

Tekbond® TB-6000-45

 Teknor Apex Company - *Thermoplastic Elastomer*

 Unit System:
Actions

 Legend ([Open](#))

General Information
General

Material Status	● Commercial: Active
Availability	<ul style="list-style-type: none"> ● Africa & Middle East ● Asia Pacific ● Europe ● Latin America ● North America ● South America
Uses	<ul style="list-style-type: none"> ● Appliances ● Automotive Interior Parts ● Bonding ● Cell Phones ● Dental Applications ● Flexible Grips ● Handles ● Knobs ● Overmolding ● Power/Other Tools ● Sporting Goods ● Toothbrush Handles ● Writing Instruments
Automotive Specifications	● CHRYSLER MS-DB590 CPN4548
Appearance	● Opaque
Forms	● Pellets
Processing Method	● Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.998	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	15	g/10 min	ASTM D1238
Molding Shrinkage - Flow	3.2	%	ASTM D955
Molding Shrinkage - Across Flow	2.1	%	ASTM D955
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength (Break)	5.52	MPa	ASTM D412
Tensile Elongation (Break)	500	%	ASTM D412
Compression Set (23°C)	20	%	ASTM D395
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	45		ASTM D2240
Flammability	Nominal Value	Unit	Test Method
Flame Rating - UL	HB		UL 94

Additional Properties

The value listed as Compression Set ASTM D395, was tested in accordance with ASTM D412.

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	65.6	°C
Drying Time	2.0 to 4.0	hr
Rear Temperature	204 to 232	°C
Middle Temperature	210 to 232	°C
Front Temperature	216 to 238	°C
Nozzle Temperature	221 to 243	°C
Processing (Melt) Temp	221 to 243	°C
Mold Temperature	23.9 to 60.0	°C
Injection Pressure	1.38 to 6.89	MPa
Injection Rate	Fast	
Back Pressure	0.172 to 0.862	MPa
Screw Speed	50 to 120	rpm
Cushion	3.81 to 25.4	mm

Notes
¹ Typical properties: these are not to be construed as specifications.

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