+135-3858-6433 (GuangDong)
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TEKNOR APEX

Sarlink® TPE EE-1230N

Teknor Apex Company - Thermoplastic Elastomer

General Information

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Uses	• Automotive Exterior Trim		
RoHS Compliance	• RoHS Compliant		
Automotive Specifications	• GM ITTA 8509		
Appearance	• Opaque		
Forms	• Pellets		
Processing Method	• Extrusion		

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.17		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	0.50	g/10 min	ASTM D1238
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress [2]			ASTM D412
Across Flow : 100% Strain	46.0	psi	
Flow : 100% Strain	85.0	psi	
Tensile Strength [2]			ASTM D412
Across Flow : Break	686	psi	
Flow : Break	382	psi	
Tensile Elongation [2]			ASTM D412
Across Flow : Break	950	%	
Flow : Break	740	%	
Tear Strength - Across Flow [2]	96.0	lbf/in	ASTM D624
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness [3]			ASTM D2240
Shore A, 1 sec, Injection Molded	33		
Shore A, 5 sec, Injection Molded	30		

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).

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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
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] Die C, 20 in/min

[3] Aged for 48 hr