

**Uniprene® UN-7100-73**

 Teknor Apex Company - *Thermoplastic Vulcanizate*

 Unit System: 
**Actions**

 Legend ([Open](#))

**General Information**
**General**

Material Status	● Commercial: Active		
Availability	● Africa & Middle East ● Asia Pacific	● Europe ● Latin America	● North America ● South America
Uses	● Expansion Joint ● Gaskets ● Glazing	● Grommets ● Plugs ● Shock Absorbing Pads	● Tubing ● Weatherstripping
Appearance	● Translucent		
Forms	● Pellets		
Processing Method	● Extrusion	● Injection Molding	

**ASTM & ISO Properties <sup>1</sup>**

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.948	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	2.0	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength (Break)	6.55	MPa	ASTM D412
Tensile Elongation (Break)	340	%	ASTM D412
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	73		ASTM D2240

**Processing Information**

Injection	Nominal Value	Unit
Rear Temperature	173 to 213	°C
Middle Temperature	179 to 219	°C
Front Temperature	184 to 224	°C
Nozzle Temperature	190 to 230	°C
Processing (Melt) Temp	190 to 230	°C
Mold Temperature	35.0 to 60.0	°C
Injection Pressure	1.38 to 6.89	MPa
Injection Rate	Fast	
Back Pressure	0.172 to 0.862	MPa
Screw Speed	50 to 120	rpm
Cushion	3.81 to 25.4	mm
Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	166 to 204	°C
Cylinder Zone 2 Temp.	171 to 210	°C
Cylinder Zone 3 Temp.	177 to 216	°C
Cylinder Zone 5 Temp.	182 to 221	°C
Die Temperature	190 to 227	°C

**Extrusion Notes**

Screw Speed: 30 to 100 rpm

**Notes**
<sup>1</sup> Typical properties: these are not to be construed as specifications.

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