



T-BLEND® 2104-45N
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® 2104-45N Can be used for plastic overmolding application, also can be used for molding directly.

T-BLEND® 2104-45N Can be used Injection molding method of machining , It has weathering resistance, flexibility,ex.

Physical Properties:

PROPERTIES	TESTING METHOD	CONDITIONS	UNITS	VALUEs
Form	N/A	--	--	Pellets
Colour	N/A	--	--	Natural
Hardness (Shore)	ASTM D2240	A Type	Shore A	42-48
Melt Flow Index	ASTM D1238	180℃@5 kg	g/10min	20-60
SP.GR/Density	ASTM D792	--	--	1.03-1.07
Tensile Strength	ASTM D412	Type3, specimen	kg/cm ²	20
Elongation	ASTM D412	Crosshead	%	500
300% Modulus	ASTM D412	500mm/min	kg/cm ²	15
Tear Strength	ASTM D624	C Die	kg/cm	15

Processing Guide :

Drying :

Under general storing condition, **T-BLEND® 2104-45N** can absorb moisture, so pre-drying is necessary before processing. Please dry the pellets in hot air circulating oven/hopper (80℃) 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
Barrel Temp. (°C)	Feed	~150
	Rear	175
	Front	180
	Die	185
Molding (°C)		30 ~ 40
Back Pressure (Kg/cm ²)		3.5 ~ 7
Injection Speed		General
Cycle (sec)		25 ~ 50

Other: **T-BLEND® 2104-45N** Molding shrinkage rate is 0.015 ~ 0.025 inch/inch

