

Telcar® TL-3089A XRD (PRELIMINARY DATA)

Thermoplastic Elastomer

Teknor Apex Company

Message:

Telcar TL-3089A XRD is a general purpose thermoplastic elastomer designed for the consumer/industrial market. Telcar TL-3089A XRD is a medium density, medium hardness grade, suitable for both injection molding and extrusion.

General Information	
Features	Low liquidity
	Lubrication
	Fill
	Medium density
	Medium hardness
Uses	Washer
	Washer
	Seals
	General
RoHS Compliance	RoHS compliance
Appearance	Opacity
	Natural color
Forms	Particle
Processing Method	Extrusion
	Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.998	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	4.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A, 1 sec	70		ASTM D2240
Shaw A, 5 seconds	68		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ¹			ASTM D412
Transverse flow: 100% strain	2.97	MPa	ASTM D412
Flow: 100% strain	5.05	MPa	ASTM D412
Transverse flow: 300% strain	4.27	MPa	ASTM D412
Flow: 300% strain	8.39	MPa	ASTM D412

Tensile Strength ²			ASTM D412
Transverse flow: Fracture	14.7	MPa	ASTM D412
Flow: Fracture	13.7	MPa	ASTM D412
Tensile Elongation ³			ASTM D412
Transverse flow: Fracture	850	%	ASTM D412
Flow: Fracture	520	%	ASTM D412
Tear Strength ⁴			ASTM D624
Transverse flow	50.1	kN/m	ASTM D624
Flow	45.0	kN/m	ASTM D624
Compression Set ⁵			ASTM D395B
23°C, 22 hr	14	%	ASTM D395B
70°C, 22 hr	87	%	ASTM D395B

Legal statement

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Injection	Nominal Value	Unit
Rear Temperature	216 - 238	°C
Middle Temperature	216 - 238	°C
Front Temperature	216 - 238	°C
Nozzle Temperature	216 - 238	°C
Processing (Melt) Temp	216 - 238	°C
Mold Temperature	16 - 32	°C
Injection Pressure	1.38 - 5.52	MPa
Back Pressure	0.172 - 0.689	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.	204 - 227	°C
Cylinder Zone 2 Temp.	204 - 227	°C
Cylinder Zone 3 Temp.	204 - 227	°C
Cylinder Zone 4 Temp.	204 - 227	°C
Cylinder Zone 5 Temp.	204 - 227	°C
Die Temperature	204 - 227	°C

Extrusion instructions

Screw Speed: 30 to 100 rpm. Screen Pack Recommendation: 60/200/200/60 to 60/200/400/400/200/60 mesh size.

NOTE

1.	C mold, 510mm/min
2.	C mold, 510mm/min
3.	C mold, 510mm/min
4.	C mold, 510mm/min
5.	Type 1

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