



Ellexar® EL-1402N

Teknor Apex Company - Thermoplastic Elastomer

General Information

General			
Material Status	• Preliminary Data		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Filled • Good Colorability • Good Moldability • Halogen Free	• High Flow • Medium Density • Medium Hardness • Slip	• Specialty Grade • Sunlight Resistant • UV Resistant
Uses	• Cable Jacketing • Connectors • Flexible Cord Jacketing	• Strain Reliefs • Terminal Cable Jacketing • Wire & Cable Applications	• Wire Jacketing
RoHS Compliance	• RoHS Compliant		
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.08		ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	30	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength (Break)	770	psi	ASTM D412
Tensile Elongation (Break)	540	%	ASTM D412
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	80		ASTM D2240
Thermal	Nominal Value	Unit	Test Method
Brittleness Temperature	-56.2	°F	ASTM D746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.12 in, NC)	V-0		UL 94
Oxygen Index	30	%	ASTM D2863

Processing Information

Injection	Nominal Value	Unit
Rear Temperature	390 to 420	°F
Middle Temperature	415 to 430	°F
Front Temperature	430 to 440	°F
Nozzle Temperature	430 to 445	°F
Processing (Melt) Temp	430 to 445	°F
Mold Temperature	77 to 150	°F

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Injection	Nominal Value	Unit
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.	380 to 410	°F
Cylinder Zone 2 Temp.	390 to 420	°F
Cylinder Zone 3 Temp.	415 to 430	°F
Cylinder Zone 5 Temp.	430 to 440	°F
Die Temperature	430 to 445	°F

Extrusion Notes

Screw Speed: 30 to 100 rpm

Notes

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