

Sarlink® TPE EE-1235N

Thermoplastic Elastomer

Teknor Apex Company

Message:

Sarlink®TPE EE-1235N 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.

Sarlink®The typical application field of TPE EE-1235N is: automobile industry

General Information			
Uses	Car exterior decoration		
Appearance	Opacity		
Forms	Particle		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.17	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	0.60	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A	38		ASTM D2240
Shaw A, 15 seconds	35		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
Transverse flow: 100% strain	0.552	MPa	ASTM D412
Flow: 100% strain	0.896	MPa	ASTM D412
Tensile Strength			ASTM D412
Transverse flow: Fracture	5.24	MPa	ASTM D412
Flow: Fracture	3.10	MPa	ASTM D412
Tensile Elongation			ASTM D412
Transverse flow: Fracture	930	%	ASTM D412
Flow: Fracture	730	%	ASTM D412
Tear Strength - Across Flow	18.7	kN/m	ASTM D624
Compression Set			ASTM D395
23°C, 22 hr	10	%	ASTM D395
70°C, 22 hr	24	%	ASTM D395
125°C, 70 hr	79	%	ASTM D395
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	35.0 - 65.6	°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

无需干燥.但如果湿度过大,则将粒料在150°F (65°C)的温度下干燥2-4小时.

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 5 Temp.	210 - 221	°C
Die Temperature	216 - 227	°C

Extrusion instructions

螺杆转速30 - 100 rpm

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