

**T-BLEND® 2002-10S** is a pre-formulated and pelletized thermoplastic elastomer compound based on styrene butadiene block copolymer. Thanks to its high strength and clarity. It is designed for the injection molding of non-toxic toy components and infant product parts with improved tear and torque resistance.

Being a thermoplastic elastomer, **T-BLEND® 2002-10S** 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
Form	N/A	--	--	Pellets
Color	N/A	--	--	Blue
SP.GR/Density	ASTM D792	--	--	0.84~0.90
Hardness	ASTM D2240	Type OO	Shore OO	52~58
Melt Flow Index	ASTM D1238	2.16 kg @ 160°C	g/10min	35~75

### Processing Guide :

**T-BLEND® 2002-10S** rubber is a versatile material and can be processed by using high shear rate injection molding methods.

**T-BLEND® 2002-10S** 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, such as polystyrenes. 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® 2002-10S** is between 0.008-0.015 inch/inch. Short cycle time can be achieved and the scrap is 20% recyclable without loss in properties.

PS or EVA color concentrates can be used to color **T-BLEND® 2002-10S**.

Items		Values
<b>Barrel Temp. (°C)</b>	Feed	130
	Rear	140
	Front	150
	Die	160
Molding temperature (°C)		30 ~ 40
Back Pressure (kg/cm <sup>2</sup> )		3.5 ~ 50
Injection Speed		Moderate
Cycle (sec)		35 ~ 50

(1 kg/cm<sup>2</sup> = 14.223 psi)

### Precaution in handling and storing :

**T-BLEND® 2002-10S** rubber pellets present no unusual handling problems, thus normal procedures for handling solids that might form a dust should be followed.

