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TEKNOR APEX

Sarlink® TPE ML-1190N NAT

Teknor Apex Company - Thermoplastic Elastomer

General Information

Product Description

Sarlink ML-1100 is a general purpose thermoplastic elastomer series, available in NAT and BLK designed for automotive interior applications. Sarlink ML-1190N NAT is a high hardness, high density, filled grade suitable for 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 Colorability • Good Flexibility	• Good Moldability • Good Tear Strength • Good Toughness • High Density • High Flow	• High Hardness • High Specific Gravity • Resilient • Sunlight Resistant
Uses	• Automotive Applications • Automotive Interior Parts • Flexible Grips	• General Purpose • Grommets • Knobs	• Rubber Replacement • Soft Touch Applications
RoHS Compliance	• RoHS Compliant		
Appearance	• Colors Available	• Natural Color	• Opaque
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.17	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	15	g/10 min	ASTM D1238
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress [2]			ISO 37
Across Flow : 100% Strain	551	psi	
Flow : 100% Strain	738	psi	
Tensile Stress [2]			ISO 37
Across Flow : Break	986	psi	
Flow : Break	1130	psi	
Tensile Elongation [2]			ISO 37
Across Flow : Break	600	%	
Flow : Break	550	%	
Tear Strength [3]			ISO 34-1
Across Flow	222	lbf/in	
Flow	176	lbf/in	
Compression Set [4]			ISO 815
73°F, 22 hr	42	%	
158°F, 22 hr	64	%	
194°F, 70 hr	74	%	
257°F, 70 hr	96	%	

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Hardness	Nominal Value	Unit	Test Method
Shore Hardness			ISO 868
Shore A, 1 sec, Injection Molded	91		
Shore A, 5 sec, Injection Molded	89		
Shore A, 15 sec, Injection Molded	88		
Aging	**Nominal Value**	**Unit**	**Test Method**
Change in Tensile Strength in Air [5]			ISO 188
Across Flow : 230°F, 1008 hr	-4.1	%	
Flow : 230°F, 1008 hr	-8.6	%	
Across Flow : 100% Strain 230°F, 1008 hr	8.3	%	
Flow : 100% Strain 230°F, 1008 hr	12	%	
Across Flow : 257°F, 168 hr	-1.8	%	
Flow : 257°F, 168 hr	-8.8	%	
Across Flow : 100% Strain 257°F, 168 hr	7.7	%	
Flow : 100% Strain 257°F, 168 hr	13	%	
Change in Tensile Strain at Break in Air [5]			ISO 188
Across Flow : 230°F, 1008 hr	-8.5	%	
Flow : 230°F, 1008 hr	-25	%	
Across Flow : 257°F, 168 hr	-4.7	%	
Flow : 257°F, 168 hr	-23	%	
Change in Shore Hardness in Air			ISO 188
Shore A, 230°F, 1008 hr [6]	2.0		
Shore A, 230°F, 1008 hr [7]	1.9		
Shore A, 230°F, 1008 hr [8]	1.5		
Shore A, 257°F, 168 hr [6]	2.6		
Shore A, 257°F, 168 hr [7]	2.2		
Shore A, 257°F, 168 hr [8]	1.6		
Fill Analysis	**Nominal Value**	**Unit**	**Test Method**
Apparent Viscosity (392°F, 206 sec^-1)	141	Pa·s	ASTM D3835

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

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Injection	Nominal Value	Unit
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).

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] 15 sec

[7] 5 sec

[8] 1 sec