

# Sarlink® TPE FM-2676 (PRELIMINARY DATA)

Teknor Apex Company - Thermoplastic Elastomer

Friday, June 30, 2017

## General Information

### Product Description

Sarlink FM-2676 is a general purpose thermoplastic elastomer, available in NAT, BLK, and colors, designed for automotive interior applications, including floor mats. Sarlink FM-2676 is a medium hardness, high density, filled grade suitable for extrusion and thermoforming.

### General

|                   |  |   |  |
|-------------------|--|---|--|
| Material Status   | • Preliminary Data   |   |  |
| Availability      | • Africa & Middle East<br>• Asia Pacific   | • Europe<br>• Latin America   | • North America  |
| Features          | • Chemical Resistant<br>• Filled<br>• Good Adhesion<br>• Good Colorability<br>• Good Flexibility | • Good Processability<br>• Good Tear Strength<br>• Good Toughness<br>• Low Flow<br>• Medium Density | • Medium Hardness<br>• Wear Resistant<br>• Weather Resistant |
| Uses              | • Automotive Applications<br>• Automotive Interior Parts   | • Rubber Replacement<br>• Thermoforming Applications  |  |
| RoHS Compliance   | • RoHS Compliant   |   |  |
| Appearance        | • Colors Available   | • Natural Color   |  |
| Forms             | • Pellets  |   |  |
| Processing Method | • Extrusion  | • Thermoforming   |  |

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

| Physical                                  | Nominal Value | Unit              | Test Method |
|---|---------------|-------------------|-------------|
| Density                                   | 1.10          | g/cm <sup>3</sup> | 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 <sup>2</sup>               |               |                   | ISO 37      |
| Across Flow : 100% Strain                 | 367           | psi               |             |
| Flow : 100% Strain                        | 544           | psi               |             |
| Tensile Stress <sup>2</sup>               |               |                   | ISO 37      |
| Across Flow : Break                       | 1330          | psi               |             |
| Flow : Break                              | 914           | psi               |             |
| Tensile Elongation <sup>2</sup>           |               |                   | ISO 37      |
| Across Flow : Break                       | 970           | %                 |             |
| Flow : Break                              | 460           | %                 |             |
| Tear Strength <sup>3</sup>                |               |                   | ISO 34-1    |
| Across Flow                               | 260           | lbf/in            |             |
| Flow                                      | 250           | lbf/in            |             |
| Compression Set <sup>4</sup>              |               |                   | ISO 815     |
| 73°F, 22 hr                               | 22            | %                 |             |
| 158°F, 22 hr                              | 37            | %                 |             |
| 194°F, 70 hr                              | 61            | %                 |             |
| Hardness                                  | Nominal Value | Unit              | Test Method |
| Shore Hardness                            |               |                   | ISO 868     |
| Shore A, 1 sec, Injection Molded          | 79            |                   |             |
| Shore A, 5 sec, Injection Molded          | 77            |                   |             |
| Shore A, 15 sec, Injection Molded         | 75            |                   |             |

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| Aging   | Nominal Value | Unit | Test Method |
|---|---------------|------|-------------|
| Change in Tensile Strength in Air <sup>5</sup>        |               |      | ISO 188     |
| Across Flow : 230°F, 1008 hr                          | -1.9          | %    |             |
| Flow : 230°F, 1008 hr                                 | 10            | %    |             |
| Across Flow : 100% Strain 230°F, 1008 hr              | 13            | %    |             |
| Flow : 100% Strain 230°F, 1008 hr                     | -2.6          | %    |             |
| Change in Tensile Strain at Break in Air <sup>5</sup> |               |      | ISO 188     |
| Across Flow : 230°F, 1008 hr                          | -3.5          | %    |             |
| Flow : 230°F, 1008 hr                                 | 14            | %    |             |
| Change in Shore Hardness in Air                       |               |      | ISO 188     |
| Shore A, 230°F, 1008 hr <sup>6</sup>                  | -0.50         |      |             |
| Shore A, 230°F, 1008 hr <sup>7</sup>                  | -0.40         |      |             |
| Shore A, 230°F, 1008 hr <sup>8</sup>                  | -0.40         |      |             |

| Fill Analysis                                      | Nominal Value | Unit | Test Method |
|--|---------------|------|-------------|
| Apparent Viscosity (392°F, 206 sec <sup>-1</sup> ) | 617           | Pa·s | ASTM D3835  |

### Legal Statement

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### 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  |
| 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



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### Notes

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

<sup>2</sup> Type 1, 20 in/min

<sup>3</sup> Method Ba, Angle (Unnicked), 20 in/min

<sup>4</sup> Type A

<sup>5</sup> Type 1

<sup>6</sup> 15 sec

<sup>7</sup> 5 sec

<sup>8</sup> 1 sec

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