

Telcar® TL-355

Thermoplastic Elastomer

Teknor Apex Company

Message:

TL-355 is a general purpose thermoplastic elastomer designed for the industrial market and is suitable for injection molding and extrusion.

General Information	
Features	Low Specific Gravity
	Low density
	Medium liquidity
	Fill
	High hardness
	Moderate smoothness
Uses	Blow molding applications
	Washer
	General
Appearance	Natural color
Forms	Particle
Processing Method	Extrusion
	Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.938	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	9.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore D, 1 second, injection molding	44		ASTM D2240
Shore D, 5 seconds, injection molding	42		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ¹			ASTM D412
Transverse flow: 100% strain	12.0	MPa	ASTM D412
Flow: 100% strain	13.7	MPa	ASTM D412
Tensile Strength ²			ASTM D412
Transverse flow: Fracture	12.1	MPa	ASTM D412
Flow: Fracture	14.0	MPa	ASTM D412
Tensile Elongation ³			ASTM D412
Transverse flow: Fracture	180	%	ASTM D412

Flow: Fracture	220	%	ASTM D412
Tear Strength ⁴			ASTM D624
Transverse flow	79.2	kN/m	ASTM D624
Flow	90.2	kN/m	ASTM D624
Compression Set ⁵			ASTM D395B
23°C, 22 hr	41	%	ASTM D395B
70°C, 22 hr	79	%	ASTM D395B

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

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 - 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. Mouth die C, 510mm/min
2. C mold, 510mm/min
3. Mouth die C, 510mm/min
4. C mold, 510mm/min
5. Type 1

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