



TECHNICAL DATA SHEET

Actymer G GA-1055A-US BLK

(Thermo Plastic Vulcanizate)

General Characteristics

Description : GA-1055A-US BLK is a Thermoplastic Vulcanized compound.**Feature :** Low compression set and ease of processing.**Process :** Injection Molding, Coextrusion, Multi Injection Molding**Applications :** Automotive, Industrial, Seals and Gaskets, General purpose**Available Color(s) :** BLACK

Technical Information

PHYSICAL	Typical Value ¹	Unit	
Form		Pellet	
Specific Gravity (± 0.03)	0.95		ISO 1183
Hardness (Shore 'A', ± 5 , 15 sec)	53		ISO 868
MECHANICAL			
Tensile Strength	4.5 MPa		ISO 37
100% Modulus	2.3 MPa		
Ultimate Elongation	290 %		
Compression set			
after 22 hours at 70 °C (158°F)	36 %		ISO 815
MELT FLOW			
MFR 230°C (446°F) 10 kg	73 g/10 min		ISO 1133
Thermal			
Brittleness	Less than -60 °C (-76°F)		ISO 974

PROCESSING

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	180 ° F	80 °C
Drying Time	3.0 hr	3.0 hr
Suggested Max Moisture	0.05 %	0.05 %
Suggested Max Re grind	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

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.



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