

# Telcar® OBC 4864A

Thermoplastic Elastomer

Teknor Apex Company

## Message:

Telcar®OBC 4864A is a thermoplastic elastomer (TPE) material. This product is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific. The processing method is extrusion or injection molding.

Typical application areas include:

Automotive Industry  
engineering/industrial accessories

| General Information                 |                                 |                   |             |
|-------------------------------------|---------------------------------|-------------------|-------------|
| Uses                                | Blow molding applications       |                   |             |
|                                     | Washer                          |                   |             |
|                                     | Weather-resistant sealing strip |                   |             |
|                                     | Application in Automobile Field |                   |             |
|                                     | Car interior parts              |                   |             |
|                                     | Automotive exterior parts       |                   |             |
|                                     | Car exterior decoration         |                   |             |
|                                     | General                         |                   |             |
| Appearance                          | Opacity                         |                   |             |
| Forms                               | Particle                        |                   |             |
| Processing Method                   | Extrusion                       |                   |             |
|                                     | Injection molding               |                   |             |
| Physical                            | Nominal Value                   | Unit              | Test Method |
| Specific Gravity                    | 1.02                            | g/cm <sup>3</sup> | ASTM D792   |
| Melt Mass-Flow Rate (MFR)           | 0.90                            | g/10 min          | ASTM D1238  |
| Hardness                            | Nominal Value                   | Unit              | Test Method |
| Durometer Hardness (Shore A, 5 sec) | 66                              |                   | ASTM D2240  |
| Elastomers                          | Nominal Value                   | Unit              | Test Method |
| Tensile Strength (Break)            | 6.89                            | MPa               | ASTM D412   |
| Tensile Elongation (Break)          | 790                             | %                 | ASTM D412   |
| Compression Set (70°C, 22 hr)       | 48                              | %                 | ASTM D395   |
| 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

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