# Sarlink® TPE FM-2676 (PRELIMINARY DATA)

Thermoplastic Elastomer

Teknor Apex Company

## Message:

Sarlink FM-2676 is a general purpose thermoplastic elastomer, available in NAT, BLK, and colors, designed for automotive interior applications, including floor mats. Sarlink FM-2676 is a medium hardness, high density, filled grade suitable for extrusion and thermoforming.

| General Information | |
|---|---|
| Features | Workability, good<br>Good flexibility<br>Good tear strength<br>Good coloring<br>Good adhesion<br>Low liquidity<br>Good chemical resistance<br>Good wear resistance<br>Good weather resistance<br>Good toughness<br>Fill<br>Medium density<br>Medium hardness |
| Uses | Thermoforming Applications<br>Application in Automobile Field<br>Car interior parts<br>Rubber substitution |
| RoHS Compliance | RoHS compliance |
| Appearance | Available colors<br>Natural color |
| Forms | Particle |
| Processing Method | Extrusion<br>Thermoforming |

| Physical | Nominal Value | Unit | Test Method |
|---|---|---|---|
| Density | 1.10 | g/cm³ | ISO 1183 |
| Melt Mass-Flow Rate (MFR) (230°C/2.16 kg) | 0.40 | g/10 min | ASTM D1238 |
| **Hardness** | **Nominal Value** | **Unit** | **Test Method** |
| Durometer Hardness | | | ISO 868 |

| | | | |
|---|---|---|---|
| Shore A, 1 second, injection molding | 79 | | ISO 868 |
| Shore A, 5 seconds, injection molding | 77 | | ISO 868 |
| Shore A, 15 seconds, injection molding | 75 | | ISO 868 |
| **Elastomers** | **Nominal Value** | **Unit** | **Test Method** |
| Tensile Stress [1] | | | ISO 37 |
| Transverse flow: 100% strain | 2.53 | MPa | ISO 37 |
| Flow: 100% strain | 3.75 | MPa | ISO 37 |
| Tensile Stress [2] | | | ISO 37 |
| Transverse flow: Fracture | 9.20 | MPa | ISO 37 |
| Flow: Fracture | 6.30 | MPa | ISO 37 |
| Tensile Elongation [3] | | | ISO 37 |
| Transverse flow: Fracture | 970 | % | ISO 37 |
| Flow: Fracture | 460 | % | ISO 37 |
| Tear Strength [4] | | | ISO 34-1 |
| Transverse flow | 46 | kN/m | ISO 34-1 |
| Flow | 44 | kN/m | ISO 34-1 |
| Compression Set [5] | | | ISO 815 |
| 23°C, 22 hr | 22 | % | ISO 815 |
| 70°C, 22 hr | 37 | % | ISO 815 |
| 90°C, 70 hr | 61 | % | ISO 815 |
| **Aging** | **Nominal Value** | **Unit** | **Test Method** |
| Change in Tensile Strength in Air [6] | | | ISO 188 |
| Transverse flow: 110°C, 1008 hr | -1.9 | % | ISO 188 |
| Flow: 110°C, 1008 hr | 10 | % | ISO 188 |
| Transverse flow: 100% strain 110°C, 1008 hr | 13 | % | ISO 188 |
| Flow: 100% strain 110°C, 1008 hr | -2.6 | % | ISO 188 |
| Change in Tensile Strain at Break in Air [7] | | | ISO 188 |
| Transverse flow: 110°C, 1008 hr | -3.5 | % | ISO 188 |
| Flow: 110°C, 1008 hr | 14 | % | ISO 188 |
| Change in Shore Hardness in Air | | | |
| Shao A, 110°C, 1008 hr [8] | -0.40 | | ISO 188 |
| Shao A, 110°C, 1008 hr [9] | -0.50 | | ISO 188 |
| **Fill Analysis** | **Nominal Value** | **Unit** | **Test Method** |
| Apparent Viscosity (200°C, 206 sec^-1) | 617 | Pa·s | ASTM D3835 |

**Legal statement**



| **Injection** | **Nominal Value** | **Unit** |
|---|---|---|

| | | |
|---|---|---|
| Rear Temperature | 227 - 249 | °C |
| Middle Temperature | 227 - 249 | °C |
| Front Temperature | 227 - 249 | °C |
| Nozzle Temperature | 227 - 249 | °C |
| Processing (Melt) Temp | 227 - 249 | °C |
| Mold Temperature | 16 - 32 | °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 |
|---|
| 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. | 216 - 238 | °C |
| Cylinder Zone 2 Temp. | 216 - 238 | °C |
| Cylinder Zone 3 Temp. | 216 - 238 | °C |
| Cylinder Zone 4 Temp. | 216 - 238 | °C |
| Cylinder Zone 5 Temp. | 216 - 238 | °C |
| Die Temperature | 216 - 238 | °C |

| Extrusion instructions |
|---|
| Screw Speed: 30 to 100 rpm |

| NOTE | |
|---|---|
| 1. | Type 1, 510mm/min |
| 2. | Type 1, 510mm/min |
| 3. | Type 1, 510mm/min |
| 4. | B method, right angle specimen (without cut), 510mm/min |
| 5. | Type a |
| 6. | Type 1 |
| 7. | Type 1 |
| 8. | 1 sec |
| 9. | 15 sec |



Recommended distributors for this material

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