

TC6MLZ (AD1 Series)
THERMOLAST® K
Applications with adhesion to polar thermoplastics such as ABS, PC and PC/ABS
Typical applications

- Bumpers
- Door sills
- Function and design elements
- Grommets
- Handles (hand tools and power tools etc.)
- Seals
- Thumb wheels

Material advantages

- Easy coloring
- Excellent adhesion
- Excellent processing behavior
- Insert molding possible
- Pleasant surface feel (Soft touch)
- Suitable for automotive-interior
- UL 94 HB listed
- UV resistance

Processing Method: Injection Molding

Product properties

Compound name	TC6MLZ
Series	AD1
Color	black

Mechanical properties

Hardness Shore A	59 ShoreA	DIN ISO 7619
Density	1.100 g/cm ³	DIN EN ISO 1183-1
Tensile Strength ¹	4.5 MPa	DIN 53504 / ISO 37
Elong. at Break S2 ¹	550 %	DIN 53504 / ISO 37
Tear Resistance	16.5 N/mm	DIN ISO 34-1
Adhesion Renault D41 1916 (ABS) ²	4.0 N/mm	
Adhesion Renault D41 1916 (PC) ²	5.5 N/mm	

¹ Deviating from ISO 37 standard test piece S2 is tested with a traverse speed of 200 mm/min.

² The adhesion quality depends on mold design, product geometry and process parameters.

All values published in this data sheet are rounded average values.
 Specification limits are based on three-fold standard deviation from the average value.

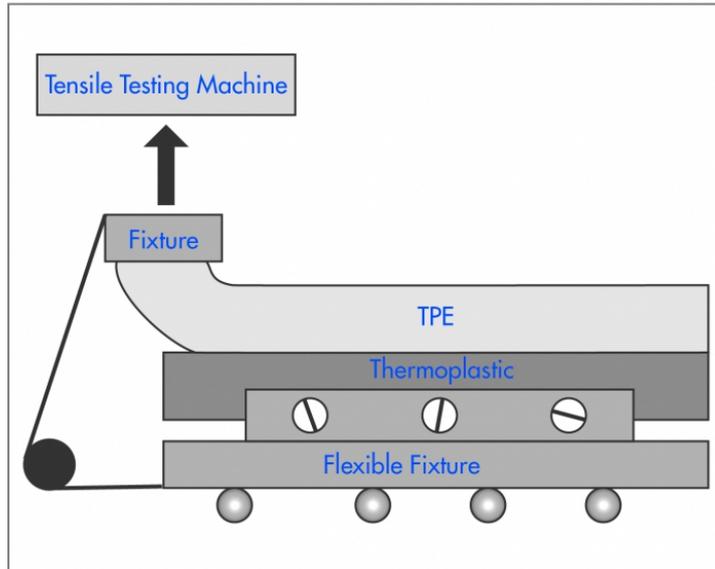
This datasheet is an extract of the KRAIBURG TPE program. Please contact KRAIBURG TPE to select the compound suitable for the requirements.

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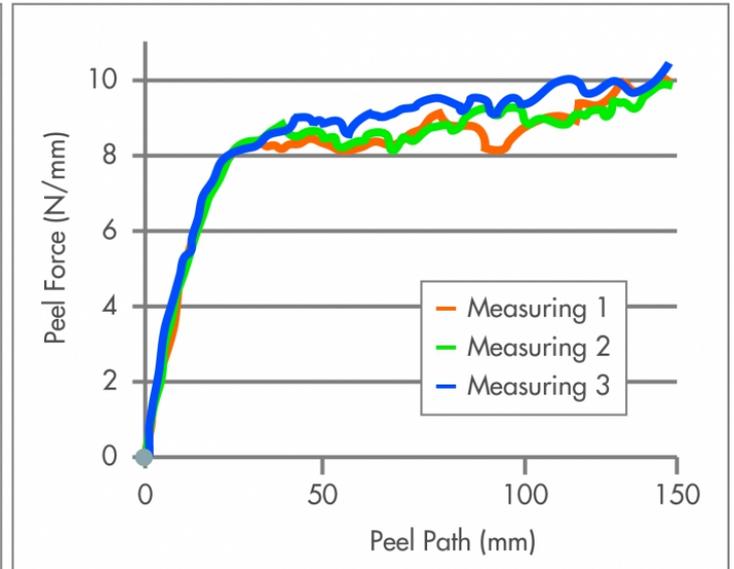
Description peel test

Peel test according to „Renault D41 1916“ standard

Test Setup



Example Diagramm as result of a peel test



The peel force is measured by a tensile testing machine in N/mm, in relation to the peel path. Test piece dimensions: Thermoplastic part: 130 x 22 x 2 mm, TPE part: 130 x 20 x 2 mm.

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Processing Guideline Injection Molding

Cylinder temperature	240 - 210 - 180 °C max. 250 °C (464 - 410 - 356 °F, max. 482 °F)
Hotrunner	Hot runner temperatures: 200 -250 °C (390 - 480 °F). The runner should be empty after a maximum of 2 - 3 shots.
Injection pressure	200 - 1000 bar (2900 - 14504 psi) (depending on the size and weight of the part).
Injection rate	In general, the fill time should not be more than 1–2 seconds.
Hold pressure	We recommend to derive the optimum hold pressure from determining the solidification point, starting with 40 % - 60 % of the required injection pressure.
Back pressure	20 - 50 bar (285 - 710 psi); if colour batches are used, higher back pressure is necessary.
Screw retraction	If an open nozzle is used processing with screw retraction is advisable.
Mold temperature	The mold temperature depends on the hard component. A temperature exceeding 80 °C (175 °F) should be avoided. The common temperature is 40 - 60 °C (105 - 140° F).
Pre drying	To achieve optimum mechanical values, drying the material for 2 - 4 hours at 60 - 80 °C (140 - 175 °F) is recommended.
Needle shut-off	With materials < 50 Shore the use of a needle seal nozzle is advisable.
Screw geometry	Standard 3-zone polyolefine screw.
Residence time	The residence time is to be set as short as possible with a maximum of 10 minutes.
Cleaning recommendation	For cleaning and purging of the machine it is appropriate to use polypropylene or polyethylene. Machine must be PVC-free.

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