIPOLPRENE® 35195 W is an ether ester thermoplastic elastomer (TPC-ET), developed and manufactured by Sipol, with a nominal hardness of Shore D 36, a very low modulus, and a rheological behaviour, which makes it suitable for injection molding and extrusion processing. SIPOLPRENE® 35195 W comes in a dry blend UV stabilised version.

#### THERMAL PROPERTIES

PROPERTY	TEST METHOD	M.U.	TYPICAL VALUE
Melting temperature	ISO 11357-3	°C	195
Crystallization temperature	ISO 11357-3	°C	131
Glass transition temperature	ISO 11357-2	°C	-45
Vicat A /50	ISO 306	°C	137

#### RHEOLOGICAL PROPERTIES

PROPERTY	TEST METHOD	M.U.	VALUE
MFI 230 °C, 2.16 Kg	ISO 1133	g/10 min	28
MVR 230 °C, 2.16 Kg	ISO 1133	cm <sup>3</sup> /10min	25

#### MECHANICAL PROPERTIES

PROPERTY	TEST METHOD	M.U.	TYPICAL VALUE
Shore D hardness, instantaneous / 15 s	ISO 868	Shore D	36/33
Stress at break	ISO 527	MPa	21
Elongation at break	ISO 527	%	700
Flexural modulus	ISO 178	MPa	50
Izod impact resistance/notched (23°C)	ISO 180	J/m	No break
Izod impact resistance/notched (-40°C)	ISO 180	J/m	No break
Abrasion resistance (Vertical load 5N)	ISO 4649	mm <sup>3</sup>	27
Compression set (23°C)	ISO 815:1991	%	22
Compression set (70°C)	ISO 815:1991	%	63

#### OTHER PROPERTIES

PROPERTY	TEST METHOD	M.U.	TYPICAL VALUE
Density	ISO 1183	g/cm <sup>3</sup>	1,11
Water absorption (23°C x 24 h immersion)	MI 08	%	0.7

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#### PROCESSING CONDITIONS

Suggested temperature profile for injection molding

MELTING TEMPERATURE	MOLD TEMPERATURE	NOZZLE	FRONT ZONE 3	CENTER ZONE 2	REAR ZONE 1
°C	°C	°C	°C	°C	°C
195	20 - 30	220	210	200	175-190

Suggested temperature profile for extrusion

MELTING TEMPERATURE	MFI	FEEDING ZONE	COMPRESSION ZONE	METERING ZONE	HEAD/DIE
°C	g/10 min.	°C	°C	°C	°C
195	28 (230 °C, 2.16 Kg)	185 - 200	195 - 205	205 - 220	205 - 220

#### DRYING CONDITIONS

Drying recommended = Yes  
Drying temperature = 90 °C  
Drying time, dehumidifier dryer = 2-3 h  
Processing moisture content = 0,15%

#### PACKAGING

25 kg bags equipped with an aluminum film barrier against moisture action.  
500 kg cardboard octabins equipped with an inner PE liner.  
500 Kg and 1000 Kg big bags.

#### STORAGE

Product is stable for 12 months when stored unopened in its original packaging, kept in a cool and dry place and protected from light. When stocked around 5 – 10°C or below, it is recommended to keep it at 15 – 20°C for at least for 24 hours before using it.