



CoolPoly® E8103 Thermally Conductive Thermoplastic Elastomer (TPE)

CoolPoly E8103 is a thermally conductive injection molding resin based on a thermoplastic elastomer (TPE) matrix. CoolPoly E8103 is electrically conductive. Thermally conductive polymers like CoolPoly E8103 cool faster than standard injection molding grade resins.

Typical Injection Molding Conditions

Temperature Settings	SI /Metric	English
Rear Zone	175 - 190 °C	350 - 370 °F
Center Zone	190 - 205 °C	370 - 400 °F
Front Zone	195 - 215 °C	380 - 420 °F
Nozzle	195 - 215 °C	380 - 420 °F
Melt	190 - 215 °C	370 - 420 °F
Mold	20 - 45 °C	70 - 110 °F

Pressure Settings

Injection	4.1 - 8.3 MPa	600 - 1200 psi
Hold	1.4 - 4.1 MPa	200 - 600 psi
Back	0 - 0.7 MPa	0 - 100 psi

Injection Settings

Fill	moderate - fast mm/sec	moderate - fast mm/s
Screw	50 - 150 rpm	50 - 150 rpm

Drying Conditions

Time & Temperature	1-2hrs @ 65 °C	1-2hrs @ 150 °F
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Additional Information

A low compression screw (less than 2:1) is recommended

Drying is required only to drive off surface moisture as the material is not hydroscopic and does not absorb moisture.

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