

Telcar® TELC 340-S

Teknor Apex Company - Thermoplastic Elastomer

Thursday, June 29, 2017

General Information

Product Description

Telcar TELC 340-S is a general purpose thermoplastic elastomer, available in NAT and BLK, designed for the automotive and industrial markets. Telcar TELC 340-S is a high hardness, low density, unfilled grade suitable for injection molding, blow molding, and extrusion.

General

| | | | |
|---------------------------|--|--|---|
| Material Status | • Commercial: Active | | |
| Availability | • Africa & Middle East • Asia Pacific | • Europe • Latin America | • North America |
| Features | • High Hardness • Low Density | • Low Flow • Low Specific Gravity | • Without Fillers |
| Uses | • Automotive Applications • Blow Molding Applications | • General Purpose • Grommets | • Industrial Applications • Weatherstripping |
| RoHS Compliance | • RoHS Compliant | | |
| Automotive Specifications | • CHRYSLER MS-DC-243 Color: Natural | • CHRYSLER MS-DC-243 CPN 2705, 2390 Color: Black | |
| Appearance | • Black | • Natural Color | |
| Forms | • Pellets | | |
| Processing Method | • Extrusion | • Injection Molding | |

ASTM & ISO Properties ¹

| Physical | Nominal Value | Unit | Test Method |
|---|---------------|----------|-------------|
| Specific Gravity | 0.890 | | ASTM D792 |
| Melt Mass-Flow Rate (MFR) (230°C/2.16 kg) | 5.0 | g/10 min | ASTM D1238 |
| Elastomers | Nominal Value | Unit | Test Method |
| Tensile Stress ² | | | ASTM D412 |
| Across Flow : 100% Strain | 1130 | psi | |
| Flow : 100% Strain | 1430 | psi | |
| Tensile Stress ² | | | ASTM D412 |
| Across Flow : 300% Strain | 1170 | psi | |
| Flow : 300% Strain | 1550 | psi | |
| Tensile Strength ² | | | ASTM D412 |
| Across Flow : Break | 1900 | psi | |
| Flow : Break | 1850 | psi | |
| Tensile Elongation ² | | | ASTM D412 |
| Across Flow : Break | 760 | % | |
| Flow : Break | 600 | % | |
| Tear Strength ² | | | |
| Across Flow | 413 | lbf/in | ASTM D1004 |
| Flow | 464 | lbf/in | ASTM D624 |
| Compression Set ³ | | | ASTM D395B |
| 73°F, 22 hr | 38 % | | |
| 158°F, 22 hr | 66 % | | |
| Hardness | Nominal Value | Unit | Test Method |
| Durometer Hardness | | | ASTM D2240 |
| Shore D, 1 sec, Injection Molded | 46 | | |
| Shore D, 5 sec, Injection Molded | 44 | | |



Revision Date: 6/1/2016

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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 |
| 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. | 360 to 399 | °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 1

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