

**T-BLEND®** is a series of thermoplastic elastomer compound materials produced by TSRC Corporation.

**T-BLEND® 2102-60B** Can be used for plastic overmolding application, also can be used for molding directly.

**T-BLEND® 2102-60B** Can be used Injection molding method of machining, It has weathering resistance, flexibilities.

### Physical Properties:

PROPERTIES	TESTING METHOD	CONDITIONS	UNITS	VALUEs
Form	N/A	--	--	Pellets
Colour	N/A	--	--	Black
Hardness (Shore)	ASTM D2240	A Type	Shore A	57-63
Melt Flow Index	ASTM D1238	180°C *5kg	g/10min	60-140
SP.GR/Density	ASTM D792	--	--	0.99-1.03
Tensile Strength	ASTM D412	Type3, specimen	kg/cm <sup>2</sup>	30
Elongation	ASTM D412	Crosshead	%	550
300% Modulus	ASTM D412	500mm/min	kg/cm <sup>2</sup>	25
Tear Strength	ASTM D624	C Die	kg/cm	25

### Processing Guide:

#### Drying:

Under general storing condition, **T-BLEND® 2102-60B** 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
Barrel Temp. (°C)	Feed	~150
	Rear	175
	Front	180
	Die	185
Molding (°C)		30 ~ 40
Back Pressure (Kg/cm <sup>2</sup> )		3.5 ~ 7
Injection Speed		General
Cycle (sec)		25 ~ 50

**Other: T-BLEND® 2102-60B** Molding shrinkage rate is 0.015 ~ 0.025 inch/inch

