

Sarlink® TPE EE-1250N

Thermoplastic Elastomer

Teknor Apex Company

Message:

Sarlink®TPE EE-1250N 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 method is: extrusion.

Sarlink®The typical application field of TPE EE-1250N is: automobile industry

General Information			
Features	High specific gravity		
	High density		
	smoothness		
	Low liquidity		
	Fill		
	Medium hardness		
Uses	Application in Automobile Field		
	Automotive exterior parts		
	Car exterior decoration		
Appearance	Opacity		
Forms	Particle		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.17	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	0.40	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ISO 868
Shaw A	53		ISO 868
Shaw A, 15 seconds	50		ISO 868
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ISO 37
Transverse flow: 100% strain	1.17	MPa	ISO 37
Flow: 100% strain	1.76	MPa	ISO 37
Tensile Strength			ISO 37
Transverse flow: Fracture	6.86	MPa	ISO 37
Flow: Fracture	4.52	MPa	ISO 37
Tensile Elongation			ISO 37
Transverse flow: Fracture	870	%	ISO 37
Flow: Fracture	690	%	ISO 37

Tear Strength - Across Flow	24.9	kN/m	ISO 34
Compression Set			ISO 815
23°C, 22 hr	15	%	ISO 815
70°C, 22 hr	30	%	ISO 815
125°C, 70 hr	76	%	ISO 815

Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (200°C, 200 sec ⁻¹)	210	Pa·s	ISO 11443

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	35.0 - 65.6	°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

无需干燥.但如果湿度过大,则将粒料在150°F (65°C)的温度下干燥2-4小时.

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

螺杆转速30 - 100 rpm

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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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