

T-BLEND® is a series of thermoplastic rubber compound materials produced by TSRC CORPORATION.

With the advantages of weather durable, rebound resilience, compression and bending properties, **T-BLEND® 1000-50T** may be applied to a variety of unique products by injection molding machine.

T-BLEND® 1000-50T is a palletized elastomer compound based on styrenic block copolymer.

T-BLEND® 1000-50T thermoplastic elastomer compound is recyclable including wastes from gate and runner.

Physical Properties :

Characteristics	Methods	Conditions	Units	Values
Form	N/A	--	-	Pellets
Color	N/A	--	-	Translucent
SP.GR/Density	ASTM D792	--	-	0.91~0.95
Hardness (Shore A)	ASTM D2240	A Type	Shore A	47~53
Tensile strength at break	ASTM D412	Type 3, specimen	kg/cm ²	≥ 40
Elongation at break	ASTM D412	500 mm/min	%	≥ 750
300% Modulus	ASTM D412	500 mm/min	kg/cm ²	-
Tear strength	ASTM D624	C Die	kg/cm	≥ 18
Melt flow index	ASTM D1238	2.16 kg@180°C	g/10 min	25~45
Rebound	ASTM D2632	--	%	≥ 60
Shrinkage	N/A	50°C*40 mins	%	≤ 2
Light fastness (UV)	TSRC Method	30W*253.7 nm UV light*4 hrs	Grade	4

Remarks : 1 MPa = 10.2 kg/cm² ;
1 kg/cm² = 14.2 psi ◦



Processing Guide:

Drying:

Under general storing condition, **T-BLEND® 1000-50T** can not absorb moisture, so pre-drying is unnecessary before processing. If the environment is humid or surface performance parts are required, please dry the pellets in hot air circulating oven/hopper (70°C) for 2 hours.

Injection machine / Screw:

Injection molding machine with L/D ratio (15:1~), CR (2:1 or 3: 1) and Shallow depth screw on metering section would be better for processing.

Barrel Temperature:

Information below is our molding guide, but actual operation should rely on your processing experience.

Items	Values	
Barrel Temp. (°C)	Feed	~160
	Rear	170
	Front	180
	Nozzle	190
Mold Temp. (°C)	30 ~ 40	
Back Pressure(kg/cm ²)	3.5 ~ 7	
Injection speed	General	
Cycle (sec)	25 ~ 50	

Others :

The molding shrinkage of **T-BLEND® 1000-50T** is approximately between 0.015 ~ 0.025 inch/inch.

