

Telcar® TL-1444A

Thermoplastic Elastomer

Teknor Apex Company

Message:

Telcar®TL-1444A 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:

Automotive Industry
engineering/industrial accessories

General Information			
Uses	Blow molding applications		
	Washer		
	Weather-resistant sealing strip		
	Application in Automobile Field		
	Car interior parts		
	Automotive exterior parts		
	Car exterior decoration		
	General		
Appearance	Opacity		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.978	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	19	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	37		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus	201	MPa	ASTM D790
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (100% Strain)	8.69	MPa	ASTM D412
Tensile Strength (Break)	19.9	MPa	ASTM D412
Tensile Elongation (Break)	640	%	ASTM D412
Injection	Nominal Value	Unit	
Rear Temperature	199 - 210	°C	
Middle Temperature	204 - 216	°C	
Front Temperature	210 - 221	°C	
Nozzle Temperature	216 - 227	°C	

Processing (Melt) Temp	216 - 227	°C
Mold Temperature	35.0 - 65.6	°C
Injection Pressure	1.38 - 6.89	MPa
Injection Rate	Fast	
Back Pressure	0.172 - 0.862	MPa
Screw Speed	50 - 120	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 - 204	°C
Cylinder Zone 2 Temp.	199 - 210	°C
Cylinder Zone 3 Temp.	204 - 216	°C
Cylinder Zone 5 Temp.	210 - 221	°C
Die Temperature	216 - 227	°C

Extrusion instructions

螺杆转速30 - 100 rpm

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