

Elexar® EL-3707-84

Thermoplastic Elastomer

Teknor Apex Company

Message:

Elexar® EL-3707-84 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 or injection molding.

Typical application areas include:

Wire and cable

Electrical/electronic applications

General Information			
Uses	Underground cable		
	Cable sheath		
	Electrical wire sheath material		
	Electrical conductor insulation material		
	Wire and cable applications		
	Wire sheath		
	Industrial cable insulation material		
	Connector		
	cord sheath		
	Terminal cable sheath material		
Appearance	Opacity		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.888	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	1.5	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	84		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength (Break)	17.2	MPa	ASTM D412
Tensile Elongation (Break)	680	%	ASTM D412
Thermal	Nominal Value	Unit	Test Method
Continuous Use Temperature	105	°C	UL 1581
Brittleness Temperature	-60.0	°C	ASTM D746
Flammability	Nominal Value	Unit	Test Method
Oxygen Index	18	%	ASTM D2863
Injection	Nominal Value	Unit	

Rear Temperature	199 - 216	°C
Middle Temperature	213 - 221	°C
Front Temperature	221 - 227	°C
Nozzle Temperature	221 - 229	°C
Processing (Melt) Temp	221 - 229	°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

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 - 210	°C
Cylinder Zone 2 Temp.	199 - 216	°C
Cylinder Zone 3 Temp.	213 - 221	°C
Cylinder Zone 5 Temp.	221 - 227	°C
Die Temperature	221 - 229	°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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