Sarlink® TPE ML-1660B BLK X (PRELIMINARY DATA)

Thermoplastic Elastomer

Teknor Apex Company

Message:

Sarlink ML-1660B BLK is a general purpose TPE designed for automotive interior applications. This is a medium hardness, medium density grade suitable for injection molding. This high flow TPE exhibits improved moldability and surface appearance.

General Information			
Features	Sunlight Resistant Medium liquidity Fill Medium density Medium hardness UV absorption		
Uses	Washer Application in Automobile Field Car interior parts General		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	0.990	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	16	g/10 min	ASTM D1238
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness			ISO 868
Shore A, 1 second, injection molding	62		ISO 868
Shore A, 5 seconds, injection molding	60		ISO 868
Shore A, 15 seconds, injection molding	58		ISO 868
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress [1]			ISO 37
Transverse flow: 100% strain	1.63	MPa	ISO 37
Flow: 100% strain	2.24	MPa	ISO 37
Tensile Stress [2]			ISO 37
Transverse flow: Fracture	6.70	MPa	ISO 37

Flow: Fracture	5.80	MPa	ISO 37
Tensile Elongation [3]			ISO 37
Transverse flow: Fracture	860	%	ISO 37
Flow: Fracture	740	%	ISO 37
Tear Strength [4]			ISO 34-1
Transverse flow	23	kN/m	ISO 34-1
Flow	25	kN/m	ISO 34-1
Compression Set [5]			ISO 815
23°C, 22 hr	22	%	ISO 815
70°C, 22 hr	43	%	ISO 815
90°C, 70 hr	65	%	ISO 815
125°C, 70 hr	92	%	ISO 815
Aging	**Nominal Value**	**Unit**	**Test Method**
Change in Tensile Strength in Air [6]			ISO 188
Transverse flow: 110°C, 1008 hr	8.3	%	ISO 188
Flow: 110°C, 1008 hr	6.2	%	ISO 188
Transverse flow: 100% strain 110°C, 1008 hr	3.0	%	ISO 188
Flow: 100% strain 110°C, 1008 hr	9.0	%	ISO 188
Transverse flow: 125°C, 168 hr	12	%	ISO 188
Flow: 125°C, 168 hr	3.6	%	ISO 188
Transverse flow: 100% strain 125°C, 168 hr	5.5	%	ISO 188
Flow: 100% strain 125°C, 168 hr	9.8	%	ISO 188
Change in Tensile Strain at Break in Air [7]			ISO 188
Transverse flow: 110°C, 1008 hr	6.8	%	ISO 188
Flow: 110°C, 1008 hr	6.7	%	ISO 188
Transverse flow: 125°C, 168 hr	9.5	%	ISO 188
Flow: 125°C, 168 hr	7.5	%	ISO 188
Change in Shore Hardness in Air			
Support a, 110°C, 1008 hr [8]	3.4		ISO 188
Support a, 110°C, 1008 hr [9]	4.1		ISO 188
Support a, 110°C, 1008 hr [10]	3.6		ISO 188
Support a, 125°C, 168 hr [11]	4.4		ISO 188
Support a, 125°C, 168 hr [12]	3.8		ISO 188
Fill Analysis	**Nominal Value**	**Unit**	**Test Method**
Apparent Viscosity (200°C, 206 sec^-1)	113	Pa·s	ASTM D3835
Additional Information	**Nominal Value**	**Unit**	**Test Method**
Xenon Weatherometer			SAE J1885
Delta E - 1250 kJ	0.900		SAE J1885
Delta E - 2500 kJ	1.10		SAE J1885
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

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).

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.	5 sec
9.	15 sec
10.	1 sec
11.	15 sec
12.	5 sec

Recommended distributors for this material

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