

Telcar® TL-2522C

Thermoplastic Elastomer

Teknor Apex Company

Message:

Telcar TL-2522C is a general purpose thermoplastic elastomer designed for the industrial market. Telcar TL-2522C is a low hardness, low density grade suitable for injection molding.

General Information			
Features	Low Specific Gravity		
	Without Fillers		
	Low density		
	smoothness		
	Medium liquidity		
	Hardness, low		
Uses	Safety equipment		
	Handle		
	Soft handle		
	General		
	Toys		
	Consumer goods application field		
Appearance	Translucent		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.888	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	2.7	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 second, injection molding	45		ASTM D2240
Shore A, 5 seconds, injection molding	43		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
Transverse flow: 100% strain ¹	2.80	MPa	ASTM D412
Flow: 100% strain ²	3.67	MPa	ASTM D412
Transverse flow: 300% strain ³	3.76	MPa	ASTM D412
Tensile Strength ⁴			ASTM D412
Transverse flow: Fracture	4.63	MPa	ASTM D412
Flow: Fracture	4.16	MPa	ASTM D412

Tensile Elongation ⁵			ASTM D412
Transverse flow: Fracture	440	%	ASTM D412
Flow: Fracture	220	%	ASTM D412
Tear Strength ⁶			ASTM D624
Transverse flow	35.0	kN/m	ASTM D624
Flow	24.7	kN/m	ASTM D624
Compression Set ⁷			ASTM D395B
23°C, 22 hr	24	%	ASTM D395B
70°C, 22 hr	43	%	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

Screw Speed: 30 to 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. Mouth die C, 510mm/min
6. C mold, 510mm/min
7. Type 1

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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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