

# Telcar® OBC 4565A

Thermoplastic Elastomer

Teknor Apex Company

## Message:

Telcar®OBC 4565A 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 methods are: blow molding, wire & cable extrusion molding, extrusion, sheet extrusion molding, thermoforming, profile extrusion molding or injection molding.

Typical application areas include:  
engineering/industrial accessories  
Handle

| General Information                       |                           |                   |             |
|-------------------------------------------|---------------------------|-------------------|-------------|
| Uses                                      | overmolding               |                   |             |
|                                           | Soft handle               |                   |             |
| Appearance                                | Translucent               |                   |             |
| Forms                                     | Particle                  |                   |             |
| Processing Method                         | Blow molding              |                   |             |
|                                           | Wire & Cable Extrusion    |                   |             |
|                                           | Extrusion                 |                   |             |
|                                           | Sheet extrusion molding   |                   |             |
|                                           | Thermoforming             |                   |             |
|                                           | Profile extrusion molding |                   |             |
|                                           | Injection molding         |                   |             |
|                                           |                           |                   |             |
|                                           |                           |                   |             |
|                                           |                           |                   |             |
|                                           |                           |                   |             |
|                                           |                           |                   |             |
| Physical                                  | Nominal Value             | Unit              | Test Method |
| Specific Gravity                          | 0.878                     | g/cm <sup>3</sup> | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (230°C/2.16 kg) | 2.5                       | g/10 min          | ASTM D1238  |
| Hardness                                  | Nominal Value             | Unit              | Test Method |
| Durometer Hardness (Shore A, 5 sec)       | 65                        |                   | ASTM D2240  |
| Elastomers                                | Nominal Value             | Unit              | Test Method |
| Tensile Strength (Break)                  | 9.58                      | MPa               | ASTM D412   |
| Tensile Elongation (Break)                | 860                       | %                 | ASTM D412   |
| 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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