

Sarlink® TPE EE-2250N NAT

Thermoplastic Elastomer

Teknor Apex Company

Message:

The Sarlink EE-2200 series UV Resistant extrusion grades suitable for automotive exterior applications.

General Information			
Additive	UV stabilizer		
Features	High density		
Uses	Application in Automobile Field		
Appearance	Natural color		
Forms	Particle		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.17	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	0.40	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ISO 868
Shaw A	53		ISO 868
Shaw A, 15 seconds	50		ISO 868
Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus	10.0	MPa	ASTM D790
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ISO 37
Transverse flow: 100% strain	1.17	MPa	ISO 37
Flow: 100% strain	1.76	MPa	ISO 37
Tensile Stress			ISO 37
Transverse flow: Fracture	6.86	MPa	ISO 37
Flow: Fracture	4.52	MPa	ISO 37
Tensile Elongation			ISO 37
Transverse flow: Fracture	870	%	ISO 37
Flow: Fracture	690	%	ISO 37
Tear Strength - Across Flow	25	kN/m	ISO 34-1
Compression Set			ISO 815
23°C, 22 hr	15	%	ISO 815
70°C, 22 hr	30	%	ISO 815
125°C, 70 hr	76	%	ISO 815
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (200°C, 206 sec ⁻¹)	210	Pa · s	ASTM D3835

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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