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TEKNOR APEX

Sarlink® TPE FM-2676 (PRELIMINARY DATA)

Teknor Apex Company - Thermoplastic Elastomer

General Information

Product Description

Sarlink FM-2676 is a general purpose thermoplastic elastomer, available in NAT, BLK, and colors, designed for automotive interior applications, including floor mats. Sarlink FM-2676 is a medium hardness, high density, filled grade suitable for extrusion and thermoforming.

General

Material Status	• Preliminary Data		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Chemical Resistant • Filled • Good Adhesion • Good Colorability • Good Flexibility	• Good Processability • Good Tear Strength • Good Toughness • Low Flow • Medium Density	• Medium Hardness • Wear Resistant • Weather Resistant
Uses	• Automotive Applications • Automotive Interior Parts	• Rubber Replacement • Thermoforming Applications	
RoHS Compliance	• RoHS Compliant		
Appearance	• Colors Available	• Natural Color	
Forms	• Pellets		
Processing Method	• Extrusion	• Thermoforming	

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.10	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	0.40	g/10 min	ASTM D1238
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress [2]			ISO 37
Across Flow : 100% Strain	367	psi	
Flow : 100% Strain	544	psi	
Tensile Stress [2]			ISO 37
Across Flow : Break	1330	psi	
Flow : Break	914	psi	
Tensile Elongation [2]			ISO 37
Across Flow : Break	970	%	
Flow : Break	460	%	
Tear Strength [3]			ISO 34-1
Across Flow	260	lbf/in	
Flow	250	lbf/in	
Compression Set [4]			ISO 815
73°F, 22 hr	22	%	
158°F, 22 hr	37	%	
194°F, 70 hr	61	%	
Hardness	**Nominal Value**	**Unit**	**Test Method**
Shore Hardness			ISO 868
Shore A, 1 sec, Injection Molded	79		
Shore A, 5 sec, Injection Molded	77		
Shore A, 15 sec, Injection Molded	75		

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Aging	Nominal Value	Unit	Test Method
Change in Tensile Strength in Air [5]			ISO 188
Across Flow : 230°F, 1008 hr	-1.9	%	
Flow : 230°F, 1008 hr	10	%	
Across Flow : 100% Strain 230°F, 1008 hr	13	%	
Flow : 100% Strain 230°F, 1008 hr	-2.6	%	
Change in Tensile Strain at Break in Air [5]			ISO 188
Across Flow : 230°F, 1008 hr	-3.5	%	
Flow : 230°F, 1008 hr	14	%	
Change in Shore Hardness in Air			ISO 188
Shore A, 230°F, 1008 hr [6]	-0.50		
Shore A, 230°F, 1008 hr [7]	-0.40		
Shore A, 230°F, 1008 hr [8]	-0.40		

Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (392°F, 206 sec^-1)	617	Pa·s	ASTM D3835

Processing Information

Injection	Nominal Value	Unit
Rear Temperature	440 to 480	°F
Middle Temperature	440 to 480	°F
Front Temperature	440 to 480	°F
Nozzle Temperature	440 to 480	°F
Processing (Melt) Temp	440 to 480	°F
Mold Temperature	60 to 90	°F
Injection Pressure	200 to 1000	psi
Injection Rate	Fast	
Back Pressure	25.0 to 125	psi
Screw Speed	50 to 120	rpm
Cushion	0.150 to 1.00	in

Injection Notes

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.	420 to 460	°F
Cylinder Zone 2 Temp.	420 to 460	°F
Cylinder Zone 3 Temp.	420 to 460	°F
Cylinder Zone 4 Temp.	420 to 460	°F
Cylinder Zone 5 Temp.	420 to 460	°F
Die Temperature	420 to 460	°F

Extrusion Notes

Screw Speed: 30 to 100 rpm

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Notes

[1] Typical properties: these are not to be construed as specifications.

[2] Type 1, 20 in/min

[3] Method Ba, Angle (Unnicked), 20 in/min

[4] Type A

[5] Type 1

[6] 15 sec

[7] 5 sec

[8] 1 sec