

Sarlink® TPE FM-2676B BLK XRD4

(DISCONTINUED)

Thermoplastic Elastomer

Teknor Apex Company

Message:

THIS GRADE IS DISCONTINUED - PLEASE CONTACT YOUR TEKNOR APEX REP FOR MORE INFO

General Information			
Features	Sunlight Resistant		
	Light stabilization		
	Low liquidity		
	Fill		
	Medium density		
	Medium hardness		
	UV absorption		
Uses	Application in Automobile Field		
	Car interior parts		
RoHS Compliance	RoHS compliance		
Appearance	Black		
Forms	Particle		
Processing Method	Extrusion		
	Thermoforming		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.02	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	0.20	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ISO 868
Shore A, 1 second, injection molding	77		ISO 868
Shore A, 5 seconds, injection molding	75		ISO 868
Shore A, 15 seconds, injection molding	74		ISO 868
Mechanical	Nominal Value	Unit	Test Method
Taber Abrasion Resistance			ASTM D1044
1000 Cycles, 1000g, H-18 wheel	6.00	mg	ASTM D1044
2000 Cycles, 1000g, H-18 runner	16.0	mg	ASTM D1044

1000 Cycles, 1000g, H-22 wheel	28.0	mg	ASTM D1044
2000 Cycles, 1000g, H-22 runner	62.0	mg	ASTM D1044
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ¹			ISO 37
Transverse flow: 100% strain	2.38	MPa	ISO 37
Flow: 100% strain	5.28	MPa	ISO 37
Tensile Stress ²			ISO 37
Transverse flow: Fracture	8.76	MPa	ISO 37
Flow: Fracture	5.81	MPa	ISO 37
Tensile Elongation ³			ISO 37
Transverse flow: Fracture	730	%	ISO 37
Flow: Fracture	200	%	ISO 37
Tear Strength ⁴			ISO 34-1
Transverse flow	33	kN/m	ISO 34-1
Flow	39	kN/m	ISO 34-1
Compression Set ⁵			ISO 815
23°C, 22 hr	24	%	ISO 815
70°C, 22 hr	38	%	ISO 815
90°C, 70 hr	53	%	ISO 815
125°C, 70 hr	71	%	ISO 815
Aging	Nominal Value	Unit	Test Method
Change in Tensile Strength in Air ⁶			ISO 188
Transverse flow: 110°C, 1008 hr	-5.7	%	ISO 188
Flow: 110°C, 1008 hr	6.2	%	ISO 188
Transverse flow: 100% strain 110°C, 1008 hr	10	%	ISO 188
Flow: 100% strain 110°C, 1008 hr	13	%	ISO 188
Transverse flow: 125°C, 168 hr	1.3	%	ISO 188
Flow: 125°C, 168 hr	7.2	%	ISO 188
Transverse flow: 100% strain 125°C, 168 hr	12	%	ISO 188
Flow: 100% strain 125°C, 168 hr	14	%	ISO 188
Change in Tensile Strain at Break in Air ⁷			ISO 188
Transverse flow: 110°C, 1008 hr	-1.7	%	ISO 188
Flow: 110°C, 1008 hr	-24	%	ISO 188
Transverse flow: 125°C, 168 hr	-1.4	%	ISO 188
Flow: 125°C, 168 hr	-30	%	ISO 188
Change in Shore Hardness in Air			ISO 188
Shao A, 110°C, 1008 hr ⁸	3.7		ISO 188
Shao A, 110°C, 1008 hr ⁹	3.3		ISO 188
Shao A, 110°C, 1008 hr ¹⁰	2.5		ISO 188
Shao A, 125°C, 168 hr ¹¹	3.8		ISO 188
Shao A, 125°C, 168 hr ¹²	3.3		ISO 188

Shao A, 125°C, 168 hr ¹³	1.7		ISO 188
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (200°C, 206 sec ⁻¹)	313	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 - 66	°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			
NOTE			
1.	Type 1, 510mm/min		
2.	Type 1, 510mm/min		
3.	Type 1, 510mm/min		
4.	B method, right angle specimen (without cut), 510mm/min		
5.	Type a		
6.	Type 1		
7.	Type 1		
8.	15 sec		
9.	5 sec		
10.	1 sec		
11.	15 sec		
12.	5 sec		
13.	1 sec		

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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