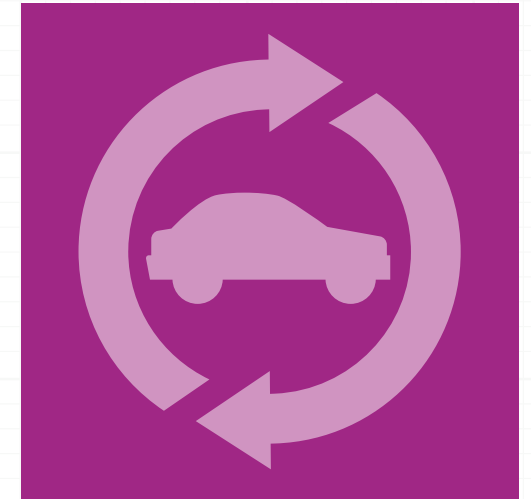


Dryflex[®] PCW

TPEs based on Post Consumer Recyclate



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INTRODUCTION

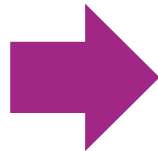
We are successfully helping to convert a rapidly growing plastics waste stream into new life plastic products with our Dryflex PCW range of TPE compounds based on Post Consumer Recyclate materials.

The Dryflex PCW range of Thermoplastic Elastomers (TPE) was developed to address demands in the automotive industry, which is obliged to use increasing quantities of post consumer recyclate and operate under the [ELV Directive](#)→ to ensure recyclability at the end of a vehicle's life.

In this guide we show typical properties for our most common grades, these tables are not exhaustive and by no means list all available properties and materials.

Please use this guide as an introduction to our Dryflex PCW range and [contact us](#) to discuss your specific requirements.

GIVING TYRE & PLASTIC RECYCLATE A NEW LIFE



Dryflex PCW compounds contain a volume of post consumer recyclate from 33% to 80% by weight. Recyclate consists of polypropylene drawn from automotive mouldings, which are cleaned and re-ground and rubber tyre crumb from both OEM and after market tyres.

Grades are available with varying amounts of recyclate. Dryflex PCW 92A331B contains 33% by weight recycled PP through to Dryflex 40D701B, which contains 70% PCW, of which 40% is tyre crumb.

PERFORMANCE

Apart from the obvious benefit of recycling, the material exhibits other advantages when compared with virgin materials, particularly its superior UV, weathering resistance and sound reduction properties (NVH testing).

Dryflex PCW compounds are also fully recyclable after use. This is true even in the case of mouldings containing rubber tyre crumb, as during the compounding process the rubber molecules remain unaffected and may be recycled time after time.

TYPICAL APPLICATIONS

- Interior and exterior trim
- Mudflaps
- Sidesteps
- Underbody stonechip protectors
- Anti-drag lips
- Wheel arch liners
- Door weatherstrips
- Spoilers

TYPICAL PROPERTIES

Grade	Hardness ¹ ISO 868 Shore A or D	Density ISO 2781 g/cm ³	Tensile Strength ² ISO 37 Type 1 MPa	Elongation at Break ² ISO 37 Type 1 %	Tear Strength ² ISO 34 Method C N/mm	CS 23°C/24h ISO 815-1 Type B %	PCW content by weight %
Dryflex PCW 80A651B	80 A	1.10	5.3	>150	38	36	65
Dryflex PCW 90A331B	90 A	1.05	9.5	>250	74	63	33
Dryflex PCW 91A701B	91 A	1.06	7.1	>20	107	52	70
Dryflex PCW 92A331B	92 A	1.11	7.5	>450	58	-	33
Dryflex PCW 93A331B	93 A	1.11	7.5	>450	58	-	33
Dryflex PCW 40D701B	40 D	1.06	8.4	>20	62	60	70
Dryflex PCW 50D801B	50 D	1.00	12.9	>20	82	73	80

¹ After 15 seconds

² Across the flow direction

PROCESSING

Dryflex PCW compounds have excellent processing characteristics and can be processed using standard thermoplastic processing methods, including injection moulding.

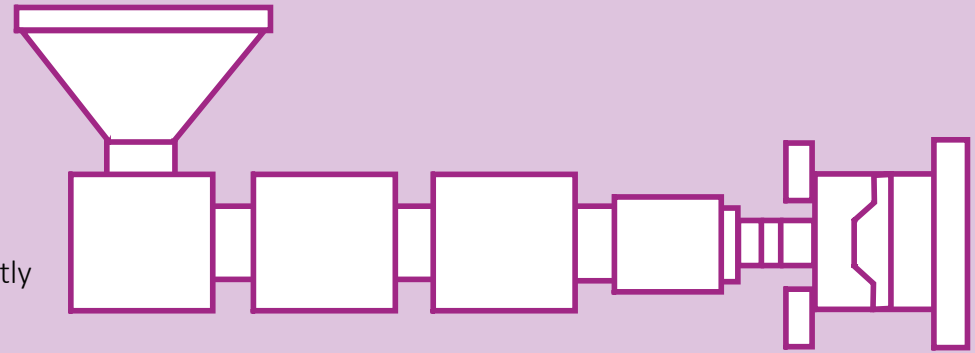
In general no predrying of the material is necessary, however, after periods of prolonged storage predrying may be necessary. Cycle times will be governed by temperature and section thickness. Care must be taken to allow sufficient cooling of the section prior to demoulding in order to prevent permanent distortion of the article.



Further TPE processing & problem solving information is available to download from our website

INJECTION MOULDING GUIDLINES

Injection Speed:	Medium - Fast
Injection Pressure:	Medium
Back Pressure:	Low - Medium
Holding Pressure:	Sufficient to pack the mould
Cooling:	Can be demoulded when parts have cooled sufficiently



Recommended start-up temperatures °C

170 - 190 180 - 200 190 - 210 200 - 220 20 - 60

This processing information is intended only as a guide. The actual parameters will depend on the machine used and the moulding being produced.