

AD/PA Series
THERMOLAST® K

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

Typical applications

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

Material advantages

- Adhesion to PA6 and PA6.6 up to 50 % glass fiber
- Easy coloring
- Excellent adhesion
- Excellent processing behavior
- Insert molding possible
- Pleasant surface feel (Soft touch)
- UL 94 HB listed
- Wide hardness range 25-80 Sh A

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 %	Adhesion Renault D41 1916 (PA 6.6) ² N/mm	Adhesion Renault D41 1916 (PA6) ² N/mm
TC2PAN	natural	23	1.150	1.0	450	8.0	31	73	87	3.0	4.0
TC2PAZ	black	24	1.150	1.5	450	8.5	31	73	87	3.0	3.5
TC3PAN	natural	29	1.150	1.5	500	8.0	30	72	80	4.5	5.5
TC3PAZ	black	32	1.150	1.5	450	8.0	33	73	80	4.5	5.0
TC4PAN	natural	42	1.150	2.0	450	10.0	30	72	80	6.0	6.5
TC4PAZ	black	39	1.150	2.0	450	10.0	32	75	83	6.0	9.0
TC5PAN	natural	48	1.150	2.5	450	12.0	27	78	79	10.0	12.0
TC5PAZ	black	48	1.150	2.5	450	12.0	30	79	80	10.0	13.5
TC6PAN	natural	60	1.150	3.5	450	19.5	29	78	86	11.0	18.0
TC6PAZ	black	58	1.150	3.0	400	16.0	28	80	81	11.0	18.0

This datasheet is an extract of the KRAIBURG TPE program. Please contact KRAIBURG TPE to select the compound suitable for the requirements.

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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 %	Adhesion Renault D41 1916 (PA 6.6) ² N/mm	Adhesion Renault D41 1916 (PA6) ² N/mm
TC7PAN	natural	68	1.150	3.5	350	17.0	30	76	81	13.0	18.0
TC7PAZ	black	71	1.150	3.5	350	17.0	34	80	85	13.0	22.0
TC8PAN	natural	80	1.150	5.5	350	29.0	29	78	90	16.0	23.5
TC8PAZ	black	80	1.150	5.5	350	23.0	34	81	82	16.0	23.5

¹ Deviating from ISO 37 standard test piece S2 is tested with a traverse speed of 200 mm/min.

² The adhesion quality depends on mold design, product geometry and process parameters.

All values published in this data sheet are rounded average values.
Specification limits are based on three-fold standard deviation from the average value.

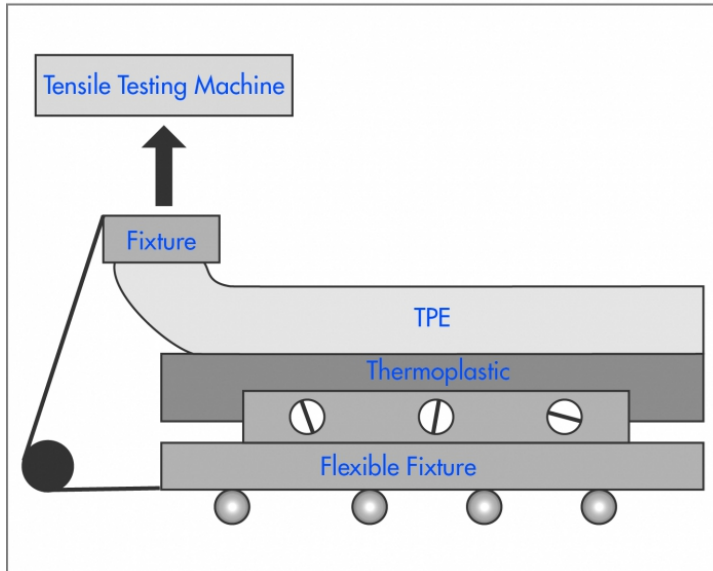
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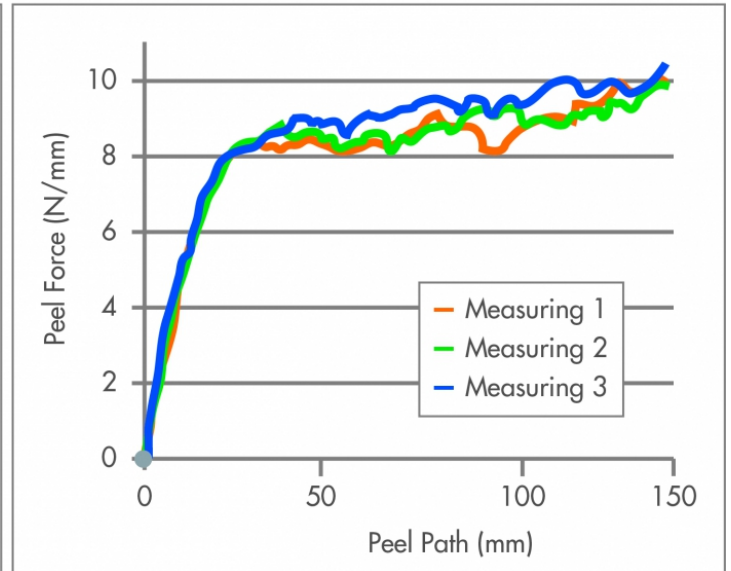
Description peel test

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	PA 6: 270 - 260 - 240 °C max. 280 °C (518 - 500 - 464 °F, max. 536 °F) PA 6.6: 280 - 270 - 255 °C, max. 290 °C (536 - 518 - 491 °F, max. 554 °F)
Hotrunner	Hot runner temperatures: PA 6 max. 280 °C (535 °F); PA 6.6 290 °C (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	The mold temperature depends on the hard component. A temperature exceeding 80 °C (175 °F) should be avoided. The common temperature is 40 - 60 °C (105 - 140° 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	The residence time is to be set as short as possible with a maximum of 10 minutes.
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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