



# ENSOFT SD-150-45D

## Ravago Manufacturing Turkey - Thermoplastic Elastomer

### General Information

#### General

Material Status	• Commercial: Active	
Availability	• Europe	• North America
Features	• Ozone Resistant	• UV Resistant
Processing Method	• Extrusion	• Injection Molding

### Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density	1.13	g/cm <sup>3</sup>	ISO 1183
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (100% Strain)	8.00	MPa	ISO 37
Tensile Stress (300% Strain)	9.00	MPa	ISO 37
Tensile Stress (Break)	15.0	MPa	ISO 37
Tensile Elongation (Break)	550	%	ISO 37
Compression Set			ASTM D395B
23°C, 22 hr	46	%	
70°C, 22 hr	61	%	
Hardness	Nominal Value	Unit	Test Method
Shore Hardness (Shore D)	45		ISO 868

#### Additional Information

The value listed as Density, ISO 1183, was tested in accordance with ISO 2781.  
 Tear Strength, ISO 34-2: 103 kN/m  
 Abrasion Resistance, DIN 53516: 93 mm<sup>3</sup>  
 Ozone Resistance, ISO 1431: No Crack

### Processing Information

Injection	Nominal Value	Unit
Rear Temperature	150 to 160	°C
Front Temperature	170 to 180	°C
Nozzle Temperature	185 to 190	°C
Processing (Melt) Temp	190 to 200	°C
Mold Temperature	10 to 50	°C
Screw L/D Ratio	20.0:1.0	
Screw Compression Ratio	2.5:1.0	
Extrusion	Nominal Value	Unit
Drying Temperature	90	°C
Drying Time	1.0	hr
Cylinder Zone 1 Temp.	190	°C
Cylinder Zone 2 Temp.	195	°C
Cylinder Zone 3 Temp.	205	°C
Cylinder Zone 4 Temp.	210	°C
Cylinder Zone 5 Temp.	220	°C

## ENSOFIT SD-150-45D

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#### Extrusion Notes

Machine Capacity, 30 mm cylinder diameter: 15 to 20 kg/hr

Machine Capacity, 45 mm cylinder diameter: 60 to 85 kg/hr

Machine Capacity, 60 mm cylinder diameter: 100 to 150 kg/hr

Machine Capacity, 90 mm cylinder diameter: 225 to 300 kg/hr

#### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.