+135-3858-6433 (GuangDong)
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TEKNOR APEX

Telcar® TL EF-6100

Teknor Apex Company - Thermoplastic Elastomer

General Information

Product Description

Telcar TL EF-6100 is a general purpose thermoplastic elastomer, available in Nat and colors, designed for the industrial market. Telcar TL EF-6100 is a high hardness, medium density grade suitable for injection molding and extrusion.

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Bondability • Filled • Good Colorability	• Good Mold Release • Good Moldability • Good Processability	• High Hardness • Medium Density • Medium Flow
Uses	• General Purpose • Grommets	• Industrial Applications • Weatherstripping	
RoHS Compliance	• RoHS Compliant		
Appearance	• Colors Available • Grey	• Natural Color • Opaque	• Yellow
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.00		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	7.0	g/10 min	ASTM D1238
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress [2]			ASTM D412
Across Flow : 100% Strain	1010	psi	
Flow : 100% Strain	1470	psi	
Tensile Stress [2]			ASTM D412
Across Flow : 300% Strain	1110	psi	
Flow : 300% Strain	1530	psi	
Tensile Strength [2]			ASTM D412
Across Flow : Break	2210	psi	
Flow : Break	1590	psi	
Tensile Elongation [2]			ASTM D412
Across Flow : Break	850	%	
Flow : Break	300	%	
Tear Strength [2]			ASTM D624
Across Flow	327	lbf/in	
Flow	408	lbf/in	
Compression Set [3]			ASTM D395B
73°F, 22 hr	36	%	
158°F, 22 hr	67	%	
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness			ASTM D2240
Shore A, 1 sec, Injection Molded	91		
Shore A, 5 sec, Injection Molded	89		

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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.	350 to 390	°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