

Sarlink® TPE EE-2260N NAT

Thermoplastic Elastomer

Teknor Apex Company

Message:

The Sarlink EE-2200 series UV Resistant extrusion grades suitable for automotive exterior applications.

General Information			
Features	High density		
Uses	Application in Automobile Field		
Appearance	Natural color		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		

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)	0.50	g/10 min	ASTM D1238

Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 5 sec)	60		ISO 868

Elastomers	Nominal Value	Unit	Test Method
Tensile Stress - Across Flow (100% Strain)	1.60	MPa	ISO 37
Tensile Stress - Across Flow (Break)	9.10	MPa	ISO 37
Tensile Elongation - Across Flow (Break)	790	%	ISO 37
Compression Set (21°C, 22 hr)	34	%	ISO 815

Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (200°C, 206 sec ⁻¹)	266	Pa · s	ASTM D3835

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

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

Extrusion instructions

Screw Speed: 30 to 100 rpm

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