



**RAVATECH RO-249-50A**

**RAVATECH**

**Product Description :** This polar thermoplastic elastomer compound is specifically designed for overmolding with different polar substrates and their blends. RAVATECH® series can be processed with conventional thermoplastics machineries and is fully recyclable.

**Additive Packages :** T / Heat and UV stabilizer  
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**Key Features :** Adhesion to various polar substrates and their blends  
Rubberlike elasticity in a wide temperature range  
Easy colorability with proper MB  
Good chemical and oil resistance

**Process Method :** Injection, multi-injection, co-injection molding

**Uses :** Soft touch grips, handles, consumer goods, home&kitchen appliances, automotive

	Value	Unit	Standard
<b>Physical</b>			
Hardness	50	SHORE A	ISO 868 (3 second)
Density	1,10	gr / cm3	ISO 1183 1-A
<b>Mechanical</b>			
100% Modulus	1,3	Mpa	ISO 37(S1,500 mm/min)
300% Modulus	2,5	Mpa	ISO 37(S1,500 mm/min)
Tensile Strength At Break	4,5	Mpa	ISO 37(S1,500 mm/min)
Elongation at Break	530	%	ISO 37(S1,500 mm/min)
Tear Strength (Perpendicular to flow)	20	N/mm	ISO 34-1 Method B
Adhesion to ABS	4 (B/D)	N/mm	VDI 2019
Adhesion to PC	4,5 (B/D)	N/mm	VDI 2019

**Drying Condition**

Drying Time(hr) 2-3  
Drying Temperature(°C) 60-80

**Molding Condition (°C)**

1st Zone (hopper)(°C) 190 - 200  
2nd Zone(°C) 190 - 210



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3rd Zone(°C)	200 - 220
Nozzle(°C)	210 - 220
Melt Temperature(°C)	200 - 220
Mold Temperature(°C)	30-70
Max Allowable Melt Temperature(°C)	230

