

Telcar® TL-6800-73

Thermoplastic Elastomer

Teknor Apex Company

Message:

Telcar®TL-6800-73 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	Translucent		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.938	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	1.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A	79		ASTM D2240
Shaw A, 5 seconds	73		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (100% Strain)	3.93	MPa	ASTM D412
Tensile Strength (Break)	6.76	MPa	ASTM D412
Tensile Elongation (Break)	340	%	ASTM D412
Tear Strength	29.8	kN/m	ASTM D624
Compression Set			ASTM D395
23°C	27	%	ASTM D395
100°C	45	%	ASTM D395
Injection	Nominal Value	Unit	

Rear Temperature	171 - 216	°C
Middle Temperature	177 - 216	°C
Front Temperature	182 - 221	°C
Nozzle Temperature	188 - 227	°C
Processing (Melt) Temp	188 - 227	°C
Mold Temperature	35.0 - 60.0	°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
Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	166 - 204	°C
Cylinder Zone 2 Temp.	171 - 210	°C
Cylinder Zone 3 Temp.	177 - 216	°C
Cylinder Zone 5 Temp.	182 - 221	°C
Die Temperature	190 - 227	°C
Extrusion instructions		

螺杆转速30 - 100 rpm

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