

Telcar® TL-2530F

Thermoplastic Elastomer

Teknor Apex Company

Message:

Telcar TL-2530F is a general purpose, high density thermoplastic elastomer designed for injection molding applications.

General Information			
Features	Oil-filled		
	High specific gravity		
	High density		
	Good coloring		
	High liquidity		
	Fill		
	General		
	Hardness, low		
Uses	Washer		
	Industrial components		
	Industrial application		
	General		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.18	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	0.50	g/10 min	ASTM D1238
Molding Shrinkage			ISO 294-4
Vertical flow direction	1.2	%	ISO 294-4
Flow direction	1.7	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A, 1 sec	32		ASTM D2240
Shaw A, 5 seconds	30		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength (Break)	3.45	MPa	ASTM D412
Tensile Elongation (Break)	780	%	ASTM D412
Tear Strength ¹			ASTM D624

Transverse flow	14.0	kN/m	ASTM D624
Flow	16.6	kN/m	ASTM D624
Compression Set			ISO 815
23°C, 22 hr	12	%	ISO 815
70°C, 22 hr	41	%	ISO 815

Injection	Nominal Value	Unit
Rear Temperature	171 - 193	°C
Middle Temperature	177 - 199	°C
Front Temperature	182 - 204	°C
Nozzle Temperature	188 - 210	°C
Processing (Melt) Temp	188 - 210	°C
Mold Temperature	25.0 - 65.6	°C
Injection Pressure	1.38 - 6.89	MPa
Injection Rate	Moderate-Fast	
Back Pressure	0.172 - 0.345	MPa
Screw Speed	50 - 100	rpm
Cushion	3.81 - 25.4	mm

Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	166 - 188	°C
Cylinder Zone 2 Temp.	171 - 193	°C
Cylinder Zone 3 Temp.	177 - 199	°C
Cylinder Zone 5 Temp.	182 - 204	°C
Die Temperature	190 - 210	°C

Extrusion instructions

螺杆转速30 - 100 rpm

NOTE

1. C mold, 510mm/min

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