

Telcar® TL-1343A BLK 111

Thermoplastic Elastomer

Teknor Apex Company

Message:

Telcar TL-1343A BLK 111 is a high performance thermoplastic elastomer designed for electrical applications requiring flexibility over a wide temperature range. Telcar TL-1343A BLK 111 is a medium durometer grade that is UV stabilized and RoHS and REACH SVHC compliant. This grade is both injection molding and extrusion.

General Information			
Features	Sunlight Resistant		
	smoothness		
	Light stabilization		
	Low liquidity		
	Fill		
	Medium density		
	Medium hardness		
Uses	Weather-resistant sealing strip		
	General		
Appearance	Black		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.02	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	2.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 second, injection molding	64		ASTM D2240
Shore A, 10 seconds, injection molding	59		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
Transverse flow: 100% strain ¹	2.04	MPa	ASTM D412
Flow: 100% strain ²	3.12	MPa	ASTM D412
Transverse flow: 300% strain ³	3.12	MPa	ASTM D412
Flow: 300% strain ⁴	4.22	MPa	ASTM D412
Tensile Strength ⁵			ASTM D412
Transverse flow: Fracture	6.17	MPa	ASTM D412

Flow: Fracture	5.12	MPa	ASTM D412
Flow: Fracture ⁶	11.5	MPa	ASTM D412
Tensile Elongation ⁷			ASTM D412
Transverse flow: Fracture	560	%	ASTM D412
Flow: Fracture	480	%	ASTM D412
Flow: Fracture ⁸	730	%	ASTM D412
Tear Strength ⁹			ASTM D624
Transverse flow	30.1	kN/m	ASTM D624
Flow	27.0	kN/m	ASTM D624
Compression Set ¹⁰			ASTM D395B
23°C, 22 hr	26	%	ASTM D395B
70°C, 22 hr	49	%	ASTM D395B
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).			
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 5 Temp.	182 - 204	°C	
Die Temperature	190 - 210	°C	
Extrusion instructions			
螺杆转速30 - 100 rpm			
NOTE			
1.	Mouth die C, 510mm/min		
2.	Mouth die C, 510mm/min		
3.	C mold, 510mm/min		
4.	C mold, 510mm/min		
5.	C mold, 510mm/min		
6.	Extruded tape		
7.	Mouth die C, 510mm/min		

8.	Extruded tape
9.	C mold, 510mm/min
10.	Type 1

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