

Sarlink® TPV 2774N XRD1

Thermoplastic Vulcanizate

Teknor Apex Company

Message:

Sarlink 2774 is a high performance thermoplastic vulcanizate used in automotive applications. Sarlink 2774 is a medium hardness lubricated grade exhibiting sunlight resistance and UV absorbing characteristics. This grade can be processed by injection molding and extrusion.

General Information			
Features	Low Specific Gravity		
	Sunlight Resistant		
	Low density		
	smoothness		
	Light stabilization		
	Low liquidity		
	Lubrication		
	Fill		
	Medium hardness		
	UV absorption		
Uses	Car interior parts		
	Car interior equipment		
	Car exterior decoration		
Appearance	Opacity		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	0.960	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	0.30	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ISO 868
Shore A, 1 second, injection molding	75		ISO 868
Shore A, 5 seconds, injection molding	71		ISO 868
Shore A, 15 seconds, injection molding	69		ISO 868
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ¹			ISO 37
Transverse flow: 100% strain	2.34	MPa	ISO 37
Flow: 100% strain	3.84	MPa	ISO 37

Tensile Stress ²			ISO 37
Transverse flow: Fracture	5.50	MPa	ISO 37
Flow: Fracture	4.60	MPa	ISO 37
Tensile Elongation ³			ISO 37
Transverse flow: Fracture	450	%	ISO 37
Flow: Fracture	210	%	ISO 37
Tear Strength ⁴			ISO 34-1
Transverse flow	24	kN/m	ISO 34-1
Flow	25	kN/m	ISO 34-1
Compression Set ⁵			ISO 815
23°C, 22 hr	20	%	ISO 815
70°C, 22 hr	32	%	ISO 815
90°C, 70 hr	37	%	ISO 815
125°C, 70 hr	49	%	ISO 815
Aging	Nominal Value	Unit	Test Method
Change in Tensile Strength in Air ⁶			ISO 188
Transverse flow: 110°C, 1008 hr	2.0	%	ISO 188
Flow: 110°C, 1008 hr	0.40	%	ISO 188
Transverse flow: 100% strain 110°C, 1008 hr	10	%	ISO 188
Flow: 100% strain 110°C, 1008 hr	8.8	%	ISO 188
Transverse flow: 125°C, 168 hr	5.5	%	ISO 188
Flow: 125°C, 168 hr	2.2	%	ISO 188
Transverse flow: 100% strain 125°C, 168 hr	11	%	ISO 188
Flow: 100% strain 125°C, 168 hr	9.1	%	ISO 188
Change in Tensile Strain at Break in Air ⁷			ISO 188
Transverse flow: 110°C, 1008 hr	-5.4	%	ISO 188
Flow: 110°C, 1008 hr	-17	%	ISO 188
Transverse flow: 125°C, 168 hr	-4.5	%	ISO 188
Flow: 125°C, 168 hr	-20	%	ISO 188
Change in Shore Hardness in Air			ISO 188
Support a, 110°C, 1008 hr ⁸	1.7		ISO 188
Support a, 110°C, 1008 hr ⁹	2.9		ISO 188
Support a, 110°C, 1008 hr ¹⁰	3.1		ISO 188
Support a, 125°C, 168 hr ¹¹	1.7		ISO 188
Support a, 125°C, 168 hr ¹²	2.5		ISO 188
Support a, 125°C, 168 hr ¹³	2.9		ISO 188
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (200°C, 206 sec ⁻¹)	330	Pa · s	ASTM D3835
Legal statement			

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Injection	Nominal Value	Unit
Rear Temperature	173 - 213	°C
Middle Temperature	179 - 219	°C
Front Temperature	184 - 224	°C
Nozzle Temperature	190 - 230	°C
Processing (Melt) Temp	190 - 230	°C
Mold Temperature	35.0 - 60.0	°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

Drying is not necessary. However, if moisture is a problem, dry the pellets for 2 to 4 hours at 150°F (65°C).

Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	166 - 204	°C
Cylinder Zone 2 Temp.	171 - 210	°C
Cylinder Zone 3 Temp.	177 - 216	°C
Cylinder Zone 5 Temp.	182 - 221	°C
Die Temperature	190 - 227	°C

Extrusion instructions

螺杆转速30 - 100 rpm

NOTE	
1.	Type 1, 510mm/min
2.	Type 1, 510mm/min
3.	Type 1, 510mm/min
4.	B method, right angle specimen (without cut), 510mm/min
5.	Type a
6.	Type 1
7.	Type 1
8.	1 sec
9.	5 sec
10.	15 sec
11.	1 sec
12.	5 sec
13.	15 sec

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