

Sarlink® TPV 2774N XRD1

Teknor Apex Company - Thermoplastic Vulcanizate

Thursday, June 29, 2017

General Information

Product Description

Sarlink 2774N XRD1 is a high performance thermoplastic vulcanizate used in automotive applications. Sarlink 2774N XRD1 is a medium hardness, low density, lubricated grade exhibiting sunlight resistance and UV absorbing characteristics. This grade can be processed by injection molding and extrusion.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Filled • Light Stabilized • Low Density • Low Flow	• Low Specific Gravity • Lubricated • Medium Hardness • Slip	• Sunlight Resistant • UV Absorbing
Uses	• Automotive Exterior Trim	• Automotive Interior Parts	• Automotive Interior Trim
RoHS Compliance	• RoHS Compliant		
Appearance	• Opaque		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	0.960	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	0.30	g/10 min	ASTM D1238

Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ²			ISO 37
Across Flow : 100% Strain	339	psi	
Flow : 100% Strain	557	psi	
Tensile Stress ²			ISO 37
Across Flow : Break	798	psi	
Flow : Break	667	psi	
Tensile Elongation ²			ISO 37
Across Flow : Break	450	%	
Flow : Break	210	%	
Tear Strength ³			ISO 34-1
Across Flow	140	lbf/in	
Flow	140	lbf/in	
Compression Set ⁴			ISO 815
73°F, 22 hr	20	%	
158°F, 22 hr	32	%	
194°F, 70 hr	37	%	
257°F, 70 hr	49	%	

Hardness

	Nominal Value	Unit	Test Method
Shore Hardness			ISO 868
Shore A, 1 sec, Injection Molded	75		
Shore A, 5 sec, Injection Molded	71		
Shore A, 15 sec, Injection Molded	69		



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Aging	Nominal Value	Unit	Test Method
Change in Tensile Strength in Air ⁵			ISO 188
Across Flow : 230°F, 1008 hr	2.0	%	
Flow : 230°F, 1008 hr	0.40	%	
Across Flow : 100% Strain 230°F, 1008 hr	10	%	
Flow : 100% Strain 230°F, 1008 hr	8.8	%	
Across Flow : 257°F, 168 hr	5.5	%	
Flow : 257°F, 168 hr	2.2	%	
Across Flow : 100% Strain 257°F, 168 hr	11	%	
Flow : 100% Strain 257°F, 168 hr	9.1	%	
Change in Tensile Strain at Break in Air ⁵			ISO 188
Across Flow : 230°F, 1008 hr	-5.4	%	
Flow : 230°F, 1008 hr	-17	%	
Across Flow : 257°F, 168 hr	-4.5	%	
Flow : 257°F, 168 hr	-20	%	
Change in Shore Hardness in Air			ISO 188
Shore A, 230°F, 1008 hr ⁶	1.7		
Shore A, 230°F, 1008 hr ⁷	2.9		
Shore A, 230°F, 1008 hr ⁸	3.1		
Shore A, 257°F, 168 hr ⁶	1.7		
Shore A, 257°F, 168 hr ⁷	2.5		
Shore A, 257°F, 168 hr ⁸	2.9		

Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (392°F, 206 sec ⁻¹)	330	Pa·s	ASTM D3835

Legal Statement

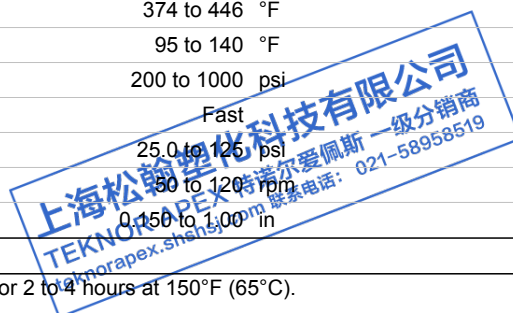
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Processing Information

Injection	Nominal Value	Unit
Rear Temperature	344 to 416	°F
Middle Temperature	354 to 426	°F
Front Temperature	364 to 436	°F
Nozzle Temperature	374 to 446	°F
Processing (Melt) Temp	374 to 446	°F
Mold Temperature	95 to 140	°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).



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Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	330 to 400	°F
Cylinder Zone 2 Temp.	340 to 410	°F
Cylinder Zone 3 Temp.	350 to 420	°F
Cylinder Zone 5 Temp.	360 to 430	°F
Die Temperature	374 to 440	°F

Extrusion Notes

Screw Speed: 30 to 100 rpm

Notes

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

² Type 1, 20 in/min

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

⁴ Type A

⁵ Type 1

⁶ 1 sec

⁷ 5 sec

⁸ 15 sec

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