

Telcar® TL-2657J BLK

Teknor Apex Company - Thermoplastic Elastomer

Friday, June 30, 2017

General Information

Product Description

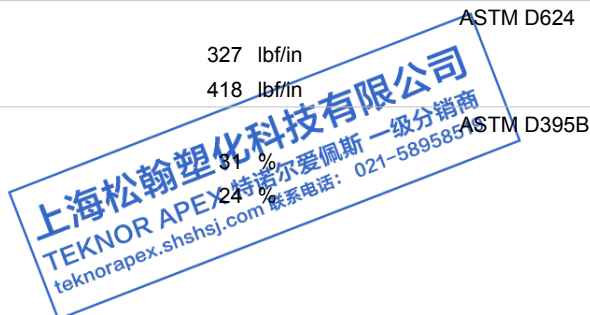
Telcar TL-2657J BLK is a general purpose thermoplastic elastomer designed for the industrial and transportation markets, including weatherstripping and wind skirts. Telcar TL-2657J BLK is a high hardness, high density, UV stable grade suitable for injection molding and extrusion.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Filled • High Density • High Hardness	• High Specific Gravity • Light Stabilized • Low Flow	• Sunlight Resistant • UV Resistant
Uses	• General Purpose • Grommets	• Industrial Applications • Rubber Replacement	• Weatherstripping
RoHS Compliance	• RoHS Compliant		
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.14		ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	5.0	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus	39300	psi	ASTM D790
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ²			ASTM D412
Across Flow : 100% Strain	1110	psi	
Flow : 100% Strain	1400	psi	
Tensile Stress ²			ASTM D412
Across Flow : 300% Strain	1240	psi	
Flow : 300% Strain	1570	psi	
Tensile Strength ²			ASTM D412
Across Flow : Break	2480	psi	
Flow : Break	1930	psi	
Tensile Elongation ²			ASTM D412
Across Flow : Break	700	%	
Flow : Break	490	%	
Tear Strength ²			ASTM D624
Across Flow	327	lbf/in	
Flow	418	lbf/in	
Compression Set ³			ASTM D395B
73°F, 22 hr	31	%	
158°F, 22 hr	24	%	



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Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A	95		
Shore D, 1 sec, Injection Molded ⁴	46		
Shore D, 5 sec, Injection Molded ⁴	45		

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	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

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.	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

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

² Die C, 20 in/min

³ Type 2

⁴ Aged for 24 hr



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