

Sarlink® TPE ML-2355B

Thermoplastic Elastomer

Teknor Apex Company

Message:

Sarlink ML-2355B is a UV resistant TPE suitable for automotive interior injection molding applications.

General Information			
Uses	Application in Automobile Field Car interior parts		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.07	g/cm ³	ISO 1183
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 5 sec, Injection Molded)	55		ISO 868
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress - Across Flow (100% Strain)	1.20	MPa	ISO 37
Tensile Strength - Across Flow (Break)	7.80	MPa	ISO 37
Tensile Elongation - Across Flow (Break)	850	%	ISO 37
Compression Set (70°C, 22 hr)	40	%	ISO 815
Additional Information	Nominal Value	Unit	Test Method
Apparent Shear Viscosity - Capillary, 206 1/s (200°C)	168	Pa · s	ISO 11443
Injection	Nominal Value	Unit	
Rear Temperature	170 - 180	°C	
Middle Temperature	180 - 200	°C	
Front Temperature	200 - 220	°C	
Nozzle Temperature	210 - 230	°C	
Processing (Melt) Temp	200 - 230	°C	
Mold Temperature	10.0 - 60.0	°C	
Injection Pressure	6.00 - 12.0	MPa	
Injection Rate	Fast		
Holding Pressure	4.00 - 6.00	MPa	
Back Pressure	0.500 - 2.00	MPa	
Screw Speed	50 - 120	rpm	
Injection instructions			

Drying is not necessary. However, if moisture is a problem, dry the pellets 2 to 4 hours at 65 degrees Celsius.
Time Settings
Injection Time: 0.5-2 seconds
Holding Time: 1-10 seconds
Cooling Time: As short as possible. The parts should be removable without deformation or piercing of the ejector(s)

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