

Telcar® TL-2450F

Teknor Apex Company - Thermoplastic Elastomer

Thursday, June 29, 2017

General Information

Product Description

Telcar TL-2450F is a general purpose thermoplastic elastomer designed for a variety of industrial applications. Telcar TL-2450F is a medium density, low 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 Flow • Low Hardness • Medium Density	• Oil Extended
Uses	• General Purpose • Grommets	• Industrial Applications • Industrial Parts	• Rubber Replacement
RoHS Compliance	• RoHS Compliant		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.980		ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	16	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (100% Strain)	200	psi	ASTM D412
Tensile Stress (300% Strain)	300	psi	ASTM D412
Tensile Strength (Break)	925	psi	ASTM D412
Tensile Elongation (Break)	800	%	ASTM D412
Tear Strength			ASTM D624
Across Flow	117	lbf/in	
Flow	116	lbf/in	
Compression Set ²			ASTM D395B
73°F, 22 hr	25	%	
158°F, 22 hr	49	%	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 sec	44		
Shore A, 15 sec	48		

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

Revision Date: 6/1/2016

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Injection	Nominal Value	Unit
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

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 Type 1

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