

Telcar® OBC 4670A

Thermoplastic Elastomer

Teknor Apex Company

Message:

Telcar®OBC 4670A is a thermoplastic elastomer (TPE) material. This product is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific. The processing methods are: blow molding, wire & cable extrusion molding, extrusion, sheet extrusion molding, thermoforming, profile extrusion molding or injection molding.

Typical application areas include:

Automotive Industry
engineering/industrial accessories

General Information			
Uses	Blow molding applications		
	Washer		
	Weather-resistant sealing strip		
	Application in Automobile Field		
	Car interior parts		
	Automotive exterior parts		
	Car exterior decoration		
	General		
Appearance	Translucent		
Forms	Particle		
Processing Method	Blow molding		
	Wire & Cable Extrusion		
	Extrusion		
	Sheet extrusion molding		
	Thermoforming		
	Profile extrusion molding		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.968	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	0.20	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 5 sec)	75		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength (Break)	8.62	MPa	ASTM D412
Tensile Elongation (Break)	850	%	ASTM D412
Compression Set			ASTM D395
23°C, 22 hr	17	%	ASTM D395

70°C, 22 hr	44	%	ASTM D395
100°C, 22 hr	65	%	ASTM D395
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	
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			
螺杆转速30 - 100 rpm			

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