

# Trexlink™ 4780

Thermoplastic Elastomer

Mitsubishi Chemical Performance Polymers, Inc.

## Message:

Trexlink™ 4780 is a highly engineered Thermoplastic Elastomer for use in applications requiring integrally colored material. This material is UV stabilized and can be pre-colored in most Automotive Interior or other colors. It can be easily processed by injection molding, blow molding or extrusion. Applications include critical color matched Automotive components such cup holders, mats, seals, soft seat trim. Also works well for two-shot molding or over-mold components such as grips and handles.

General Information	
Additive	UV stabilizer
Features	Good UV resistance
	Workability, good
	Good coloring
Uses	Handle
	overmolding
	Seals
	Car interior parts
	Car interior equipment
	Soft handle
	Seat
Appearance	Available colors
Forms	Particle
Processing Method	Blow molding
	Extrusion
	Injection molding

Physical	Nominal Value	Unit	Test Method
Density	0.950	g/cm <sup>3</sup>	ISO 1183
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 5 sec, Injection Molded)	82		ISO 868
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress - Across Flow <sup>1</sup> (100% Strain)	3.90	MPa	ISO 37
Tensile Stress - Across Flow <sup>2</sup> (Yield)	8.50	MPa	ISO 37
Tensile Elongation - Across Flow <sup>3</sup> (Break)	720	%	ISO 37
Tear Strength - Across Flow <sup>4</sup>	35	kN/m	ISO 34-1
Compression Set <sup>5</sup> (70°C, 22 hr)	43	%	ISO 815
Aging	Nominal Value	Unit	Test Method

Change in Tensile Strength in Air <sup>6</sup> (135°C, 1000 hr)	7.0	%	ISO 188
Change in Tensile Strain at Break in Air <sup>7</sup> (135°C, 1000 hr)	-2.0	%	ISO 188
Additional Information			
Change in Color, SAE J1885, 1240.8kJ/m <sup>2</sup> exposure: <3.0 delta E			
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	3.0	hr	
Rear Temperature	177 - 216	°C	
Middle Temperature	177 - 216	°C	
Front Temperature	177 - 216	°C	
Nozzle Temperature	188 - 221	°C	
Processing (Melt) Temp	182 - 221	°C	
Mold Temperature	10.0 - 65.6	°C	
Back Pressure	0.0689 - 1.03	MPa	
Screw Speed	100 - 200	rpm	
Screw L/D Ratio	20.0:1.0		
Extrusion	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	3.0	hr	
Cylinder Zone 1 Temp.	182 - 204	°C	
Cylinder Zone 2 Temp.	182 - 204	°C	
Cylinder Zone 3 Temp.	188 - 210	°C	
Cylinder Zone 4 Temp.	188 - 210	°C	
Melt Temperature	193 - 216	°C	
Die Temperature	193 - 216	°C	
Take-Off Roll	21.1 - 48.9	°C	
Extrusion instructions			
Screen Pack: 20 to 60 meshScrew: general purpose 3 to 1 compression ratio			
NOTE			
1.	Type 1		
2.	Type 1		
3.	Type 1		
4.	Method B, right-angle specimen (cut)		
5.	Type a		
6.	Method B		
7.	Method B		

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