



Telcar® TL-355

Teknor Apex Company - Thermoplastic Elastomer

General Information

Product Description

Telcar TL-355 is a general purpose thermoplastic elastomer designed for consumer/industrial applications. Telcar TL-355 is a low density, high hardness grade suitable for both injection molding and extrusion.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Filled • High Hardness	• Low Density • Low Specific Gravity	• Medium Flow • Medium Slip
Uses	• Blow Molding Applications • General Purpose	• Grommets • Rubber Replacement	
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	0.940		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	9.0	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ²			ASTM D412
Across Flow : 100% Strain	1750	psi	
Flow : 100% Strain	1990	psi	
Tensile Strength ²			ASTM D412
Across Flow : Break	1760	psi	
Flow : Break	2030	psi	
Tensile Elongation ²			ASTM D412
Across Flow : Break	180	%	
Flow : Break	220	%	
Tear Strength ²			ASTM D624
Across Flow	452	lbf/in	
Flow	515	lbf/in	
Compression Set ³			ASTM D395B
73°F, 22 hr	41	%	
158°F, 22 hr	79	%	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore D, 1 sec, Injection Molded	44		
Shore D, 5 sec, Injection Molded	42		

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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.	360 to 400	°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