



禾祥禎有限公司

**Ho Hsiang Ching Co.,LTD.**

**ISO 9001,14001 Certified**

**HA 4555N - TPE Thermoplastic Elastome - Natural color**

- Conforming to EU REACH-SVHC,PAHs,RoHS and US California
- Pleasing appearance and feel, easy to add color, good stability.
- Good insulation and weather resistant.
- Good two color combinations and be adhesion to ABS and PC
- High tensile strength resistance and low compression deformed.
- Non-toxic,non-polluting in production processes, eco-friendly material.
- Application: Stationery,Hand tools,Consumables,Toys, Consumables, Medical equipment

**Properties**

Item	Test Method	Value	Unit
Hardness	ASTM D2240	40 +/- 5	Shore A
Specific Gravity	ASTM D792	0.98	g/cm <sup>3</sup>
Tensile Elongation	ASTM 412C	650	%
Tensile Strength	ASTM 412C	45	Kg/cm <sup>2</sup>
Tear Strength	ASTM 624C	25	Kg/cm
Melt Flow Index	ASTM D1238	2.0 E	g/10min

B: 125°C/2.16kg C:150°C/2.16kg E: 190°C/2.16kg G: 200°C/5kg

**Processing Information**

Injection	Nominal Value	Unit
Shrinkage rate	0.8-1	%
Drying Temperature	60	oC
Drying Time	2.0~4.0	hr
Rear Temperature	170~187	oC
Middle Temperature	176~192	oC
Front Temperature	187~201	oC
Processing (Melt) Temp	185~210	oC
Mold Temperature	16~66	oC
Injection Pressure	34~69	Mpa
Back Pressure	0.34~0.69	Mpa
Screw Speed	50~70	rpm
Injection Speed	13~25	mm/sec

Cushion	3.81~25.4	mm/sec
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#### Injection Notes:

The values quoted here are typical of the grade, however, it is important to recognize that some variation around these values is to be expected as a result of uncertainties associated with measurement of the specific property and due to the normal variations encountered during the manufacturing process.

Moisture can degrade the material. Drying is suggested. This can be accomplished by placing the material in a desiccant dryer for 2 to 4 hours at 60°C

#### **Purging**

HHC TPE has excellent melt stability. Empty the barrel for idle periods of 30 minutes or longer. Purge thoroughly before and after use of this product with polyethylene or polypropylene.

#### **Coloring**

The use of polyolefin based colour concentrates is recommended. Apply back pressure in injection moulding to disperse color.

#### **Recycling/Regrind**

This product can be reprocessed. Physical properties are generally not degraded. Dry regrind prior to reprocessing.

#### **Bonding/Assembly**

Thermal bonding techniques can be used to form high strength bonds. Adhesive bonding can be achieved with specialized adhesives. Adhesive bond strength is limited due to the polypropylene base of this material.

#### **Storage & Handling**

HHC TPEE is available in 25 kg polyethylene bags (up to 1000 kg per pallet). It has a storage life at normal temperatures of several years. Please refer to the Material Safety Data Sheet for this grade prior to first time handling.

Ho Hsiang Ching Co., LTD.

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