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TEKNOR APEX

Sarlink® TPE RV-2670D

Teknor Apex Company - Thermoplastic Elastomer

General Information

Product Description

Sarlink RV-2670D is a high performance thermoplastic elastomer, available in NAT and BLK, used in a variety of transportation applications. Sarlink RV-2670D is a high hardness, high density, filled grade with a 400k psi modulus that is UV stabilized and suitable for extrusion and injection molding.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Chemical Resistant • Filled • Good Adhesion • Good Toughness • High Density	• High Hardness • High Specific Gravity • Light Stabilized • Low Flow • Lubricated	• Slip • Sunlight Resistant • UV Resistant • Weather Resistant
Uses	• Automotive Applications • Automotive Exterior Parts	• Automotive Exterior Trim • Racks	
RoHS Compliance	• RoHS Compliant		
Appearance	• Black	• Natural Color	
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.18	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	2.0	g/10 min	ASTM D1238
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Flexural Modulus	390000	psi	ASTM D790
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress [2]			ISO 37
Across Flow : 100% Strain	1850	psi	
Flow : 100% Strain	2500	psi	
Tensile Stress [2]			ISO 37
Across Flow : Break	2590	psi	
Flow : Break	3160	psi	
Tensile Elongation [2]			ISO 37
Across Flow : Break	120	%	
Flow : Break	140	%	
Tear Strength [3]			ISO 34-1
Across Flow	1000	lbf/in	
Flow	710	lbf/in	
Compression Set [4]			ISO 815
73°F, 22 hr	67	%	
158°F, 22 hr	94	%	
194°F, 70 hr	93	%	
Hardness	**Nominal Value**	**Unit**	**Test Method**
Shore Hardness			ISO 868
Shore D, 1 sec, Injection Molded	70		
Shore D, 5 sec, Injection Molded	69		
Shore D, 15 sec, Injection Molded	68		

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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	6.1	%	
Flow : 230°F, 1008 hr	11	%	
Across Flow : 100% Strain 230°F, 1008 hr	16	%	
Flow : 100% Strain 230°F, 1008 hr	29	%	
Across Flow : 257°F, 168 hr	3.9	%	
Flow : 257°F, 168 hr	7.9	%	
Across Flow : 100% Strain 257°F, 168 hr	20	%	
Flow : 100% Strain 257°F, 168 hr	33	%	
Change in Tensile Strain at Break in Air [5]			ISO 188
Across Flow : 230°F, 1008 hr	-31	%	
Flow : 230°F, 1008 hr	-18	%	
Across Flow : 257°F, 168 hr	16	%	
Flow : 257°F, 168 hr	9.2	%	
Change in Shore Hardness in Air			ISO 188
Shore D, 230°F, 1008 hr [6]	0.60		
Shore D, 230°F, 1008 hr [7]	1.2		
Shore D, 230°F, 1008 hr [8]	1.4		
Shore D, 257°F, 168 hr [8]	0.10		
Shore D, 257°F, 168 hr [7]	1.1		
Shore D, 257°F, 168 hr [6]	1.3		

Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (392°F, 206 sec^-1)	613	Pa·s	ASTM D3835

Processing Information

Injection	Nominal Value	Unit
Rear Temperature	380 to 450	°F
Middle Temperature	380 to 450	°F
Front Temperature	380 to 450	°F
Nozzle Temperature	380 to 450	°F
Processing (Melt) Temp	380 to 450	°F
Mold Temperature	60 to 110	°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

Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	380 to 430	°F
Cylinder Zone 2 Temp.	380 to 430	°F
Cylinder Zone 3 Temp.	380 to 430	°F

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Extrusion	Nominal Value	Unit
Cylinder Zone 4 Temp.	380 to 430	°F
Cylinder Zone 5 Temp.	380 to 430	°F
Die Temperature	380 to 430	°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