



TECHNICAL DATA SHEET

Multiuse Leostomer LJ-3190N-US

(Olefin-based Thermoplastic Elastomer)

General Characteristics

Description : LJ-3190N-US is a Thermoplastic Elastomer compound.**Feature :** Ease of Injection processing.**Application :** General purpose Injection.**Available Color(s) :** Black and Natural

Technical Information

PHYSICAL	Typical Value ¹	Unit	
Form		Pellet	
Specific Gravity (± 0.03)	0.95		ISO 1183
Hardness (Shore 'A', ± 5 , 15 sec)	90		ISO 868
MECHANICAL			
Tensile Strength	20.0 MPa		ISO 37
100% Modulus	4.8 MPa		ISO 37
Ultimate Elongation	920 %		ISO 37
Tear Strength	67 N/mm		ISO 34-1
Elasticity			
Compression set after 22 hours at 70 °C (158°F)	50 %		ISO 815
Thermal			
Brittleness	Less than -60 °C (-76°F)		ISO 974
Aging			
Retention in Tensile Stress (50°C (122°F), 24 hr, in IRM 902 Oil)	89 %		ISO 1817
Volume Swell(50°C, (122°F) 24 hr, in IRM 902 Oil)	9 %		ISO 1817
MELT FLOW			
MFR 230°C (446°F) 2,160g	2.5 g/10 min		ISO 1133

PROCESSING

Injection

	Typical Value (English)	Typical Value (SI)
Suggested Max Moisture	0.05 %	0.05 %
Suggested Max Regrind	20 %	20 %
Rear Temperature	320 to 392 °F	160 to 200 °C
Middle Temperature	356 to 446 °F	180 to 230 °C
Front Temperature	374 to 446 °F	190 to 230 °C
Nozzle Temperature	374 to 446 °F	190 to 230 °C
Processing(Melt) Temp	374 to 446 °F	190 to 230 °C
Mold Temperature	68 to 104 °F	20 to 40 °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

Feed zone Temperature	320 to 356 °F	160 to 180 °C
Compression zone Temperature	338 to 374 °F	170 to 190 °C
Metering zone Temperature	356 to 410 °F	180 to 210 °C
Die Temperature	356 to 428 °F	180 to 220 °C
Melt Temperature	356 to 428 °F	180 to 220 °C
Screen mesh	Recommend 40 or more	

REGULATORY

N/A



¹ Typical Values: These are not construed as specifications.

² Type 1A tensile bars. Speed of testing: 500mm/min

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