

# Sarlink® TPE EE-1290N NAT

Teknor Apex Company - Thermoplastic Elastomer

Thursday, June 29, 2017

## General Information

### General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• High Density		
Uses	• Automotive Applications • Automotive Exterior Parts	• Automotive Exterior Trim • General Purpose	
RoHS Compliance	• RoHS Compliant		
Automotive Specifications	• ASTM D4000		
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Extrusion		

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

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.18		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	0.60	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus	270	psi	ASTM D790
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (100% Strain)	660	psi	ASTM D412
Tensile Strength (Break)	1800	psi	ASTM D412
Tensile Elongation (Break)	550	%	ASTM D412
Tear Strength <sup>2</sup>	270	lbf/in	ASTM D1004
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 15 sec)	90		ASTM D2240

## Processing Information

Injection	Nominal Value	Unit
Rear Temperature	390 to 410	°F
Middle Temperature	400 to 420	°F
Front Temperature	410 to 430	°F
Nozzle Temperature	420 to 440	°F
Processing (Melt) Temp	420 to 440	°F
Mold Temperature	95 to 150	°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

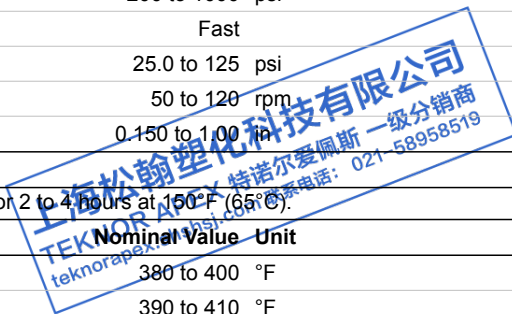
### Injection Notes

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.	380 to 400	°F
Cylinder Zone 2 Temp.	390 to 410	°F
Cylinder Zone 3 Temp.	400 to 420	°F

Revision Date: 6/1/2016



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Extrusion	Nominal Value	Unit
Cylinder Zone 5 Temp.	410 to 430	°F
Die Temperature	420 to 440	°F

### Extrusion Notes

Screw Speed: 30 to 100 rpm

### Notes

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

<sup>2</sup> Die C

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