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TEKNOR APEX

Sarlink® TPE RV-2668DN

Teknor Apex Company - Thermoplastic Elastomer

General Information

Product Description

Sarlink RV-2668DN is a high performance Thermoplastic Elastomer used in transportation applications. Sarlink RV-2668DN is a high hardness, medium density, RoHS compliant grade that can be processed by injection molding and extrusion.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Bondability • Chemical Resistant • Filled • Good Adhesion • Good Color Stability	• Good Colorability • Good Mold Release • Good Moldability • Good Processability • High Hardness	• High Viscosity • Light Stabilized • Low Flow • Medium Density • Slip
Uses	• Automotive Applications • Automotive Exterior Parts	• Automotive Exterior Trim • General Purpose	• Grommets • Rubber Replacement
RoHS Compliance	• RoHS Compliant		
Appearance	• Black	• Natural Color	• Opaque
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.05	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	3.5	g/10 min	ASTM D1238
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Flexural Modulus	245000	psi	ASTM D790
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress [2]			ISO 37
Across Flow : 100% Strain	2150	psi	
Flow : 100% Strain	2100	psi	
Tensile Stress [2]			ISO 37
Across Flow : Break	3160	psi	
Flow : Break	3640	psi	
Tensile Elongation [2]			ISO 37
Across Flow : Break	320	%	
Flow : Break	140	%	
Tear Strength [3]			ISO 34-1
Across Flow	1200	lbf/in	
Flow	800	lbf/in	
Compression Set [4]			ISO 815
73°F, 22 hr	63	%	
158°F, 22 hr	86	%	
194°F, 70 hr	93	%	
257°F, 70 hr	100	%	

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Hardness	Nominal Value	Unit	Test Method
Shore Hardness [5]			ISO 868
Shore D, 1 sec, Injection Molded	73		
Shore D, 5 sec, Injection Molded	69		
Shore D, 15 sec, Injection Molded	68		
Aging	**Nominal Value**	**Unit**	**Test Method**
Change in Tensile Strength in Air [6]			ISO 188
Across Flow : 230°F, 1008 hr	1.8	%	
Flow : 230°F, 1008 hr	9.0	%	
Across Flow : 100% Strain 230°F, 1008 hr	12	%	
Flow : 100% Strain 230°F, 1008 hr	68	%	
Across Flow : 257°F, 168 hr	-2.8	%	
Flow : 257°F, 168 hr	2.4	%	
Across Flow : 100% Strain 257°F, 168 hr	15	%	
Flow : 100% Strain 257°F, 168 hr	75	%	
Change in Tensile Strain at Break in Air [6]			ISO 188
Across Flow : 230°F, 1008 hr	-58	%	
Flow : 230°F, 1008 hr	-7.2	%	
Across Flow : 257°F, 168 hr	-54	%	
Flow : 257°F, 168 hr	27	%	
Change in Shore Hardness in Air			ISO 188
Shore D, 230°F, 1008 hr [7]	2.3		
Shore D, 230°F, 1008 hr [8]	2.0		
Shore D, 230°F, 1008 hr [9]	2.0		
Shore D, 257°F, 168 hr [7]	1.3		
Shore D, 257°F, 168 hr [8]	1.2		
Shore D, 257°F, 168 hr [9]	1.1		
Fill Analysis	**Nominal Value**	**Unit**	**Test Method**
Apparent Viscosity (392°F, 206 sec^-1)	560	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	77 to 150	°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

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Injection	Nominal Value	Unit
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).

Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	330 to 370	°F
Cylinder Zone 2 Temp.	340 to 380	°F
Cylinder Zone 3 Temp.	350 to 390	°F
Cylinder Zone 4 Temp.	375 to 410	°F
Cylinder Zone 5 Temp.	360 to 400	°F
Die Temperature	374 to 410	°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] 24 hrs

[6] Type 1

[7] 15 sec

[8] 5 sec

[9] 1 sec