

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		
	Good flexibility		
	Good tear strength		
	Good coloring		
	Good adhesion		
	Low liquidity		
	Good chemical resistance		
	Good wear resistance		
	Good weather resistance		
	Good toughness		
	Fill		
	Medium density		
	Medium hardness		
Uses	Thermoforming Applications		
	Application in Automobile Field		
	Car interior parts		
	Rubber substitution		
RoHS Compliance	RoHS compliance		
Appearance	Available colors		
	Natural color		
Forms	Particle		
Processing Method	Extrusion		
	Thermoforming		
Physical	Nominal Value	Unit	Test Method
Density	1.10	g/cm ³	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			
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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

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