

**Innoprene™ 2500B**

Thermoplastic Rubber

**Product Description**

Innoprene™ 2500B is thermoplastic rubber which incorporates the elasticity of thermoset rubber with the plasticity of thermoplastics. This grade can be formed by extrusion, injection molding and blow molding for various applications such as ducts, plugs, bumpers and other articles.

**General**

Applications	Automotive – Air Induction System Ducts Automotive – Plugs, Bumpers Consumer Applications – Gaskets, Seals Appliance Components		
Color	Black		
Form(s)	Pellets		
Processing	Injection Molding	Extrusion	Blow Molding
Revision Date	2021-04-01		

Physical Properties	Unit	Typical Value	Test Method
Specific Gravity	–	0.94	ISO 1183
Hardness (Shore D, 15 sec.)	–	51	ISO 868
Tensile Strength	Kgf/cm <sup>2</sup>	209	ISO 37
Elongation	%	573	ISO 37
Tear Strength	Kgf/cm	103	ISO 34-1
Compression set [125°C, 70 hrs]	%	75	ISO 815

Thermal Property	Unit	Typical Value	Test Method
Brittleness Temperature	°C	–40	ISO 812

Aging Properties [150°C, 168 hrs]	Unit	Typical Value	Test Method
Change in Shore Hardness	–	+5	ISO 188
Change in Tensile Strength	%	–20	ISO 188
Change in Elongation	%	–18	ISO 188

## Injection Molding Conditions

Drying Temperature	85 °C
Drying Time	3.0 hrs
Rear Temperature	195 °C
Middle Temperature	195 ~ 205 °C
Front Temperature	210 °C
Nozzle Temperature	215 °C
Processing(Melt) Temperature	210 ~ 215 °C
Mold Temperature	10 ~ 60 °C
Cooling Time	20 ~ 30 sec / 100 ~175 g
Injection Rate	Fast

## Extrusion Conditions

Drying Temperature	85 °C
Drying Time	3.0 hrs
Feed Temperature	195 °C
Zone 1 ~ Zone 3 Temperature	195 ~ 205 °C
Head Temperature	210 °C
Die Temperature	215 °C
Processing(Melt) Temperature	210 ~ 215 °C
Screen Pack	20 ~ 60 mesh
Back Pressure	5.0 to 20.0 Mpa

The property values shown are measured on injection molded specimens. They are based on a limited number of tests. Therefore, should not be interpreted as product specifications. These values may shift slightly as additional data are accumulated.

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