

## Product Data Sheet

KUMHO POLYCHEM

# Innoprene™ 1350N

Thermoplastic Rubber

### Product Description

Innoprene™ 1350N is thermoplastic rubber which incorporates the elasticity of thermoset rubber with the plasticity of thermoplastics. This grade can be formed by extrusion and injection molding for various applications such as tubing, gaskets, bumpers, seals and other articles.

### General

Applications	Appliance Components – Seals and Gaskets	
	Automotive – Plugs, Bumpers, Grommets, Seals and Gaskets	
	Industrial – Seals and Gaskets	
	Grips and Tubing	
Color	Natural	
Form(s)	Pellets	
Processing	Extrusion	Injection Molding
Revision Date	2021-04-01	

Physical Properties	Unit	Typical Value	Test Method
Specific Gravity	–	0.94	ISO 1183
Hardness (Shore A, 15 sec.)	–	38	ISO 868
Tensile Strength	Kgf/cm <sup>2</sup>	37	ISO 37
Elongation	%	590	ISO 37
Modulus at 100%	Kgf/cm <sup>2</sup>	11	ISO 37
Tear Strength	Kgf/cm	16	ISO 34-1
Compression set (70°C, 22 hrs)	%	26	ISO 815

Thermal Property	Unit	Typical Value	Test Method
Brittleness Temperature	°C	-62	ISO 812

Aging Properties (150°C, 168 hrs)	Unit	Typical Value	Test Method
Change in Shore Hardness	–	+3	ISO 188
Change in Tensile Strength	%	-25	ISO 188
Change in Elongation	%	-27	ISO 188

## Injection Molding Conditions

Drying Temperature	85 °c
Drying Time	3.0 hrs
Rear Temperature	165 °c
Middle Temperature	170 ~ 180 °c
Front Temperature	190 °c
Nozzle Temperature	195 °c
Processing(Melt) Temperature	190 ~ 195 °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	165 °c
Zone 1 ~ Zone 3 Temperature	170 ~ 180 °c
Head Temperature	190 °c
Die Temperature	195 °c
Processing(Melt) Temperature	190 ~ 195 °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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