

Telcar® TL-2450F

Thermoplastic Elastomer

Teknor Apex Company

Message:

Telcar TL-2450F is a general purpose, medium density thermoplastic elastomer designed for injection molding applications.

General Information			
Features	Oil-filled		
	Good coloring		
	High liquidity		
	Fill		
	General		
	Hardness, low		
	Medium density		
Uses	Washer		
	Industrial components		
	Industrial application		
	General		
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) (190°C/2.16 kg)	16	g/10 min	ASTM D1238
Molding Shrinkage			ISO 294-4
Vertical flow direction	1.2	%	ISO 294-4
Flow direction	1.1	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A, 1 sec	44		ASTM D2240
Shaw A, 15 seconds	48		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
100% strain	1.38	MPa	ASTM D412
300% strain	2.07	MPa	ASTM D412
Tensile Strength (Break)	6.38	MPa	ASTM D412

Tensile Elongation (Break)	800	%	ASTM D412
Tear Strength			ASTM D624
Transverse flow	20.5	kN/m	ASTM D624
Flow	20.3	kN/m	ASTM D624
Compression Set ¹			ASTM D395B
23°C, 22 hr	25	%	ASTM D395B
70°C, 22 hr	49	%	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	
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.	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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