



Telcar® 1383M

Teknor Apex Company - Thermoplastic Elastomer

General Information

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• General Purpose • Good Colorability • Halogen Free	• High Elongation • Low Density • Low Hardness	• Medium Flow
Uses	• Consumer Applications • Electrical/Electronic Applications	• General Purpose • Industrial Applications	
RoHS Compliance	• RoHS Compliant		
Appearance	• Opaque		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.950		ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	15	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength (Break)	750	psi	ASTM D412
Tensile Elongation (Break)	900	%	ASTM D412
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 1 sec)	45		ASTM D2240

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
Cushion	0.150 to 1.00	in
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 5 Temp.	360 to 400	°F
Die Temperature	374 to 410	°F

Extrusion Notes

Screw Speed: 30 to 100 rpm