



Telcar® TL-2550DA

Teknor Apex Company - Thermoplastic Elastomer

General Information

Product Description

The Telcar TL-2500A Series of thermoplastic elastomer compounds, available in NAT or colors, from 25 Shore A to 50 Shore D, are designed specifically for general purpose applications. Telcar TL-2550DA is a higher hardness, low density, unfilled grade that is suitable for injection molding.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Abrasion Resistant • Chemical Resistant • Good Adhesion • Good Colorability • Good Melt Strength • Good Moldability	• Good Processability • Good Processing Stability • Good Tear Strength • Good Toughness • Halogen Free • High Elongation	• High Flow • High Hardness • Low Density • Low Specific Gravity • Without Fillers
Uses	• Handles • Industrial Applications • Low Temperature Applications	• Rubber Replacement • Wall Panels • Wheels/Casters	• Windows & Doors
RoHS Compliance	• RoHS Compliant		
Appearance	• Colors Available	• Natural Color	• Translucent
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.902		ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	20	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ²			ASTM D412
Across Flow : 100% Strain	725	psi	
Flow : 100% Strain	870	psi	
Tensile Strength ²			ASTM D412
Across Flow : Break	1740	psi	
Flow : Break	1450	psi	
Tensile Elongation ²			ASTM D412
Across Flow : Break	700	%	
Flow : Break	750	%	
Tear Strength ²			ASTM D624
Across Flow	400	lbf/in	
Flow	428	lbf/in	
Compression Set ³			ASTM D395B
73°F, 22 hr	35	%	
158°F, 22 hr	50	%	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore D, 1 sec, Injection Molded	52		
Shore D, 5 sec, Injection Molded	50		

Telcar® TL-2550DA

Teknor Apex Company - Thermoplastic Elastomer

Processing Information

Injection	Nominal Value	Unit
Rear Temperature	380 to 420	°F
Middle Temperature	400 to 440	°F
Front Temperature	420 to 460	°F
Nozzle Temperature	420 to 460	°F
Processing (Melt) Temp	420 to 460	°F
Mold Temperature	60 to 90	°F
Injection Pressure	200 to 800	psi
Injection Rate	Fast	
Back Pressure	25.0 to 100	psi
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 Die C, 20 in/min

³ Type 1