

AD/POM Series
THERMOLAST® K

The AD/POM Series is your material solution for applications with excellent adhesion to POM. The compounds are available in natural and black colors.

Typical applications

- Bumpers
- Function and design elements
- Grommets
- Handles (hand tools and power tools etc.)
- Seals
- Thumb wheels

Material advantages

- Easy coloring
- Excellent adhesion
- Excellent processing behavior
- Insert molding possible
- Patented system for TPS and POM
- Pleasant surface feel (Soft touch)
- Suitable for automotive-interior
- UV resistance

Processing Method: Injection Molding

	Color	Hardness Shore A DIN ISO 7619 ShoreA	Density DIN EN ISO 1183-1 g/cm ³	Tensile Strength ¹ DIN 53504/ISO 37 MPa	Elong. at Break S ₂ ¹ DIN 53504 / ISO 37 %	Tear Resistance DIN ISO 34-1 N/mm	Compr. Set 72h/RT DIN ISO 815 %	Compr. Set 24h/70°C DIN ISO 815 %	Compr. Set 24h/100°C DIN ISO 815 %
TC4HAA	natural	47	1.050	3.0	500	6.0	44	86	89
TC4HAZ	black	47	1.050	2.5	500	6.0	44	86	89
TC5HAA	natural	50	1.070	3.5	600	16.0	44	79	84
TC5HAZ	black	52	1.070	3.5	600	13.5	32	78	80
TC6HAA	natural	57	1.070	4.0	600	18.0	29	79	87
TC6HAZ	black	56	1.070	4.0	600	18.0	29	79	87
TC6HBA	natural	59	1.100	4.5	500	20.0	22	77	82
TC6HBZ	black	61	1.110	4.5	550	20.0	22	77	82
TC7HAA	natural	65	1.110	5.0	600	23.0	20	78	82
TC7HAZ	black	65	1.110	5.0	600	23.0	20	78	82

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.

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	Color	Hardness Shore A DIN ISO 7619 ShoreA	Density DIN EN ISO 1183-1 g/cm ³	Tensile Strength ¹ DIN 53504/ISO 37 MPa	Elong. at Break S2 ¹ DIN 53504 / ISO 37 %	Tear Resistance DIN ISO 34-1 N/mm	Compr. Set 72h/RT DIN ISO 815 %	Compr. Set 24h/70°C DIN ISO 815 %	Compr. Set 24h/100°C DIN ISO 815 %
TC7HBA	natural	70	1.130	6.0	600	24.0	21	74	76
TC7HBZ	black	72	1.130	6.0	600	21.5	21	66	67
TC8HAA	natural	77	1.150	7.5	600	28.0	19	75	77
TC8HAZ	black	77	1.150	6.5	550	28.0	19	75	77

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.

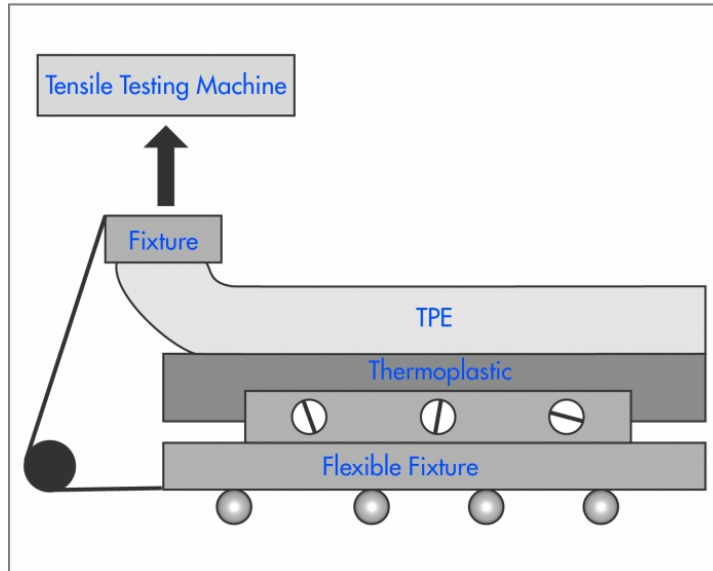
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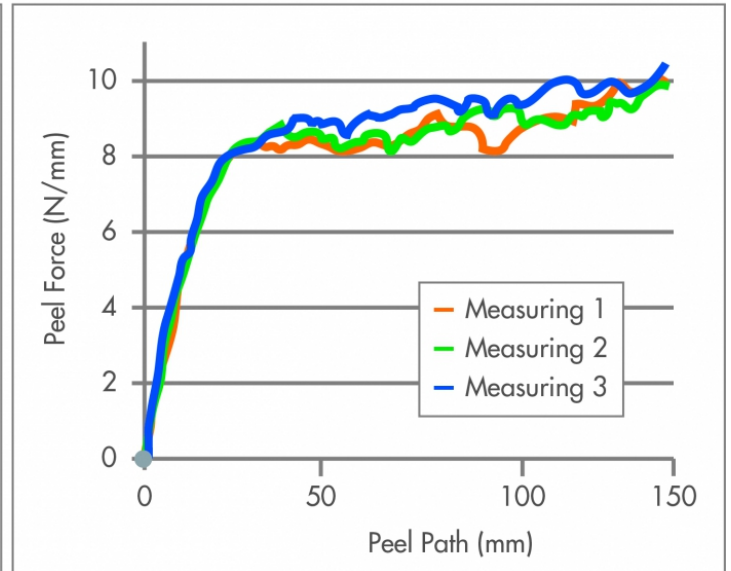
Description peel test

Peel test according to „Renault D41 1916“ standard

Test Setup



Example Diagramm as result of a peel test



The peel force is measured by a tensile testing machine in N/mm, in relation to the peel path. Test piece dimensions: Thermoplastic part: 130 x 22 x 2 mm, TPE part: 130 x 20 x 2 mm.

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Processing Guideline Injection Molding

Cylinder temperature	240 - 210 - 180 °C max. 250 °C (464 - 410 - 356 °F, max. 482 °F)
Hotrunner	Hot runner temperatures (250 -265 °C / 480 - 510 °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 - 50 bar (285 - 710 psi); 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	80 - 110 °C (175 - 230 °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 shut-off	With materials < 50 Shore the use of a needle seal nozzle is advisable.
Screw geometry	Standard 3-zone polyolefine screw.
Residence time	TPE: max. 10 Min. POM: max. 4 Min.
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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