



Sarlink® TPE FM-2676B BLK XRD4 (DISCONTINUED)

Teknor Apex Company - Thermoplastic Elastomer

General Information

Product Description

THIS GRADE IS DISCONTINUED - PLEASE CONTACT YOUR TEKNOR APEX REP FOR MORE INFO

General

Material Status	• Preliminary Data		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Filled • Light Stabilized • Low Flow	• Medium Density • Medium Hardness • Sunlight Resistant	• UV Absorbing
Uses	• Automotive Applications	• Automotive Interior Parts	
RoHS Compliance	• RoHS Compliant		
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	• Thermoforming

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.02	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	0.20	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Taber Abrasion Resistance			ASTM D1044
1000 Cycles, 1000 g, H-18 Wheel	6.00	mg	
2000 Cycles, 1000 g, H-18 Wheel	16.0	mg	
1000 Cycles, 1000 g, H-22 Wheel	28.0	mg	
2000 Cycles, 1000 g, H-22 Wheel	62.0	mg	
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ²			ISO 37
Across Flow : 100% Strain	346	psi	
Flow : 100% Strain	766	psi	
Tensile Stress ²			ISO 37
Across Flow : Break	1270	psi	
Flow : Break	843	psi	
Tensile Elongation ²			ISO 37
Across Flow : Break	730	%	
Flow : Break	200	%	
Tear Strength ³			ISO 34-1
Across Flow	190	lbf/in	
Flow	220	lbf/in	
Compression Set ⁴			ISO 815
73°F, 22 hr	24	%	
158°F, 22 hr	38	%	
194°F, 70 hr	53	%	
257°F, 70 hr	71	%	

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Hardness	Nominal Value	Unit	Test Method
Shore Hardness			ISO 868
Shore A, 1 sec, Injection Molded	77		
Shore A, 5 sec, Injection Molded	75		
Shore A, 15 sec, Injection Molded	74		
Aging	Nominal Value	Unit	Test Method
Change in Tensile Strength in Air ⁵			ISO 188
Across Flow : 230°F, 1008 hr	-5.7	%	
Flow : 230°F, 1008 hr	6.2	%	
Across Flow : 100% Strain 230°F, 1008 hr	10	%	
Flow : 100% Strain 230°F, 1008 hr	13	%	
Across Flow : 257°F, 168 hr	1.3	%	
Flow : 257°F, 168 hr	7.2	%	
Across Flow : 100% Strain 257°F, 168 hr	12	%	
Flow : 100% Strain 257°F, 168 hr	14	%	
Change in Tensile Strain at Break in Air ⁵			ISO 188
Across Flow : 230°F, 1008 hr	-1.7	%	
Flow : 230°F, 1008 hr	-24	%	
Across Flow : 257°F, 168 hr	-1.4	%	
Flow : 257°F, 168 hr	-30	%	
Change in Shore Hardness in Air			ISO 188
Shore A, 230°F, 1008 hr ⁶	2.5		
Shore A, 230°F, 1008 hr ⁷	3.3		
Shore A, 230°F, 1008 hr ⁸	3.7		
Shore A, 257°F, 168 hr ⁶	1.7		
Shore A, 257°F, 168 hr ⁷	3.3		
Shore A, 257°F, 168 hr ⁸	3.8		
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (392°F, 206 sec ⁻¹)	313	Pa·s	ASTM D3835

Processing Information

Injection	Nominal Value	Unit
Rear Temperature	390 to 410	°F
Middle Temperature	400 to 420	°F
Front Temperature	410 to 430	°F
Nozzle Temperature	420 to 440	°F
Processing (Melt) Temp	420 to 440	°F
Mold Temperature	95 to 150	°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.	380 to 400	°F
Cylinder Zone 2 Temp.	390 to 410	°F
Cylinder Zone 3 Temp.	400 to 420	°F

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Extrusion	Nominal Value	Unit
Cylinder Zone 5 Temp.	410 to 430	°F
Die Temperature	420 to 440	°F

Extrusion Notes

Screw Speed: 30 to 100 rpm

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 1 sec

⁷ 5 sec

⁸ 15 sec