

Telcar® TL-1000-95

Thermoplastic Elastomer

Teknor Apex Company

Message:

Telcar®TL-1000-95 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 or injection molding.
Typical application areas include:
Automotive Industry
engineering/industrial accessories

General Information			
Uses	Blow molding applications		
	Washer		
	Weather-resistant sealing strip		
	Application in Automobile Field		
	Car interior parts		
	Automotive exterior parts		
	Car exterior decoration		
	General		
Appearance	Translucent		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.898	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	2.4	g/10 min	ASTM D1238
Molding Shrinkage			ASTM D955
Flow	1.2	%	ASTM D955
Transverse flow	1.4	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D, 10 sec)	45		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus	365	MPa	ASTM D790
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength (Break)	15.2	MPa	ASTM D412
Tensile Elongation (Break)	600	%	ASTM D412
Tear Strength	91.9	kN/m	ASTM D624
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		

螺杆转速30 - 100 rpm

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