

Telcar® TELC-340

Thermoplastic Elastomer

Teknor Apex Company

Message:

Telcar TELC-340 is a general purpose thermoplastic elastomer designed for the consumer and industrial markets. Telcar TELC-340 is a high hardness, low density grade that is suitable for extrusion and injection molding.

General Information			
Features	Low density		
Uses	General		
Appearance	Natural color		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.888	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	5.0	g/10 min	ASTM D1238

Hardness	Nominal Value	Unit	Test Method
Durometer Hardness ¹ (Shore A, 5 sec)	94		ISO 868

Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus	172	MPa	ASTM D790

Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ISO 37
Transverse flow: 100% strain	6.24	MPa	ISO 37
Flow: 100% strain	8.31	MPa	ISO 37
Tensile Strength			ISO 37
Transverse flow: Fracture	12.5	MPa	ISO 37
Flow: Fracture	9.90	MPa	ISO 37
Tensile Elongation			ISO 37
Transverse flow: Fracture	810	%	ISO 37
Flow: Fracture	560	%	ISO 37
Tear Strength - Across Flow	74.0	kN/m	ISO 34
Compression Set ² (23°C, 22 hr)	57	%	ISO 815

Aging	Nominal Value	Unit	Test Method
Change in Tensile Strength in Air			ISO 188
110°C, 1008 hr	-7.2	%	ISO 188
125°C, 168 hr	-4.0	%	ISO 188
Changes in tensile stress upon fracture in air-Transverse flow			ISO 188

110°C, 1008 hr	-14	%	ISO 188
125°C, 168 hr	-8.3	%	ISO 188
Change in Shore Hardness in Air			ISO 188
Support a, 110°C, 1008 hr	-0.20		ISO 188
Support a, 125°C, 168 hr	0.50		ISO 188
Thermal	Nominal Value	Unit	Test Method
Brittleness Temperature	< -50.0	°C	ASTM D746
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (200°C, 206 sec ⁻¹)	322	Pa·s	ASTM D3835
Legal statement			

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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

Screw Speed: 30 to 100 rpm

NOTE	
1.	Instant
2.	Method A

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