

Sarlink® TPE EE-1255

Teknor Apex Company - Thermoplastic Elastomer

Thursday, June 29, 2017

General Information

Product Description

Sarlink EE-1255 is a general purpose thermoplastic elastomer used in automotive applications, including exterior. Sarlink EE-1255 is a medium hardness, high density, lubricated grade exhibiting good colorability and processability. This grade 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	• Filled • General Purpose • Good Melt Strength • Good Mold Release • Good Processability	• Good Processability • Good Processing Stability • High Density • High Specific Gravity • Low Flow	• Lubricated • Medium Hardness • Slip
Uses	• Automotive Applications • Automotive Exterior Parts	• Automotive Exterior Trim • Automotive Interior Parts	• Automotive Interior Trim
RoHS Compliance	• RoHS Compliant		
Appearance	• Black • Colors Available	• Natural Color • Opaque	
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.16	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	0.40	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ²			ISO 37
Across Flow : 100% Strain	152	psi	
Flow : 100% Strain	328	psi	
Tensile Stress ²			ISO 37
Across Flow : Break	812	psi	
Flow : Break	421	psi	
Tensile Elongation ²			ISO 37
Across Flow : Break	780	%	
Flow : Break	350	%	
Tear Strength ³			ISO 34-1
Across Flow	100	lbf/in	
Flow	120	lbf/in	
Compression Set ⁴			ISO 815
73°F, 22 hr	16	%	
158°F, 22 hr	36	%	
194°F, 70 hr	58	%	
257°F, 70 hr	70	%	



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Hardness	Nominal Value	Unit	Test Method
Shore Hardness			ISO 868
Shore A, 1 sec, Injection Molded	57		
Shore A, 5 sec, Injection Molded	55		
Shore A, 15 sec, Injection Molded	54		
Aging	Nominal Value	Unit	Test Method
Change in Tensile Strength in Air ⁵			ISO 188
Across Flow : 230°F, 1008 hr	8.9	%	
Flow : 230°F, 1008 hr	6.9	%	
Across Flow : 100% Strain 230°F, 1008 hr	6.7	%	
Flow : 100% Strain 230°F, 1008 hr	6.2	%	
Across Flow : 257°F, 168 hr	3.6	%	
Flow : 257°F, 168 hr	3.4	%	
Across Flow : 100% Strain 257°F, 168 hr	1.9	%	
Flow : 100% Strain 257°F, 168 hr	7.1	%	
Change in Tensile Strain at Break in Air ⁵			ISO 188
Across Flow : 230°F, 1008 hr	6.7	%	
Flow : 230°F, 1008 hr	14	%	
Across Flow : 257°F, 168 hr	2.7	%	
Flow : 257°F, 168 hr	3.4	%	
Change in Shore Hardness in Air			ISO 188
230°F, 1008 hr ⁶	2.1		
Shore A, 230°F, 1008 hr ⁷	2.2		
Shore A, 230°F, 1008 hr ⁸	1.5		
Shore A, 257°F, 168 hr ⁷	0.90		
Shore A, 257°F, 168 hr ⁶	0.60		
Shore A, 257°F, 168 hr ⁸	-0.50		
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (392°F, 206 sec ⁻¹)	235	Pa·s	ASTM D3835

Legal Statement

The information and recommendations contained in this bulletin are, to the best of our knowledge, accurate and reliable but no guarantee of their accuracy is made. All products are sold upon condition that purchasers shall make their own tests to determine the suitability of such products for their particular purposes and uses and purchaser assumes all risks and liability for the results of use of the products, including use in accordance with seller's recommendations. Nothing in this bulletin constitutes permission or a recommendation to practice or use any invention covered by any patent owned by this company or others. There is no warranty of merchantability and there are no other warranties for the products described. For detailed Product Stewardship information, please contact us. Any product of Teknor Apex, including product names, shall not be used or tested in medical or food contact applications without the prior written acknowledgement of Teknor Apex as to the intended use. Please note that some products may not be available in one or more countries.

Processing Information

Injection	Nominal Value	Unit
Rear Temperature	440 to 480	°F
Middle Temperature	440 to 480	°F
Front Temperature	440 to 480	°F
Nozzle Temperature	440 to 480	°F
Processing (Melt) Temp	440 to 480	°F
Mold Temperature	60 to 90	°F
Injection Pressure	200 to 1000	psi
Injection Rate	Fast	
Back Pressure	25.0 to 125	psi
Screw Speed	50 to 120	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.	420 to 460	°F
Cylinder Zone 2 Temp.	420 to 460	°F
Cylinder Zone 3 Temp.	420 to 460	°F
Cylinder Zone 4 Temp.	420 to 460	°F
Cylinder Zone 5 Temp.	420 to 460	°F
Die Temperature	420 to 460	°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 Type 1

⁶ 5 sec

⁷ 15 sec

⁸ 1 sec

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