



TECHNICAL DATA SHEET

Actymer G GA-1090A-US BLK

(Thermo Plastic Vulcanizate)

General Characteristics

Description : GA-1090A-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 only.

Technical Information

PHYSICAL	Typical Value ¹	Unit	
Form		Pellet	
Specific Gravity (± 0.03)	0.96		ISO 1183
Hardness (Shore 'A', ± 5 , 15 sec)	87		ISO 868
MECHANICAL			
Tensile Strength	13.1 MPa		ISO 37
100% Modulus	5.2 MPa		
Ultimate Elongation	400 %		
Compression set			
after 22 hours at 70 °C (158°F)	49 %		ISO 815
after 22 hours at 120 °C (248°F)	64 %		
after 70 hours at 125 °C (257°F)	75 %		
Thermal			
Brittleness	Less than -60 °C (-76°F)		ISO 974
Aging			
Chang in Tensile Strength in Air 150°C (302°F), 168hr	-3 %		ISO 188
Chang in Ultimate elongation in Air 150°C (302°F), 168hr	-11 %		
Chang in Durometer Hardness in Air 150°C (302°F), 168hr	1.0		
Volume Swell (120°C, (248°F) 24 hr, in IRM 903 Oil)	61 %		ISO 1817
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 Teemperature	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. Tehnsile 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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