



# Sarlink® TPE FM-2669 (PRELIMINARY DATA)

Teknor Apex Company - Thermoplastic Elastomer

## General Information

### Product Description

Sarlink TPE FM-2669 is a general purpose thermoplastic elastomer available in Nat, Blk, and colors, used in a variety of automotive interior applications including floor mats. Sarlink TPE FM-2669 is a UV stabilized, medium hardness, high density, wear-resistant grade suitable for extrusion, injection molding, or 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 Processability • Good Toughness • High Density • High Specific Gravity	• Low Flow • Medium Hardness • UV Resistant • Wear Resistant
Uses	• Automotive Applications	• Automotive Interior Parts	• Rubber Replacement
RoHS Compliance	• RoHS Compliant		
Appearance	• Black	• Colors Available	• Natural Color
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	• Thermoforming

## ASTM & ISO Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density	1.15	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	0.10	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (Break)	870	psi	ISO 37
Tensile Elongation (Break)	500	%	ISO 37
Hardness	Nominal Value	Unit	Test Method
Shore Hardness			ISO 868
Shore A, 1 sec, Injection Molded	79		
Shore A, 5 sec, Injection Molded	75		
Shore A, 15 sec, Injection Molded	74		

## 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

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<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
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).

<b>Extrusion</b>	<b>Nominal Value</b>	<b>Unit</b>
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

### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.