

# Elexar® EL-1402E

Thermoplastic Elastomer

Teknor Apex Company

## Message:

Elexar® EL-1402E 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. Elexar® The main characteristics of the EL-1402E are: flame retardant/rated flame. Elexar® Typical application fields of EL-1402E are: electrical/electronic applications

| General Information |                   |  |  |
|---------------------|-------------------|--|--|
| Uses                | Connector         |  |  |
| Appearance          | Opacity           |  |  |
| Forms               | Particle          |  |  |
| Processing Method   | Extrusion         |  |  |
|                     | Injection molding |  |  |

| Physical                                 | Nominal Value | Unit              | Test Method |
|------------------------------------------|---------------|-------------------|-------------|
| Specific Gravity                         | 1.09          | g/cm <sup>3</sup> | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (200°C/5.0 kg) | 11            | g/10 min          | ASTM D1238  |

| Hardness                     | Nominal Value | Unit | Test Method |
|------------------------------|---------------|------|-------------|
| Durometer Hardness (Shore A) | 60            |      | ASTM D2240  |

| Elastomers                 | Nominal Value | Unit | Test Method |
|----------------------------|---------------|------|-------------|
| Tensile Stress             |               |      | ASTM D412   |
| 100% strain                | 1.24          | MPa  | ASTM D412   |
| 300% strain                | 1.65          | MPa  | ASTM D412   |
| Tensile Strength (Break)   | 3.31          | MPa  | ASTM D412   |
| Tensile Elongation (Break) | 770           | %    | ASTM D412   |
| Tear Strength              | 14.9          | kN/m | ASTM D624   |

| Flammability           | Nominal Value | Test Method |
|------------------------|---------------|-------------|
| Flame Rating (3.18 mm) | V-0           | UL 94       |

| Injection              | Nominal Value | Unit |
|------------------------|---------------|------|
| Rear Temperature       | 171 - 177     | °C   |
| Middle Temperature     | 177 - 182     | °C   |
| Front Temperature      | 182 - 188     | °C   |
| Nozzle Temperature     | 188 - 193     | °C   |
| Processing (Melt) Temp | 188 - 193     | °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

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 |
|-----------------------|---------------|------|
| Drying Temperature    | 80.0          | °C   |
| Drying Time           | 1.0 - 2.0     | hr   |
| Cylinder Zone 1 Temp. | 171 - 177     | °C   |
| Cylinder Zone 2 Temp. | 177 - 182     | °C   |
| Cylinder Zone 3 Temp. | 182 - 188     | °C   |
| Cylinder Zone 5 Temp. | 188 - 193     | °C   |
| Melt Temperature      | 193 - 196     | °C   |
| Die Temperature       | 121 - 177     | °C   |

#### Extrusion instructions

螺杆转速30 - 100 rpm

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#### Recommended distributors for this material

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