

## PIBIFLEX® 3567S2 - TPC

### Description

PIBIFLEX® 3567S2 is a nominal 35 Shore D thermoplastic polyester elastomer with medium modulus and improved flow for injection molding applications, in particular for MuCell injection molding (Dolphin process), UV stabilized and Hi scratch resistance.

### Physical properties

ISO	Value	Unit	Test Standard
Density	1120	kg/m <sup>3</sup>	ISO 1183
Melt volume rate, MVR	25	cm <sup>3</sup> /10min	ISO 1133
MVR temperature	220	°C	ISO 1133
MVR load	2.16	kg	ISO 1133
Humidity absorption, 23 °C/50%RH	0.9	%	ISO 62

### Mechanical properties

ISO	Value	Unit	Test Standard
Tensile stress at break, 50mm/min	18	MPa	ISO 527-2/1A
Tensile strain at break, 50mm/min	>500	%	ISO 527-2/1A
Flexural modulus, 23 °C	55	MPa	ISO 178
Charpy notched impact strength, 23 °C	NB	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30 °C	NB	kJ/m <sup>2</sup>	ISO 179/1eA
Izod impact notched, 23 °C	NB	kJ/m <sup>2</sup>	ISO 180/1A
Izod impact notched, -30 °C	NB	kJ/m <sup>2</sup>	ISO 180/1A
Shore D hardness, 15s	35	-	ISO 868

### Thermal properties

ISO	Value	Unit	Test Standard
Melting temperature, 10 °C/min	195	°C	ISO 11357-1/-3
Limiting oxygen index (LOI)	20	%	ISO 4589-1/-2

### Typical injection moulding processing conditions

#### Pre Drying

	LowMaxRes	DryTime	DryTemp
max	0.05 %	4 h	120 °C
min			110 °C

#### Temperature

	HRTemp	CavTemp	MTemp	Nozzle Temp	Z4Temp	Z3Temp	Z2Temp	Z1Temp	FeedTem p	Hopper
max	215 °C	55 °C	220 °C	215 °C	215 °C	210 °C	210 °C	200 °C	200 °C	50 °C
min	190 °C	20 °C	200 °C	190 °C	185 °C	185 °C	185 °C	185 °C	185 °C	20 °C

#### Speed

	Value	Unit	Test Standard
Injection speed	medium-fast	-	-

### Characteristics

#### Special Characteristics

High flow, UV resistant

#### Processing

Injection molding, Other extrusion