

Telcar® TL-4129

Thermoplastic Elastomer

Teknor Apex Company

Message:

Telcar TL-4129 is a low density thermoplastic elastomer designed for the industrial market. Telcar TL-4129 is a clear TPE that is UV stable and is suitable for injection molding and extrusion.

General Information			
Features	Low Specific Gravity		
	Sunlight Resistant		
	Without Fillers		
	Low density		
	smoothness		
	Light stabilization		
	Low liquidity		
	Lubrication		
	Medium hardness		
	UV absorption		
Uses	Industrial application		
	Weather-resistant sealing strip		
	General		
Appearance	Clear/transparent		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.888	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	4.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 second, injection molding	65		ASTM D2240
Shore A, 5 seconds, injection molding	63		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
Transverse flow: 100% strain ¹	2.08	MPa	ASTM D412
Flow: 100% strain ²	2.93	MPa	ASTM D412
Transverse flow: 300% strain ³	3.46	MPa	ASTM D412

Flow: 300% strain ⁴	4.34	MPa	ASTM D412
Tensile Strength ⁵			ASTM D412
Transverse flow: Fracture	9.60	MPa	ASTM D412
Flow: Fracture	5.93	MPa	ASTM D412
Tensile Elongation ⁶			ASTM D412
Transverse flow: Fracture	710	%	ASTM D412
Flow: Fracture	490	%	ASTM D412
Tear Strength ⁷			ASTM D624
Transverse flow	37.1	kN/m	ASTM D624
Flow	30.1	kN/m	ASTM D624
Compression Set ⁸			ASTM D395B
23°C, 22 hr	18	%	ASTM D395B
70°C, 22 hr	87	%	ASTM D395B

Legal statement

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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

NOTE	
1.	Mouth die C, 510mm/min
2.	Mouth die C, 510mm/min
3.	C mold, 510mm/min
4.	C mold, 510mm/min
5.	C mold, 510mm/min
6.	Mouth die C, 510mm/min
7.	C mold, 510mm/min
8.	Type 1

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