

UV/AD1 Series
THERMOLAST® A

The UV/AD1 Series is your material solution for applications requiring a high UV resistance and adhesion to polar thermoplastics such as PC, ABS, PC/ABS. It is particularly appropriate for automotive exterior components.

Typical applications

- Handles (hand tools and power tools etc.)
- Seals for windows and doors

Material advantages

- Easy flowing
- Excellent adhesion
- Excellent resistance against oil and grease
- Perfect surface finish
- UV resistance

Processing Method: Extrusion, Injection Molding

	Color / RAL DESIGN	Hardness DIN ISO 7619 ShoreA	Density DIN EN ISO 1183-1 g/cm ³	Tensile Strength ¹ DIN 53504/ISO 37 MPa	Elongation at Break ¹ DIN 53504/ISO 37 %	Tear Resistance ISO 34-1 Methode B (b)(Graves) N/mm	Adhesion to ABS VDI 2019 N/mm	Adhesion to PC VDI 2019 N/mm	Adhesion to PC/ABS VDI 2019 N/mm
TA4AOZ	black	38	1.150	2.0	500	8.5	1.0 (A)	2.5 (D)	2.5 (D)
TA5AOZ	black	47	1.150	3.0	600	13.0	1.0 (A)	3.5 (D)	3.5 (D)
TA6AOZ	black	59	1.150	3.5	550	16.0	5.0 (D)	5.0 (D)	5.0 (D)
TA7AOZ	black	70	1.150	5.5	550	25.0	4.0 (D)	7.0 (D)	7.0 (D)
TA8AOZ	black	80	1.150	6.0	450	23.0	6.5 (D)	8.5 (D)	8.5 (D)

¹ Deviating from ISO 37 standard test piece S2 is tested with a traverse speed of 200 mm/min.

All values published in this data sheet are rounded average values.
Specification limits are based on three-fold standard deviation from the average value.

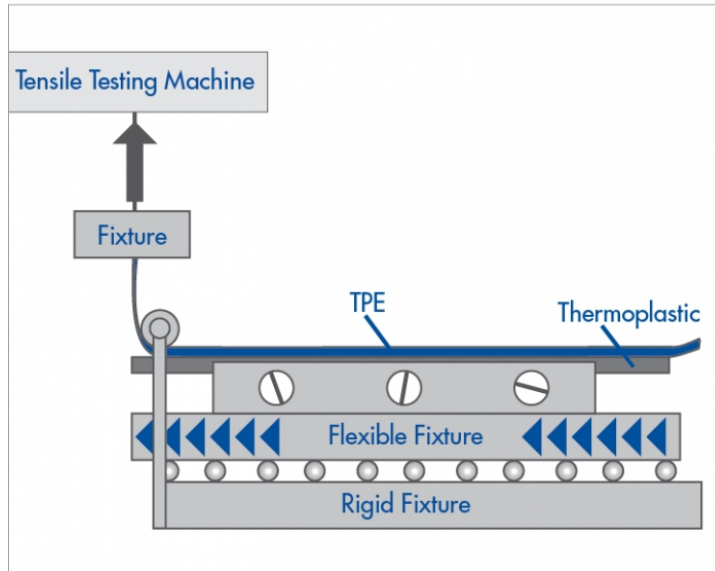
This datasheet is an extract of the KRAIBURG TPE program. Please contact KRAIBURG TPE to select the compound suitable for the requirements.

Disclaimer: The information provided in this documentation corresponds to our knowledge on the subject at the date of its publication and may be subject to revision as new knowledge and data becomes available. All values reported are typical values based on sample test results and are not a guarantee of performance. The responsibility to conduct testing to determine suitability of use for the particular process or end-use application remains with the customer. KRAIBURG TPE does not warrant or assume any liability with regards to the use of the information presented in this document.

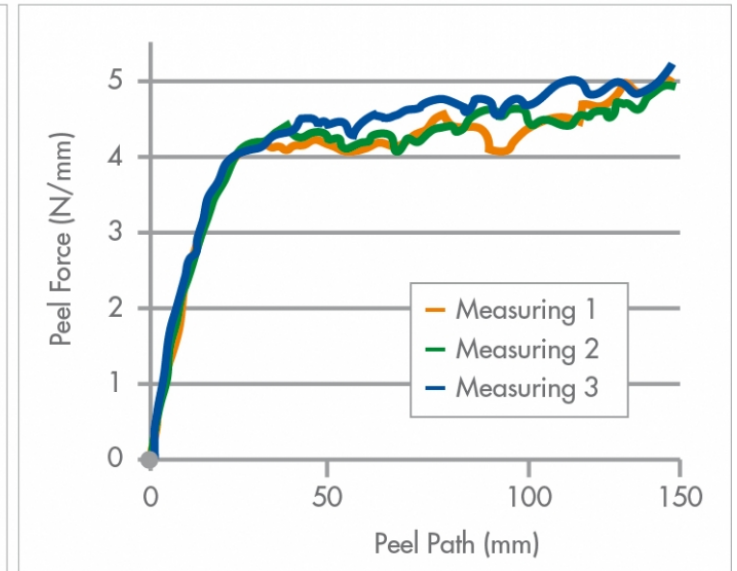
Description peel test

Peel test according to VDI guide line 2019

Test Setup



Example diagram for results of a peel test



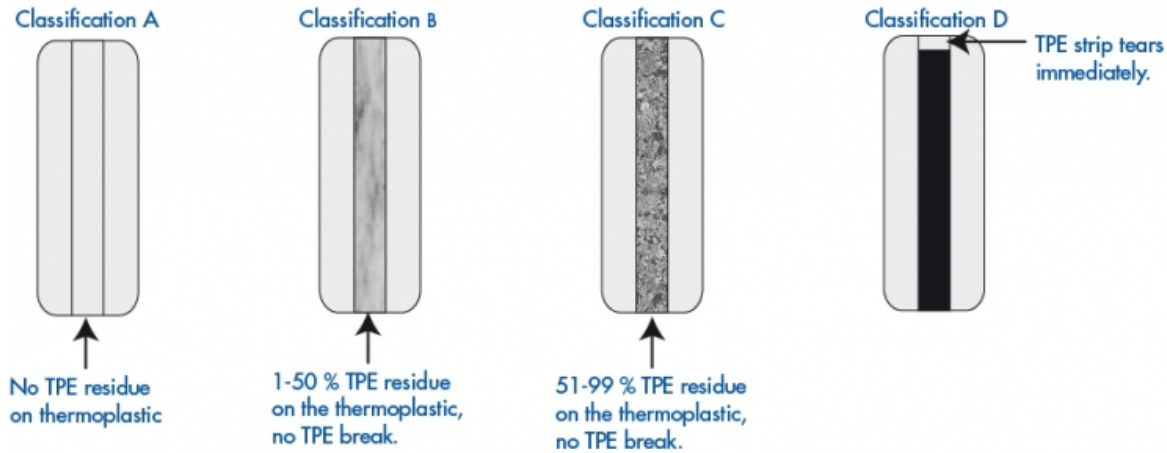
Classification

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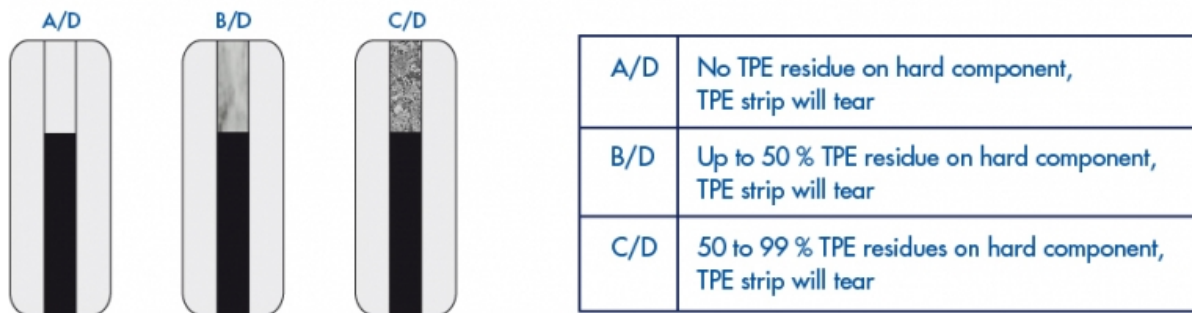
Peel test according to VDI Guideline 2019

For the VDI peel test we add two characters to the peel force value. The first character describes the TPE residue on the hard component.



A	No TPE residue on hard component
B	Up to 50 % TPE residue on hard component
C	50 to 99 % TPE residue on hard component
D	TPE strip tears immediately

The second character describes if the TPE strip will tear during the measurement at any position on the peel path.



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Processing Guideline Injection Molding

Cylinder temperature	180 - 210 - 240 °C, max. 250 °C (360 - 410 - 460 °F, max. 480 °F)
Hotrunner	Hot runner temperatures: 200 -250 °C (390 - 480 °F). The runner should be empty after a maximum of 2 - 3 shots.
Injection pressure	200 - 1000 bar (2900 - 14504 psi) (depending on the size and weight of the part).
Injection rate	In general, the fill time should not be more than 1–2 seconds.
Hold pressure	We recommend to derive the optimum hold pressure from determining the solidification point, starting with 40 % - 60 % of the required injection pressure.
Back pressure	20 - 100 bar; if colour batches are used, higher back pressure is necessary.
Screw retraction	If an open nozzle is used processing with screw retraction is advisable.
Mold temperature	The mold temperature depends on the hard component. A temperature exceeding 80 °C (175 °F) should be avoided. The common temperature is 40 - 60 °C (105 - 140° F).
Pre drying	To achieve optimum mechanical values, drying the material for 2 - 4 hours at 60 - 80 °C (140 - 175 °F) is recommended.
Needle valve	With materials < 50 Shore A the use of a needle valve is advisable.
Screw geometry	Standard 3-zone polyolefine screw.
Residence time	The residence time is to be set as short as possible with a maximum of 10 minutes.
Cleaning recommendation	For cleaning and purging of the machine it is appropriate to use polypropylene or polyethylene. Machine must be PVC-free.

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Processing Guideline Extrusion

Cylinder temperature	160 - 180 - 200 °C (320 - 360 - 390 °F). For Coextrusion with engineering thermoplastics temperature profile should be increased up to 30 °C (85 °F); maximum 230 °C (440 °F)
Screw geometry	Standard three-zone screw (e.g. polyolefin screw). The screw must be able to provide sufficient shearing.
L/D ratio	At least 25
Compression ratio	At least 3 : 1
Screens / breaker plate	A breaker plate and a screen pack are generally recommended in the extruder configuration in order to increase pressure.
Die land	<= 3 mm (<= 0,12 in.)
Extruder Head	Ca. 220 °C (430 °F)
Die temperature	Ca. 220 °C (430 °F)
Pre drying	Drying of the material for at least four hours at 80°C (175°F) is recommended. The moisture level of material has to be below 0.02 %.
Calibration	Generally not necessary; support elements may be required when extruding THERMOLAST® compounds with high hardness or when coextruding with standard thermoplastics.
Cleaning recommendation	For cleaning and purging of the machine it is appropriate to use polypropylene or polyethylene. Machine must be PVC-free.

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