

Telcar® OBC 1383N

Thermoplastic Elastomer

Teknor Apex Company

Message:

Telcar OBC 1383N is a general purpose thermoplastic elastomer designed for a variety of consumer product applications requiring a soft, rubber-like feel. Telcar OBC 1383N is a medium hardness grade suitable for injection molding and extrusion.

General Information	
Features	Low density
	Low liquidity
	Fill
	Medium hardness
Uses	Industrial application
	Weather-resistant sealing strip
	General
Appearance	Opacity
Forms	Particle
Processing Method	Extrusion
	Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.948	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	5.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 second, injection molding	55		ASTM D2240
Shore A, 5 seconds, injection molding	53		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
Transverse flow: 100% strain ¹	1.94	MPa	ASTM D412
Flow: 100% strain ²	1.68	MPa	ASTM D412
Transverse flow: 300% strain ³	2.04	MPa	ASTM D412
Flow: 300% strain ⁴	2.50	MPa	ASTM D412
Tensile Strength ⁵			ASTM D412
Transverse flow: Fracture	6.72	MPa	ASTM D412
Flow: Fracture	4.34	MPa	ASTM D412
Tensile Elongation ⁶			ASTM D412
Transverse flow: Fracture	2600	%	ASTM D412

Flow: Fracture	720	%	ASTM D412
Tear Strength ⁷			ASTM D624
Transverse flow	23.6	kN/m	ASTM D624
Flow	24.9	kN/m	ASTM D624
Compression Set ⁸			ASTM D395B
23°C, 22 hr	27	%	ASTM D395B
70°C, 22 hr	67	%	ASTM D395B

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

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.	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

Screw Speed: 30 to 100 rpm

NOTE

1. Mouth die C, 510mm/min
2. Mouth die C, 510mm/min
3. C mold, 510mm/min
4. C mold, 510mm/min
5. C mold, 510mm/min
6. Mouth die C, 510mm/min
7. C mold, 510mm/min
8. Type 1

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