

Sarlink® TPE ML-1670N NAT (PRELIMINARY DATA)

Thermoplastic Elastomer
Teknor Apex Company

Message:

Sarlink ML-1600 series is a high performance, high flow thermoplastic elastomer series, available in NAT and BLK designed for automotive interior applications. Sarlink ML-1670N NAT is a medium hardness, medium density grade with excellent surface appearance suitable for injection molding.

General Information			
Features	Sunlight Resistant		
	Good formability		
	Good flexibility		
	Good tear strength		
	Good adhesion		
	High liquidity		
	Good chemical resistance		
	Good toughness		
	Fill		
	Excellent appearance		
	Elastic		
	Medium density		
	Medium hardness		
Uses	Washer		
	Application in Automobile Field		
	Car interior parts		
	Soft touch application		
	Soft handle		
	Rubber substitution		
	Knob		
RoHS Compliance	RoHS compliance		
Appearance	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	0.990	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	18	g/10 min	ASTM D1238

Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ISO 868
Shore A, 1 second, injection molding	73		ISO 868
Shore A, 5 seconds, injection molding	70		ISO 868
Shore A, 15 seconds, injection molding	68		ISO 868
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ¹			ISO 37
Transverse flow: 100% strain	2.00	MPa	ISO 37
Flow: 100% strain	2.69	MPa	ISO 37
Tensile Stress ²			ISO 37
Transverse flow: Fracture	6.70	MPa	ISO 37
Flow: Fracture	6.20	MPa	ISO 37
Tensile Elongation ³			ISO 37
Transverse flow: Fracture	800	%	ISO 37
Flow: Fracture	700	%	ISO 37
Tear Strength ⁴			ISO 34-1
Transverse flow	26	kN/m	ISO 34-1
Flow	27	kN/m	ISO 34-1
Compression Set ⁵			ISO 815
23°C, 22 hr	27	%	ISO 815
70°C, 22 hr	46	%	ISO 815
90°C, 70 hr	68	%	ISO 815
125°C, 70 hr	93	%	ISO 815
Aging	Nominal Value	Unit	Test Method
Change in Tensile Strength in Air ⁶			ISO 188
Transverse flow: 110°C, 1008 hr	3.3	%	ISO 188
Flow: 110°C, 1008 hr	-3.6	%	ISO 188
Transverse flow: 100% strain 110°C, 1008 hr	9.7	%	ISO 188
Flow: 100% strain 110°C, 1008 hr	13	%	ISO 188
Transverse flow: 125°C, 168 hr	9.8	%	ISO 188
Flow: 125°C, 168 hr	0.0	%	ISO 188
Transverse flow: 100% strain 125°C, 168 hr	5.9	%	ISO 188
Flow: 100% strain 125°C, 168 hr	10	%	ISO 188
Change in Tensile Strain at Break in Air ⁷			ISO 188
Transverse flow: 110°C, 1008 hr	-5.1	%	ISO 188
Flow: 110°C, 1008 hr	-4.8	%	ISO 188
Transverse flow: 125°C, 168 hr	11	%	ISO 188
Flow: 125°C, 168 hr	7.2	%	ISO 188
Change in Shore Hardness in Air			ISO 188
Shao A, 110°C, 1008 hr ⁸	3.6		ISO 188
Shao A, 110°C, 1008 hr ⁹	3.1		ISO 188

Shao A, 110°C, 1008 hr ¹⁰	2.9	ISO 188
Shao A, 125°C, 168 hr ¹¹	3.3	ISO 188
Shao A, 125°C, 168 hr ¹²	2.7	ISO 188
Shao A, 125°C, 168 hr ¹³	1.8	ISO 188

Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (200°C, 206 sec ⁻¹)	111	Pa·s	ASTM D3835

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).

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.	15 sec
9.	5 sec
10.	1 sec
11.	15 sec
12.	5 sec
13.	1 sec

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