

# Telcar® TL-2657J BLK

Thermoplastic Elastomer

Teknor Apex Company

## Message:

Telcar TL-2657J BLK is a general purpose thermoplastic elastomer designed for the industrial and transportation markets, including weatherstripping and wind skirts. Telcar TL-2657J BLK is a high hardness, high density, UV stable grade suitable for injection molding and extrusion.

General Information			
Features	Sunlight Resistant		
	High specific gravity		
	High density		
	Light stabilization		
	Good UV resistance		
	Low liquidity		
	Fill		
	High hardness		
Uses	Washer		
	Industrial application		
	Weather-resistant sealing strip		
	General		
	Rubber substitution		
RoHS Compliance	RoHS compliance		
Appearance	Black		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.14	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	5.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A	95		ASTM D2240
Shore D, 1 second, injection molding <sup>1</sup>	46		ASTM D2240
Shore D, 5 seconds, injection molding <sup>2</sup>	45		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus	271	MPa	ASTM D790
Elastomers	Nominal Value	Unit	Test Method

Tensile Stress <sup>3</sup>			ASTM D412
Transverse flow: 100% strain	7.65	MPa	ASTM D412
Flow: 100% strain	9.63	MPa	ASTM D412
Transverse flow: 300% strain	8.57	MPa	ASTM D412
Flow: 300% strain	10.8	MPa	ASTM D412
Tensile Strength <sup>4</sup>			ASTM D412
Transverse flow: Fracture	17.1	MPa	ASTM D412
Flow: Fracture	13.3	MPa	ASTM D412
Tensile Elongation <sup>5</sup>			ASTM D412
Transverse flow: Fracture	700	%	ASTM D412
Flow: Fracture	490	%	ASTM D412
Tear Strength <sup>6</sup>			ASTM D624
Transverse flow	57.3	kN/m	ASTM D624
Flow	73.2	kN/m	ASTM D624
Compression Set <sup>7</sup>			ASTM D395B
23°C, 22 hr	31	%	ASTM D395B
70°C, 22 hr	24	%	ASTM D395B

#### Legal statement

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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 - 66	°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).

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 4 Temp.	177 - 199	°C
Cylinder Zone 5 Temp.	182 - 204	°C
Die Temperature	190 - 210	°C

#### Extrusion instructions

Screw Speed: 30 to 100 rpm

#### NOTE

1.	Aging 24 hr
2.	Aging 24 hr
3.	C mold, 510mm/min
4.	C mold, 510mm/min
5.	C mold, 510mm/min
6.	C mold, 510mm/min
7.	Type 2

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#### Recommended distributors for this material

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