



Sarlink® TPE ML-1690B BLK X (PRELIMINARY DATA)

Teknor Apex Company - Thermoplastic Elastomer

General Information

Product Description

Sarlink ML-1690B BLK X is a general purpose TPE designed for automotive interior applications. This is a high hardness, medium density grade suitable for injection molding. This high flow TPE exhibits improved moldability and surface appearance.

General

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

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.00	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	24	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ²			ISO 37
Across Flow : 100% Strain	711	psi	
Flow : 100% Strain	895	psi	
Tensile Stress ²			ISO 37
Across Flow : Break	1170	psi	
Flow : Break	1460	psi	
Tensile Elongation ²			ISO 37
Across Flow : Break	590	%	
Flow : Break	580	%	
Tear Strength ³			ISO 34-1
Across Flow	270	lbf/in	
Flow	220	lbf/in	
Compression Set ⁴			ISO 815
73°F, 22 hr	38	%	
158°F, 22 hr	62	%	
194°F, 70 hr	76	%	
257°F, 70 hr	100	%	
Hardness	Nominal Value	Unit	Test Method
Shore Hardness			ISO 868
Shore A, 1 sec, Injection Molded	92		
Shore A, 5 sec, Injection Molded	91		
Shore A, 15 sec, Injection Molded	90		

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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	3.3	%	
Flow : 230°F, 1008 hr	-3.6	%	
Across Flow : 100% Strain 230°F, 1008 hr	9.7	%	
Flow : 100% Strain 230°F, 1008 hr	13	%	
Across Flow : 257°F, 168 hr	15	%	
Flow : 257°F, 168 hr	-3.2	%	
Across Flow : 100% Strain 257°F, 168 hr	12	%	
Flow : 100% Strain 257°F, 168 hr	15	%	
Change in Tensile Strain at Break in Air ⁵			ISO 188
Across Flow : 230°F, 1008 hr	-5.1	%	
Flow : 230°F, 1008 hr	-4.8	%	
Across Flow : 257°F, 168 hr	8.8	%	
Flow : 257°F, 168 hr	-2.0	%	
Change in Shore Hardness in Air			ISO 188
Shore A, 230°F, 1008 hr ⁶	0.0		
Shore A, 230°F, 1008 hr ⁷	0.50		
Shore A, 230°F, 1008 hr ⁸	0.90		
Shore A, 257°F, 168 hr ⁶	-1.6		
Shore A, 257°F, 168 hr ⁷	-0.80		
Shore A, 257°F, 168 hr ⁸	-0.30		

Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (392°F, 206 sec ⁻¹)	133	Pa·s	ASTM D3835
Additional Information	Nominal Value	Unit	Test Method
Xenon Weatherometer			SAE J1885
Delta E - 1250 kJ	1.00		
Delta E - 2500 kJ	1.65		

Processing Information

Injection	Nominal Value	Unit
Rear Temperature	340 to 380	°F
Middle Temperature	350 to 390	°F
Front Temperature	360 to 400	°F
Nozzle Temperature	370 to 410	°F
Processing (Melt) Temp	370 to 410	°F
Mold Temperature	60 to 90	°F
Injection Pressure	200 to 1000	psi
Injection Rate	Moderate-Fast	
Back Pressure	25.0 to 50.0	psi
Screw Speed	50 to 100	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).

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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 1 sec

⁷ 5 sec

⁸ 15 sec