

Sarlink® TPE ME-2245B BLK X (PRELIMINARY DATA)

Thermoplastic Elastomer

Teknor Apex Company

Message:

Sarlink ME-2255B BLK X is a low density TPE designed for automotive exterior applications. This is a UV stabilized grade suitable for injection molding.

General Information			
Features	Low Specific Gravity Sunlight Resistant Low density smoothness Light stabilization Low liquidity Lubrication Fill Hardness, low UV absorption		
Uses	Application in Automobile Field Automotive exterior parts Car exterior decoration		
Appearance	Black		
Forms	Particle		
Processing Method	Extrusion Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	0.925	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	0.50	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ISO 868
Shore A, 1 second, injection molding	49		ISO 868
Shore A, 5 seconds, injection molding	46		ISO 868
Shore A, 15 seconds, injection molding	44		ISO 868
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ¹			ISO 37

Transverse flow: 100% strain	1.02	MPa	ISO 37
Flow: 100% strain	1.58	MPa	ISO 37
Tensile Stress ²			ISO 37
Transverse flow: Fracture	6.80	MPa	ISO 37
Flow: Fracture	3.30	MPa	ISO 37
Tensile Elongation ³			ISO 37
Transverse flow: Fracture	840	%	ISO 37
Flow: Fracture	540	%	ISO 37
Tear Strength ⁴			ISO 34-1
Transverse flow	18	kN/m	ISO 34-1
Flow	22	kN/m	ISO 34-1
Compression Set ⁵			ISO 815
23°C, 22 hr	14	%	ISO 815
70°C, 22 hr	34	%	ISO 815
90°C, 70 hr	57	%	ISO 815
125°C, 70 hr	75	%	ISO 815
Aging	Nominal Value	Unit	Test Method
Change in Tensile Strength in Air ⁶			ISO 188
Transverse flow: 110°C, 1008 hr	34	%	ISO 188
Flow: 110°C, 1008 hr	67	%	ISO 188
Transverse flow: 100% strain 110°C, 1008 hr	5.9	%	ISO 188
Flow: 100% strain 110°C, 1008 hr	5.7	%	ISO 188
Transverse flow: 125°C, 168 hr	31	%	ISO 188
Flow: 125°C, 168 hr	52	%	ISO 188
Transverse flow: 100% strain 125°C, 168 hr	2.9	%	ISO 188
Flow: 100% strain 125°C, 168 hr	0.0	%	ISO 188
Change in Tensile Strain at Break in Air ⁷			ISO 188
Transverse flow: 110°C, 1008 hr	7.0	%	ISO 188
Flow: 110°C, 1008 hr	33	%	ISO 188
Transverse flow: 125°C, 168 hr	7.7	%	ISO 188
Flow: 125°C, 168 hr	40	%	ISO 188
Change in Shore Hardness in Air			
Support a, 110°C, 1008 hr ⁸	1.1		ISO 188
Support a, 110°C, 1008 hr ⁹	1.6		ISO 188
Support a, 110°C, 1008 hr ¹⁰	1.5		ISO 188
Support a, 125°C, 168 hr ¹¹	0.60		ISO 188
Support a, 125°C, 168 hr ¹²	0.90		ISO 188
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (200°C, 206 sec ⁻¹)	234	Pa · s	ASTM D3835
Additional Information	Nominal Value	Unit	Test Method
Xenon Weatherometer			SAE J2527

Delta E - 1250 kJ	0.600	SAE J2527
Delta E - 2500 kJ	0.350	SAE J2527

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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

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.	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

Screw Speed: 30 to 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.	5 sec
9.	1 sec
10.	15 sec

11. 1 sec

12. 15 sec

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