

Elexar® EL-1402F

Thermoplastic Elastomer

Teknor Apex Company

Message:

Elexar® EL-1402F 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. Elexar® The main characteristics of the EL-1402F are: flame retardant/rated flame. Elexar® Typical application fields of EL-1402F are: electrical/electronic applications

General Information			
Uses	Connector		
Appearance	Opacity		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.09	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	9.0	g/10 min	ASTM D1238

Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	63		ASTM D2240

Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
100% strain	1.24	MPa	ASTM D412
300% strain	1.79	MPa	ASTM D412
Tensile Strength (Break)	4.27	MPa	ASTM D412
Tensile Elongation (Break)	670	%	ASTM D412
Tear Strength ¹	19.3	kN/m	ASTM D624

Flammability	Nominal Value	Test Method
Flame Rating (3.18 mm)	V-0	UL 94

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		
NOTE		

1.	C mould
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