

**FORPRENE® 665901A60 NERO - TPV**
**Description**

Forprene 665901A60 Nero (Black) is a high melt flow injection molding thermoplastic vulcanizate (TPV) that is stabilized for heat aging and UV/weathering resistance in automotive exterior components, including glass encapsulation seals, wiper spoilers, body plugs, etc.

Physical properties	Value	Unit	Test Standard
Density	57.7	lb/ft <sup>3</sup>	ISO 1183
Mechanical properties (TPE)	Value	Unit	Test Standard
Tensile stress at 100%, perpendicular	305	psi	ISO 37
Compression set, 70 °C, 22h, Type A	39	%	ISO 815
Tensile strain at break, perpendicular	480	%	ISO 37
Tensile stress at break, perpendicular	783	psi	ISO 37
Shore A hardness-TPE, 3s	64	-	ISO 868
Shore A hardness-TPE, 15s	62	-	ISO 868
Tear strength, Method Ba, perpendicular	189	lb/in	ISO 34-1

**Typical injection moulding processing conditions**

Pre Drying	Value	Unit
Necessary low maximum residual moisture content	0.08	%
Drying time	3	h
Drying temperature	176	°F
Temperature	Value	Unit
Feeding zone temperature	338 - 356	°F
Zone1 temperature	347 - 365	°F
Zone2 temperature	365 - 383	°F
Zone3 temperature	374 - 392	°F
Nozzle temperature	383 - 401	°F
Melt temperature	392 - 428	°F
Mold temperature	68 - 104	°F

**Other text information**
**Pre-drying**

3h@80C

**Longer pre-drying times/storage**

Forprene must be stored indoors in the original, unopened and undamaged packaging, away from direct sunlight, moisture and heat.

**Characteristics**

<b>Special Characteristics</b>	High flow, UV resistant
<b>Processing</b>	Injection molding
<b>Delivery Form</b>	Pellets