

Sarlink® TPE EE-1230N

Thermoplastic Elastomer

Teknor Apex Company

Message:

Sarlink®TPE EE-1230N 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 method is: extrusion.

Sarlink®The typical application field of TPE EE-1230N is: automobile industry

General Information			
Uses	Car exterior decoration		
Appearance	Opacity		
Forms	Particle		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.17	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	0.50	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness ¹			ASTM D2240
Shore A, 1 second, injection molding	33		ASTM D2240
Shore A, 5 seconds, injection molding	30		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ²			ASTM D412
Transverse flow: 100% strain	0.317	MPa	ASTM D412
Flow: 100% strain	0.586	MPa	ASTM D412
Tensile Strength ³			ASTM D412
Transverse flow: Fracture	4.73	MPa	ASTM D412
Flow: Fracture	2.63	MPa	ASTM D412
Tensile Elongation ⁴			ASTM D412
Transverse flow: Fracture	950	%	ASTM D412
Flow: Fracture	740	%	ASTM D412
Tear Strength - Across Flow ⁵	16.8	kN/m	ASTM D624
Injection	Nominal Value	Unit	
Rear Temperature	199 - 210	°C	
Middle Temperature	204 - 216	°C	
Front Temperature	210 - 221	°C	
Nozzle Temperature	216 - 227	°C	
Processing (Melt) Temp	216 - 227	°C	
Mold Temperature	35.0 - 65.6	°C	
Injection Pressure	1.38 - 6.89	MPa	
Injection Rate	Fast		

Back Pressure	0.172 - 0.862	MPa
Screw Speed	50 - 120	rpm
Cushion	3.81 - 25.4	mm

Injection instructions

无需干燥.但如果湿度过大,则将粒料在150°F (65°C)的温度下干燥2-4小时.

Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	193 - 204	°C
Cylinder Zone 2 Temp.	199 - 210	°C
Cylinder Zone 3 Temp.	204 - 216	°C
Cylinder Zone 5 Temp.	210 - 221	°C
Die Temperature	216 - 227	°C

Extrusion instructions

螺杆转速30 - 100 rpm

NOTE

1. Aging 48 hr
2. Mouth die C, 510mm/min
3. C mold, 510mm/min
4. Mouth die C, 510mm/min
5. C mold, 510mm/min

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