PRODUCT INFORMATION

PIBIFLEX E4482

PIBIFLEX E4482 is a nominal 44 Shore D thermoplastic polyester elastomer with high melting point that is used for extrusion applications and use as performance modifier for TPE compounding.

ISO short ISO 18064: TPC-ET
Form Pellets

Key Features

- Low flow
- Designed for extrusion applications
- Good surface aspect

Availability

- Natural colour only

Process

- INJECTION MOULDING
- EXTRUSION

Property	Method	Unit	Value	Condition	State
PHYSICAL					
Density (+23 °C)	ISO 1183	g/cm^3	1,19		
Melting temperature (10 °C/min)	ISO 11357	°C	213		
Melt Flow Rate MFR (230 °C - 2,16 kg)	ISO 1133	g/10 min	5,0		
MECHANICAL					
Shore D hardness, 15 s	ISO 868	Shore D	44		
Tensile stress at break, speed 50 mm/min	ISO 527	MPa	31		
Tensile strain at break, speed 50 mm/min	ISO 527	%	> 450		
Flexural modulus (+23 °C)	ISO 178	MPa	143		

EXTRUSION	Value
Drying Temperature (Desiccant Dryer)	100 - 110°C
Drying Time (Desiccant Dryer)	3 - 4 h
Suggested Max Moisture	< 0,03%
Suggested Max Regrind	< 20%
Melt Temperature	220 - 250°C
Feed Temperature	215 - 225°C

The listed data are in the normal range of product properties, they should not be used to establish specification nor as the basis of design. Values are valid for natural coloured version only.

Unless specified to the contrary, the given values have been established on standardized test specimens at room temperature. These values are for natural colour only. The figures should be regarded as guide values only and not as binding minimum values. Please note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mold/die, the processing conditions, pigments and any other additives.

All information, recommendation or technical advice provided by TARO PLAST S.p.A. are given in good faith but without warranty, to the best of its knowledge and based on current procedures in effect. Our advice does not release you from the obligation to check its validity and to test our products as to their suitability for the intended processes and uses. The application, use and processing methods and conditions of our products and the products manufactured by you on the basis of our technical advice are beyond our control and, therefore, entirely under your own responsibility.

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Rear Temperature	220 - 235°C
Middle Temperature	220 - 240°C
Front Temperature	220 - 245°C
Die Temperature	220 - 250°C

Notes All TPC-ET (Pibiflex/Riteflex) compounds must be stored indoors at a temperature below 40°C / 105°F avoiding humidity and direct sunlight as well. Despite a longer shelf storage life without loss of properties, we recommend using the material within 6 months from the production date. During processing, a dehumidifying hopper dryer is recommended at a temperature of 60 to 80°C. The processing parameters like processing temperatures are a recommendation and can be adjusted in function of injection machine or extruder size, part geometry and design. To avoid hydrolytic degradation during processing,all TPC-ET (Pibiflex/Riteflex) resins have to be dried to a moisture level equal to or less than 0,05%. Drying should be done in a dehumidifying hopper dryer capable of dewpoints <-40°C (-40°F) at 107°C (225°F) for 4 hours. For subsequent storage of the material in the dryer until processed (<= 60 h) it is necessary to lower the temperature to 100°C.

INJECTION MOULDING	**Value**
Drying Temperature (Desiccant Dryer)	100 - 110°C
Drying Time (Desiccant Dryer)	2 - 4 h
Suggested Max Moisture	< 0,03%
Suggested Max Regrind	< 20%
Melt Temperature	220 - 260°C
Feed Temperature	220 - 230°C
Rear Temperature	220 - 240°C
Middle Temperature	230 - 250°C
Front Temperature	230 - 250°C
Nozzle Temperature	230 - 260°C
Mould Temperature	20 - 55°C

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