

Telcar® TL-2363T XRD9 (PRELIMINARY DATA)

Thermoplastic Elastomer

Teknor Apex Company

Message:

Telcar TL-2363T XRD9 is a UV resistant thermoplastic elastomer designed for outdoor applications requiring a soft, rubber-like feel. Telcar TL-2363T XRD9 is a high hardness grade that exhibits excellent abrasion resistance, suitable for injection molding.

General Information			
Features	Sunlight Resistant		
	smoothness		
	Light stabilization		
	High liquidity		
	Ablation resistance		
	Lubrication		
	Fill		
	brominated		
	High hardness		
	Medium density		
	UV absorption		
	Flame retardancy		
Uses	Floor Material		
Appearance	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.02	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	8.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 second, injection molding	90		ASTM D2240
Shore A, 5 seconds, injection molding	88		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
Transverse flow: 100% strain ¹	6.05	MPa	ASTM D412
Flow: 100% strain ²	8.13	MPa	ASTM D412
Transverse flow: 300% strain ³	7.29	MPa	ASTM D412
Flow: 300% strain ⁴	9.54	MPa	ASTM D412
Tensile Strength ⁵			ASTM D412
Transverse flow: Fracture	9.87	MPa	ASTM D412

Flow: Fracture	12.5	MPa	ASTM D412
Tensile Elongation ⁶			ASTM D412
Transverse flow: Fracture	520	%	ASTM D412
Flow: Fracture	550	%	ASTM D412
Tear Strength ⁷			ASTM D624
Transverse flow	46.8	kN/m	ASTM D624
Flow	57.6	kN/m	ASTM D624
Compression Set ⁸			ASTM D395B
23°C, 22 hr	44	%	ASTM D395B
70°C, 22 hr	85	%	ASTM D395B
Flammability	Nominal Value	Unit	Test Method
Oxygen Index	20	%	ASTM D2863
Injection	Nominal Value	Unit	
Rear Temperature	171 - 193	°C	
Middle Temperature	177 - 199	°C	
Front Temperature	182 - 204	°C	
Nozzle Temperature	188 - 210	°C	
Processing (Melt) Temp	188 - 210	°C	
Mold Temperature	25.0 - 65.6	°C	
Injection Pressure	1.38 - 6.89	MPa	
Injection Rate	Moderate-Fast		
Back Pressure	0.172 - 0.345	MPa	
Screw Speed	50 - 100	rpm	
Cushion	3.81 - 25.4	mm	
Injection instructions			
Drying is not necessary. However, if moisture is a problem, dry the pellets for 2 to 4 hours at 150°F (65°C).			
Extrusion	Nominal Value	Unit	
Cylinder Zone 1 Temp.	166 - 188	°C	
Cylinder Zone 2 Temp.	171 - 193	°C	
Cylinder Zone 3 Temp.	177 - 199	°C	
Cylinder Zone 5 Temp.	182 - 204	°C	
Die Temperature	190 - 210	°C	
Extrusion instructions			
Screw Speed: 30 to 100 rpm			
NOTE			
1.	Mouth die C, 510mm/min		
2.	Mouth die C, 510mm/min		
3.	C mold, 510mm/min		
4.	C mold, 510mm/min		
5.	C mold, 510mm/min		
6.	Mouth die C, 510mm/min		
7.	C mold, 510mm/min		

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