

SARLINK® 3460 is a NSF* certified, low hardness and multi-purpose thermoplastic elastomer (black and natural color) featuring excellent fluid resistance and high temperature performance. It can be processed by injection molding, blow molding or extrusion for applications in contact with potable water, such as pipes, fittings and appurtenances.

Typical properties**	Test method	S.I.		U.S.	
		Typical value	Units	Typical value	Units
Hardness Shore A (5 sec) Injection molded sample Extruded sample	ASTM D-2240, 5 sec. Delay 5 sec. Delay	66	--	66	--
		62	--	62	--
Specific Gravity	ASTM D-792	0.95	--	0.95	--
Stress/Strain properties <u>Flow direction</u> Tensile strength Modulus at 100% Elongation at break <u>Cross direction</u> Tensile strength Modulus at 100% Elongation at break	ASTM D-412, Die C				
		4.2	MPa	609	Psi
		2.9	MPa	421	Psi
		353	%	353	%
		6.2	MPa	899	Psi
		2.4	MPa	348	Psi
Tear Strength <u>Cross direction</u> Unnicked	ASTM D-624, Die C				
		32	kN/m	182	Pli
Compression set 22h/23°C 22h/70°C 22h/100°C	ASTM D-395, Method B				
		23	%	23	%
		38	%	38	%
		41	%	41	%

* Complies with NSF standards 61: Piping related system components for drinking water with surface area to volume ratio of 100 square inches per liter at hot temperature.

** Tests are conducted on injection molded plaques unless indicated otherwise.

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SARLINK® 3460 is a polypropylene based elastomer, which can be processed on conventional thermoplastic equipment for injection molding, extrusion and blow molding. This product has a wide processing window in most applications. Melt temperatures from 360°F to 430°F can be used. Do not exceed 450°F. Drying is recommended for extrusion and blow molding and any time the material is used from an unsealed package. Dry three (3) hours at 180°F. Drying is best accomplished in a desiccant dryer.

INJECTION MOULDING CONDITIONS			EXTRUSION CONDITIONS		
Melt temperature		360-430°F	Melt temperature		380-420°F
Barrel Temperatures	Rear Middle Front Nozzle	350-420°F 350-420°F 350-420°F 370-430°F	Barrel Temperatures	Rear Transition Metering Front Die	360-400°F 360-400°F 370-410°F 370-410°F 380-420°F
Mould temperature		50-150°F			
Screw Speed		100-200 RPM	Roll Temperature		70-120°F
Back Pressure		10-150 psi	Screen Pack		20 to 60 mesh
Screw	General Purpose 20:1 L/D ratio		Screw	General Purpose 3:1 compression ratio	

PURGING

SARLINK® 3460 has excellent melt stability. Empty the barrel for idle periods of thirty (30) minutes or longer. Purge thoroughly before and after use of this product with polyethylene or polypropylene.

RECYCLING/REGRIND

This product can be reprocessed. Physical properties are generally not degraded. Dry regrind prior to reprocessing. Drying is best accomplished in a desiccant dryer.

COLORING

The use of polyolefin based color concentrates is recommended. Apply back pressure in injection molding to disperse color.

STORAGE & HANDLING

SARLINK® 3460 is available in 55 lb. foil lined bags (up to 2,200 lbs. per pallet) or 1,100 lb. polyethylene lined gaylords. It has a storage life at normal temperatures of several years. Please refer to the Material Safety Data Sheet for this grade prior to first time handling.

