

Sarlink® TPV X6765 (PRELIMINARY DATA)

Thermoplastic Vulcanizate

Teknor Apex Company

Message:

SARLINK® TPV X6765 is a high performance thermoplastic vulcanizate used in automotive applications including interior trim. Sarlink TPV X6765 is a medium hardness, low density grade, available in Nat or can be color-matched with good color stability, exhibiting good UV resistance. This grade is designed for injection molding but could also be extruded.

General Information			
Features	Low Specific Gravity		
	Low compressive deformability		
	Low density		
	Light stabilization		
	Good UV resistance		
	Workability, good		
	Good formability		
	Good color stability		
	Good coloring		
	Good adhesion		
	Good chemical resistance		
	Medium hardness		
Uses	Seals		
	Application in Automobile Field		
	Car interior parts		
	Car interior equipment		
	Rubber substitution		
	Profile		
RoHS Compliance	RoHS compliance		
Appearance	Unspecified Color		
	Opacity		
	Available colors		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	0.920	g/cm ³	ISO 1183
Hardness	Nominal Value	Unit	Test Method

Durometer Hardness		ISO 868	
Shore A, 1 second, injection molding	70	ISO 868	
Shore A, 5 seconds, injection molding	68	ISO 868	
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (100% Strain)	2.55	MPa	ISO 37
Tensile Stress (Break)	6.70	MPa	ISO 37
Tensile Elongation (Break)	650	%	ISO 37
Compression Set (70°C, 22 hr)	43	%	ISO 815
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (200°C, 206 sec ⁻¹)	230	Pa · s	ASTM D3835
Legal statement			

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Injection	Nominal Value	Unit
Drying Temperature	82	°C
Drying Time	3.0	hr
Rear Temperature	177 - 216	°C
Middle Temperature	177 - 216	°C
Front Temperature	177 - 216	°C
Nozzle Temperature	188 - 221	°C
Processing (Melt) Temp	182 - 221	°C
Mold Temperature	10 - 66	°C
Back Pressure	0.0689 - 1.03	MPa
Screw Speed	100 - 200	rpm
Screw L/D Ratio	20.0:1.0	
Extrusion	Nominal Value	Unit
Drying Temperature	82	°C
Drying Time	3.0	hr
Cylinder Zone 1 Temp.	182 - 204	°C
Cylinder Zone 2 Temp.	182 - 204	°C
Cylinder Zone 3 Temp.	188 - 210	°C
Cylinder Zone 4 Temp.	188 - 210	°C
Melt Temperature	193 - 216	°C
Die Temperature	193 - 216	°C
Take-Off Roll	21 - 49	°C
Extrusion instructions		

Screen Pack: 20 to 60 meshScrew: 3:1 Compression Ratio

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