



Sarlink® TPV X6765 (PRELIMINARY DATA)

Teknor Apex Company - Thermoplastic Vulcanizate

General Information

Product Description

SARLINK® TPV X6765 is a high performance thermoplastic vulcanizate used in automotive applications including interior trim. Sarlink TPV X6765 is a medium hardness, low density grade, available in Nat or can be color-matched with good color stability, exhibiting good UV resistance. This grade is designed for injection molding but could also be extruded.

General

Material Status	• Preliminary Data		
Availability	• Asia Pacific • Europe	• Latin America • North America	
Features	• Chemical Resistant • Good Adhesion • Good Color Stability • Good Colorability	• Good Moldability • Good Processability • Light Stabilized • Low Compression Set	• Low Density • Low Specific Gravity • Medium Hardness • UV Resistant
Uses	• Automotive Applications • Automotive Interior Parts	• Automotive Interior Trim • Profiles	• Rubber Replacement • Seals
RoHS Compliance	• RoHS Compliant		
Appearance	• Colors Available	• Opaque	• Unspecified Color
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	0.920	g/cm ³	ISO 1183
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (100% Strain)	370	psi	ISO 37
Tensile Stress (Break)	972	psi	ISO 37
Tensile Elongation (Break)	650	%	ISO 37
Compression Set (158°F, 22 hr)	43	%	ISO 815
Hardness	Nominal Value	Unit	Test Method
Shore Hardness			ISO 868
Shore A, 1 sec, Injection Molded	70		
Shore A, 5 sec, Injection Molded	68		
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (392°F, 206 sec ⁻¹)	230	Pa·s	ASTM D3835

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	3.0	hr
Rear Temperature	350 to 420	°F
Middle Temperature	350 to 420	°F

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Injection	Nominal Value	Unit
Front Temperature	350 to 420	°F
Nozzle Temperature	370 to 430	°F
Processing (Melt) Temp	360 to 430	°F
Mold Temperature	50 to 150	°F
Back Pressure	10.0 to 150	psi
Screw Speed	100 to 200	rpm
Screw L/D Ratio	20.0:1.0	
Extrusion	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	3.0	hr
Cylinder Zone 1 Temp.	360 to 400	°F
Cylinder Zone 2 Temp.	360 to 400	°F
Cylinder Zone 3 Temp.	370 to 410	°F
Cylinder Zone 4 Temp.	370 to 410	°F
Melt Temperature	380 to 420	°F
Die Temperature	380 to 420	°F
Take-Off Roll	70 to 120	°F
Extrusion Notes		
Screen Pack: 20 to 60 mesh		
Screw: 3:1 Compression Ratio		

Notes

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