



Sarlink® TPE ML-2355B (PRELIMINARY DATA)

Teknor Apex Company - Thermoplastic Elastomer

General Information

Product Description

Sarlink TPE ML-2355B is a high performance thermoplastic elastomer designed for molding complex automotive applications. Sarlink TPE ML-2355B is a medium hardness, high density grade having good UV resistance, excellent molding behavior, and faster cycle times versus TPV's.

General

Material Status	• Preliminary Data		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Chemical Resistant • Good Adhesion • Good Flow • Good Moldability	• Good Processability • High Density • High Specific Gravity • Low Fogging	• Medium Hardness • UV Resistant
Uses	• Automotive Applications	• Automotive Interior Parts	• Rubber Replacement
RoHS Compliance	• RoHS Compliant		
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.07	g/cm ³	ISO 1183
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress - Across Flow (100% Strain)	1.20	MPa	ISO 37
Tensile Strength - Across Flow (Break)	7.80	MPa	ISO 37
Tensile Elongation - Across Flow (Break)	850	%	ISO 37
Compression Set (70°C, 22 hr)	40	%	ISO 815
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 5 sec, Injection Molded)	55		ISO 868
Additional Information	Nominal Value	Unit	Test Method
Apparent Shear Viscosity - Capillary, 206 1/s (200°C)	168	Pa·s	ISO 11443

Processing Information

Injection	Nominal Value	Unit
Rear Temperature	170 to 180	°C
Middle Temperature	180 to 200	°C
Front Temperature	200 to 220	°C
Nozzle Temperature	210 to 230	°C
Processing (Melt) Temp	200 to 230	°C
Mold Temperature	10 to 60	°C
Injection Pressure	6.00 to 12.0	MPa
Injection Rate	Fast	

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Injection	Nominal Value	Unit
Holding Pressure	4.00 to 6.00	MPa
Back Pressure	0.500 to 2.00	MPa
Screw Speed	50 to 120	rpm

Injection Notes

Drying is not necessary. However, if moisture is a problem, dry the pellets 2 to 4 hours at 65 degrees Celsius.

Time Settings

Injection Time: 0.5-2 seconds

Holding Time: 1-10 seconds

Cooling Time: As short as possible. The parts should be removable without deformation or piercing of the ejector(s)

Notes

¹ Typical properties: these are not to be construed as specifications.