



Tekbond® TB-6000-60

Teknor Apex Company - Thermoplastic Elastomer

General Information

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America • South America
Uses	• Appliances • Bonding • Cell Phones • Dental Applications	• Flexible Grips • Handles • Knobs • Overmolding	• Power/Other Tools • Sporting Goods • Toothbrush Handles • Writing Instruments
Appearance	• Opaque		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.998	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow	2.5	%	ASTM D955
Molding Shrinkage - Across Flow	3.6	%	ASTM D955
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (300% Strain)	4.14	MPa	ASTM D412
Tensile Strength (Break)	8.27	MPa	ASTM D412
Tensile Elongation (Break)	560	%	ASTM D412
Compression Set (23°C)	28	%	ASTM D395
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	60		ASTM D2240
Flammability	Nominal Value	Unit	Test Method
Flame Rating - UL (ALL)	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	60.0	°C
Drying Time	2.0 to 4.0	hr
Rear Temperature	138 to 160	°C
Middle Temperature	182 to 199	°C
Front Temperature	182 to 199	°C
Nozzle Temperature	193 to 210	°C
Processing (Melt) Temp	177 to 199	°C
Mold Temperature	4.44 to 48.9	°C
Injection Pressure	1.38 to 5.52	MPa
Back Pressure	0.172 to 0.862	MPa
Screw Speed	50 to 100	rpm
Cushion	3.81 to 25.4	mm

Injection Notes

Moisture can degrade the material. Drying is suggested. This can be accomplished by placing the material in a desiccant dryer for 2 to 4 hours at 140°F.

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Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	138 to 149	°C
Cylinder Zone 2 Temp.	149 to 160	°C
Cylinder Zone 3 Temp.	160 to 182	°C
Cylinder Zone 5 Temp.	171 to 193	°C
Die Temperature	182 to 204	°C

Notes

¹ Typical properties: these are not to be construed as specifications.