



TECHNICAL DATA SHEET

Actymer G GA-1065A-US BLK

(Thermo Plastic Vulcanizate)

General Characteristics

Description : GA-1065A-US BLK is a Thermoplastic Vulcanized compound.**Feature :** Low compression set and ease of processing.**Process :** Injectino Molding, Coextrusion, Multi Injection Molding**Applications :** Automotive, Industrial, Seals and Gaskets, General purpose**Available Color(s) :** Black only.

Technical Information

PHYSICAL	Typical Value ¹	Unit
Form	Pellet	
Specific Gravity (± 0.03)	0.96	ISO 1183
Hardness (Shore 'A', ± 5 , 10 sec)	64	ISO 868
Hardness (Shore 'A', ± 5 , 15 sec)	62	
MECHANICAL		
Tensile Strength	6.1 MPa	ISO 37
100% Modulus	3.3 MPa	
Ultimate Elongation	380 %	
Compression set		
after 22 hours at 70 °C (158°F)	25 %	ISO 815
after 22 hours at 120 °C (248°F)	36 %	
after 70 hours at 125 °C (257°F)	53 %	

PROCESSING**Injection**

	Typical Value (English)	Typical Value (SI)
Drying Teemperature	180 °F	80 °C
Drying Time	3.0 hr	3.0 hr
Suggested Max Moisture	0.05 %	0.05 %
Suggested Max Regrind	20 %	20 %
Rear Temperature	320 to 392 °F	160 to 200 °C
Middle Temperature	374 to 446 °F	190 to 230 °C
Front Temperature	374 to 446 °F	190 to 230 °C
Nozzle Temperature	392 to 446 °F	200 to 230 °C
Processing(Melt) Temp	374 to 446 °F	190 to 230 °C
Mold Temperature	86 to 122 °F	30 to 50 °C
Injection Rate	Fast	Fast
Back Pressure	50 to 100 psi	0.3 to 0.7 MPa
Screw Speed	100 to 200 rpm	100 to 200 rpm

Extrusion

Drying Temperature	180 °F	80 °C
Drying Time	3.0 hr	3.0 hr
Melt Temperature	374 to 446 °F	190 to 230 °C
Die Temperature	374 to 446 °F	190 to 230 °C

Thermal

Brittleness	Less than -60 °C (-76°F)	ISO 974
-------------	--------------------------	---------

Aging

Chang in Tensile Strength in Air 150°C (302°F), 168hr	8 %	ISO 188
Chang in Ultimate elongation in Air 150°C (302°F), 168hr	6 %	
Chang in Durometer Hardness in Air 150°C (302°F), 168hr	-1	
Volume Swell (120°C, (248°F) 24 hr, in IRM 903 Oil)	61 %	ISO 1817

REGULATORY

N/A

Additional Information

Where applicable, test results based on film gated, 2.0mm injection molded plaques. Tensile strength, elongation and tensile stress are measured across the flow direction. Compression set at 25% deflection.

Notes

¹ Typical Values: These are not construed as specifications; values may vary depending on colors.



IMPORTANT: These suggestions and data are based on information we believe to be reliable. They are offered in good faith without guarantee or warranty, as conditions and methods of use of our products are beyond our control. We strongly urge that the prospective user determine the suitability of our materials and suggestions before adopting them on a commercial scale. User assumes all risks and liabilities in connection with use of this product.