



# Telcar® TL-2535F

Teknor Apex Company - Thermoplastic Elastomer

## General Information

### Product Description

Telcar® TL-2535F is a general purpose thermoplastic elastomer designed for a variety of industrial applications. Telcar® TL-2535F is a high density, low hardness grade suitable for injection molding.

### General

|                   |                                                                      |                                                         |                                                   |
|-------------------|----------------------------------------------------------------------|---------------------------------------------------------|---------------------------------------------------|
| Material Status   | • Commercial: Active                                                 |                                                         |                                                   |
| Availability      | • Africa & Middle East<br>• Asia Pacific                             | • Europe<br>• Latin America                             | • North America                                   |
| Features          | • Filled<br>• Good Mold Release<br>• Good Moldability                | • High Density<br>• High Specific Gravity<br>• Low Flow | • Low Hardness                                    |
| Uses              | • Construction Applications<br>• Flexible Grips<br>• General Purpose | • Grommets<br>• Handles<br>• Industrial Applications    | • Rubber Replacement<br>• Soft Touch Applications |
| RoHS Compliance   | • RoHS Compliant                                                     |                                                         |                                                   |
| Appearance        | • Opaque                                                             |                                                         |                                                   |
| Forms             | • Pellets                                                            |                                                         |                                                   |
| Processing Method | • Extrusion                                                          | • Injection Molding                                     |                                                   |

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

| Physical                                  | Nominal Value | Unit     | Test Method |
|-------------------------------------------|---------------|----------|-------------|
| Density / Specific Gravity                | 1.18          |          | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (190°C/2.16 kg) | 1.0           | g/10 min | ASTM D1238  |
| Elastomers                                | Nominal Value | Unit     | Test Method |
| Tensile Strength (Break)                  | 785           | psi      | ASTM D412   |
| Tensile Elongation (Break)                | 700           | %        | ASTM D412   |
| Hardness                                  | Nominal Value | Unit     | Test Method |
| Durometer Hardness (Shore A)              | 38            |          | ASTM D2240  |

## 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  |

| Injection   | Nominal Value | Unit |
|-------------|---------------|------|
| Screw Speed | 50 to 100     | rpm  |
| Cushion     | 0.150 to 1.00 | in   |

### Notes

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