



## T-BLEND® 6594-65B Thermoplastic Rubber(TPR/TPE) Technical Data Sheet

**T-BLEND®** is a series of thermoplastic elastomer compound materials produced by TSRC (Shanghai) Industries LTD.

**T-BLEND® 6594-65B** can be used for plastic overmolding application, also can be used for molding directly.

**T-BLEND® 6594-65B** can be used Injection molding method of machining , It has weathering resistance, flexibility,ex.

### Physical Properties:

PROPERTIES	TESTING METHOD	CONDITIONS	UNITS	VALUES
<b>Form</b>	N/A	--	--	Pellets
<b>Colour</b>	N/A	--	--	Black
<b>Hardness (Shore)</b>	ASTM D2240	A Type	Shore A	62-68
<b>Melt Flow Index</b>	ASTM D1238	180°C*5kg	g/10min	30-70
<b>SP.GR/Density</b>	ASTM D792	--	--	0.98-1.02
<b>Tensile Strength</b>	ASTM D412	Type3, specimen	kg/cm <sup>2</sup>	35
<b>Elongation</b>	ASTM D412	Crosshead	%	450
<b>300% Modulus</b>	ASTM D412	500mm/min	kg/cm <sup>2</sup>	30
<b>Tear Strength</b>	ASTM D624	C Die	kg/cm	20

### Processing Guide :

#### Drying :

Under general storing condition, **T-BLEND® 6594-65B** can absorb moisture, so pre-drying is necessary before processing. Please dry the pellets in hot air circulating oven/hopper (80°C) for 1~2 hours.

#### Injection Machine / Screw :

With L/D ratio 15:1 or more would be better. The compression ratio (CR) is 2:1 or 3:1 and Shallow depth screw on metering section would be better for processing.

#### Barrel Temperature :

Information below is our injection-molding guide

Items		Values
<b>Barrel Temp.</b> (°C)	Feed	~220
	Rear	250
	Front	250
	Die	260
Molding (°C)		30 ~ 40
Back Pressure (Kg/cm <sup>2</sup> )		3.5 ~ 7
Injection Speed		General
Cycle (sec)		25 ~ 50

**Other: T-BLEND® 6594-65B** Molding shrinkage rate is 0.015 ~ 0.025 inch/inch

