台橡股份有限公司
TSRC CORPORATION

T-BLEND® 2108-65T
Thermoplastic Elastomer
Technical Data Sheet

T-BLEND® 2108-65T is a pre-formulated and pelletized general-purpose thermoplastic elastomer compound based on styrene ethylene-butylene styrene (SEBS).
It is designed for the over-molding of soft-touch elastomer components onto hard olefin thermoplastics such as PP, PE resins.
This material exhibits excellent flow properties and offers molded articles with fine texture, dry surface and excellent rubbery feeling.
Being a thermoplastic elastomer, **T-BLEND® 2108-65T** can be easily processed with general processing equipment and tools designed for thermoplastics and yet possess elastomeric properties at ambient temperatures.

Physical Properties:

Properties	Testing Method	Conditions	Units	Values
Product form	N/A	--	--	Pellets
Color	N/A	--	--	Natural
Specific gravity	ASTM D792	--	--	0.85~0.91
Hardness	ASTM D2240	A Type	Shore A	63~69
Melt Flow Index	ASTM D1238	5 kg @ 180℃	g/10min	25~75
Tensile strength at break	ASTM D412	500 mm/min	kg/cm^2	46 Typical
Elongation at break	ASTM D412	500 mm/min	%	236 Typical
Tear strength	ASTM D624	C Die	kg/cm	27 Typical

Processing Guide :

T-BLEND® 2108-65T rubber is a versatile material and can be processed by using high shear rate injection molding methods.
Stability of **T-BLEND® 2108-65T** is excellent at normal processing temperatures. However should inadvertent loss of temperature control lead to decomposition the degradation products are non-
corrosive. Generally, it reacts the same as other easy molding thermoplastics. The finished parts have sharp and well defined details.

Typical starting conditions for a reciprocating screw injection molding machine are listed in the accompanying chart. These values are intended only as guidelines, and the optimum conditions will vary from machine to machine.

Typical mold shrinkage for **T-BLEND® 2108-65T** is between 0.015-0.025 inch/inch. Short cycle time can be achieved and the scrap is recyclable.

LDPE or EVA color concentrates can be used to color **T-BLEND® 2108-65T**.

Suggested Processing Conditions	
Barrel temperature	
Feed	160ºC
Rear	170ºC
Front	180ºC
Nozzle	190ºC
Mold temperature	30~40ºC
Back pressure	50~100 psi
Injection rate	Moderate
Cycle time	35~45 sec

(1 kg/cm^2=14.223 psi)