

# Telcar® TL-2550F

Teknor Apex Company - Thermoplastic Elastomer

Thursday, June 29, 2017

## General Information

### Product Description

Telcar TL-2550F is a general purpose thermoplastic elastomer designed for a variety of industrial applications. Telcar TL-2550F is a high density, medium hardness grade suitable for both 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 Colorability	• High Density • High Flow • High Specific Gravity	• Medium Hardness • Oil Extended
Uses	• General Purpose • Grommets	• Industrial Applications • Industrial Parts	• Rubber Replacement
RoHS Compliance	• RoHS Compliant		
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

## ASTM & ISO Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.18		ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	5.0	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength (Break)	800	psi	ASTM D412
Tensile Elongation (Break)	800	%	ASTM D412
Tear Strength			ASTM D624
Across Flow	119	lbf/in	
Flow	115	lbf/in	
Compression Set			ASTM D395
73°F, 22 hr	24	%	
158°F, 22 hr	52	%	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	53		ASTM D2240

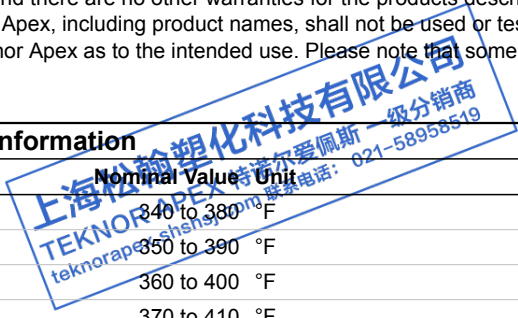
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## Processing Information

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

Revision Date: 6/1/2016



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Injection	Nominal Value	Unit
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 4 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

### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

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