



Telcar® TL-86-K902A

Teknor Apex Company - Thermoplastic Elastomer

General Information

Product Description

Telcar TL-86-K902A is a general purpose thermoplastic elastomer designed for the industrial market. Telcar TL-86-K902A is high density, medium 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	• Bondability • Filled • Good Colorability • Good Melt Strength • Good Mold Release	• Good Moldability • Good Processability • High Density • High Specific Gravity • Light Stabilized	• Low Flow • Medium Hardness • Slip
Uses	• Building Materials • Glazing	• Industrial Applications • Windows & Doors	
RoHS Compliance	• RoHS Compliant		
Appearance	• Colors Available	• Natural Color	• Opaque
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.18		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	0.40	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ²			ASTM D412
Across Flow : 100% Strain	392	psi	
Flow : 100% Strain	770	psi	
Tensile Stress - Across Flow ² (300% Strain)	568	psi	ASTM D412
Tensile Strength ²			ASTM D412
Across Flow : Break	1570	psi	
Flow : Break	895	psi	
Tensile Elongation ²			ASTM D412
Across Flow : Break	710	%	
Flow : Break	280	%	
Tear Strength ²			ASTM D624
Across Flow	215	lbf/in	
Flow	191	lbf/in	
Compression Set ³			ASTM D395B
73°F, 22 hr	25	%	
158°F, 22 hr	46	%	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 sec, Injection Molded	77		
Shore A, 15 sec, Injection Molded	75		

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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