



SoftFlex rubber: Thermoplastic Elastomer (TPE) SoftFlex 345A-BK

SoftFlex 345A is both an extrusion and injection molding grade Thermoplastic Elastomer (TPE) designed for soft touch applications requiring good weatherability and excellent chemical resistance. SoftFlex TPE is ideal for components such as connectors, seals, boots, flanges and grommets. It is easy to mold or extrude, exhibits low gloss and bonds very well to polypropylene.

SoftFlex 345A-BK

Typical Physical Property	ASTM	UNITS	SoftFlex 345A-BK
Hardness: I.Molded (5 Seconds)	D-2240	A	45
Specific Gravity	D-792		1.00
Tensile Strength	D-412	Mpa	4.0
Tensile Modulus @ 100 %	D-412	Mpa	1.0
Ultimate Elongation	D-412	%	750

Recommended Extrusion Process Conditions

Feed Zone: 315°F, Transition Zone: 360°F, Metering Zone: 400°F, Melt Temp: 400°F

Recommended Injection Molding Parameters

Injection Speed (fill rate) 1 to 3 cu. in/sec Injection Pressure 400 to 800 psi Injection Time (first stage/boost) 0.5 to 4 sec. Second Stage Pressure 300 to 500 psi Second Stage Time 3 to 10 sec Cooling Time 10 to 20 sec. Screw Speed 50 to 150 rpm Back Pressure 25 to 75 psi

All information supplied by TPE Solutions, Inc. is believed to be correct. It is supplied upon the express condition that the customer shall make its own assessment to determine the product suitability for a particular use.