



Telcar® TELC-340

Teknor Apex Company - Thermoplastic Elastomer

General Information

Product Description

Telcar TELC-340 is a general purpose thermoplastic elastomer designed for the consumer and industrial markets. Telcar TELC-340 is a high hardness, low density grade that is suitable for extrusion and injection molding.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Bondability • Good Colorability • Good Flow • Good Melt Strength	• Good Mold Release • Good Moldability • Good Processability • Good Processing Stability	• High Hardness • Low Density • Low Specific Gravity • Without Fillers
Uses	• General Purpose	• Industrial Applications	• Profiles
RoHS Compliance	• RoHS Compliant		
Appearance	• Colors Available	• Natural Color	• Translucent
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.890		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	5.0	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus	25000	psi	ASTM D790
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ISO 37
Across Flow : 100% Strain	905	psi	
Flow : 100% Strain	1210	psi	
Tensile Strength			ISO 37
Across Flow : Break	1810	psi	
Flow : Break	1440	psi	
Tensile Elongation			ISO 37
Across Flow : Break	810	%	
Flow : Break	560	%	
Tear Strength - Across Flow	423	lbf/in	ISO 34
Compression Set ² (73°F, 22 hr)	57	%	ISO 815
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			
Shore A, Instant	94		ISO 868
Shore D, Injection Molded	36		ASTM D2240
Thermal	Nominal Value	Unit	Test Method
Brittleness Temperature	< -58.0	°F	ASTM D746

Telcar® TELC-340

Teknor Apex Company - Thermoplastic Elastomer

Aging	Nominal Value	Unit	Test Method
Change in Tensile Strength in Air			ISO 188
230°F, 1008 hr	-7.2	%	
257°F, 168 hr	-4.0	%	
Change in Tensile Strain at Break in Air - Across Flow			ISO 188
230°F, 1008 hr	-14	%	
257°F, 168 hr	-8.3	%	
Change in Shore Hardness in Air			ISO 188
Shore A, 230°F, 1008 hr	-0.20		
Shore A, 257°F, 168 hr	0.50		
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (392°F, 206 sec ⁻¹)	322	Pa·s	ASTM D3835

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
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 Method A