

Sarlink® TPE ME-2345B-02 BLK XRD1

(PRELIMINARY DATA)

Thermoplastic Elastomer
Teknor Apex Company

Message:

Sarlink ME-2345B-02 BLK XRD1 is a high performance thermoplastic elastomer used in automotive applications including exterior trim and weatherstripping. Sarlink ME-2345B-02 BLK XRD1 is a low hardness, low density, light stabilized grade suitable for injection molding.

General Information			
Features	Low Specific Gravity		
	Low to No Fogging		
	Sunlight Resistant		
	Low density		
	Low friction coefficient		
	High smoothness		
	Light stabilization		
	Medium liquidity		
	Lubrication		
	Fill		
	Hardness, low		
	UV absorption		
Uses	Washer		
	Weather-resistant sealing strip		
	Application in Automobile Field		
	Automotive exterior parts		
	Car exterior decoration		
RoHS Compliance	RoHS compliance		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	0.920	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	7.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ISO 868
Shore A, 1 second, injection molding	48		ISO 868

Shore A, 5 seconds, injection molding	45		ISO 868
Shore A, 15 seconds, injection molding	43		ISO 868
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ¹			ISO 37
Transverse flow: 100% strain	1.07	MPa	ISO 37
Flow: 100% strain	1.69	MPa	ISO 37
Tensile Stress ²			ISO 37
Transverse flow: Fracture	6.41	MPa	ISO 37
Flow: Fracture	3.92	MPa	ISO 37
Tensile Elongation ³			ISO 37
Transverse flow: Fracture	900	%	ISO 37
Flow: Fracture	680	%	ISO 37
Tear Strength ⁴			ISO 34-1
Transverse flow	17	kN/m	ISO 34-1
Flow	22	kN/m	ISO 34-1
Compression Set ⁵			ISO 815
23°C, 22 hr	20	%	ISO 815
70°C, 22 hr	39	%	ISO 815
90°C, 70 hr	65	%	ISO 815
125°C, 70 hr	82	%	ISO 815
Aging	Nominal Value	Unit	Test Method
Change in Tensile Strength in Air ⁶			ISO 188
Transverse flow: 110°C, 1008 hr	6.7	%	ISO 188
Flow: 110°C, 1008 hr	34	%	ISO 188
Transverse flow: 100% strain 110°C, 1008 hr	7.6	%	ISO 188
Flow: 100% strain 110°C, 1008 hr	9.6	%	ISO 188
Transverse flow: 125°C, 168 hr	16	%	ISO 188
Flow: 125°C, 168 hr	34	%	ISO 188
Transverse flow: 100% strain 125°C, 168 hr	4.5	%	ISO 188
Flow: 100% strain 125°C, 168 hr	8.6	%	ISO 188
Change in Tensile Strain at Break in Air ⁷			ISO 188
Transverse flow: 110°C, 1008 hr	-5.8	%	ISO 188
Flow: 110°C, 1008 hr	11	%	ISO 188
Transverse flow: 125°C, 168 hr	6.2	%	ISO 188
Flow: 125°C, 168 hr	22	%	ISO 188
Change in Shore Hardness in Air			ISO 188
Shao A, 110°C, 1008 hr ⁸	2.5		ISO 188
Shao A, 110°C, 1008 hr ⁹	2.2		ISO 188
Shao A, 110°C, 1008 hr ¹⁰	1.9		ISO 188
Shao A, 125°C, 168 hr ¹¹	3.1		ISO 188
Shao A, 125°C, 168 hr ¹²	2.6		ISO 188

Shao A, 125°C, 168 hr ¹³	2.3		ISO 188
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (200°C, 206 sec ⁻¹)	137	Pa·s	ASTM D3835
Legal statement			
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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 - 66	°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.	193 - 204	°C	
Cylinder Zone 2 Temp.	199 - 210	°C	
Cylinder Zone 3 Temp.	204 - 216	°C	
Cylinder Zone 4 Temp.	204 - 216	°C	
Cylinder Zone 5 Temp.	210 - 221	°C	
Die Temperature	216 - 227	°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.	15 sec		

9.	5 sec
10.	1 sec
11.	15 sec
12.	5 sec
13.	1 sec

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