Sarlink® TPE ML-1690B BLK

Teknor Apex Company - Thermoplastic Elastomer

Friday, April 3, 2026

General Information

Product Description

Sarlink ML-1690B BLK is a general purpose TPE designed for automotive interior applications. This is a high hardness, medium density grade suitable for injection molding. This high flow TPE exhibits improved moldability and surface appearance.

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Filled • Good Mold Release • Good Moldability	• Good Processability • High Flow • High Hardness	• Medium Density
Uses	• Automotive Applications • Automotive Interior Parts	• General Purpose • Grommets	
RoHS Compliance	• RoHS Compliant		
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.00	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	24	g/10 min	ASTM D1238
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress [2]			ISO 37
Across Flow : 100% Strain	711	psi	
Flow : 100% Strain	895	psi	
Tensile Stress [2]			ISO 37
Across Flow : Break	1170	psi	
Flow : Break	1460	psi	
Tensile Elongation [2]			ISO 37
Across Flow : Break	590	%	
Flow : Break	580	%	
Tear Strength [3]			ISO 34-1
Across Flow	273	lbf/in	
Flow	219	lbf/in	
Compression Set [4]			ISO 815
73°F, 22 hr	38	%	
158°F, 22 hr	62	%	
194°F, 70 hr	76	%	
257°F, 70 hr	100	%	
Hardness	**Nominal Value**	**Unit**	**Test Method**
Shore Hardness			ISO 868
Shore A, 1 sec, Injection Molded	92		
Shore A, 5 sec, Injection Molded	91		
Shore A, 15 sec, Injection Molded	90		

Revision Date: 6/24/2019

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Aging	Nominal Value	Unit	Test Method
Change in Tensile Strength in Air [5]			ISO 188
Across Flow : 230°F, 1008 hr	3.3	%	
Flow : 230°F, 1008 hr	-3.6	%	
Across Flow : 100% Strain 230°F, 1008 hr	9.7	%	
Flow : 100% Strain 230°F, 1008 hr	13	%	
Across Flow : 257°F, 168 hr	15	%	
Flow : 257°F, 168 hr	-3.2	%	
Across Flow : 100% Strain 257°F, 168 hr	12	%	
Flow : 100% Strain 257°F, 168 hr	15	%	
Change in Tensile Strain at Break in Air [5]			ISO 188
Across Flow : 230°F, 1008 hr	-5.1	%	
Flow : 230°F, 1008 hr	-4.8	%	
Across Flow : 257°F, 168 hr	8.8	%	
Flow : 257°F, 168 hr	-2.0	%	
Change in Shore Hardness in Air			ISO 188
Shore A, 230°F, 1008 hr [6]	0.90		
Shore A, 230°F, 1008 hr [7]	0.50		
Shore A, 230°F, 1008 hr [8]	0.0		
Shore A, 257°F, 168 hr [6]	-0.30		
Shore A, 257°F, 168 hr [7]	-0.80		
Shore A, 257°F, 168 hr [8]	-1.6		

Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (392°F, 206 sec^-1)	133	Pa·s	ASTM D3835

Additional Information	Nominal Value	Unit	Test Method
Xenon Weatherometer			SAE J1885
Delta E - 1250 kJ	1.00		
Delta E - 2500 kJ	1.65		

Legal Statement

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Processing Information

Injection	Nominal Value	Unit
Rear Temperature	340 to 380	°F
Middle Temperature	350 to 390	°F
Front Temperature	360 to 400	°F
Nozzle Temperature	370 to 410	°F
Processing (Melt) Temp	370 to 410	°F
Mold Temperature	60 to 90	°F
Injection Pressure	200 to 1000	psi
Injection Rate	Moderate-Fast	
Back Pressure	25.0 to 50.0	psi
Screw Speed	50 to 100	rpm

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Injection	Nominal Value	Unit
Cushion	0.150 to 1.00	in

Injection Notes

Drying is not necessary. However, if moisture is a problem, dry the pellets for 2 to 4 hours at 150°F (65°C).

Notes

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

[2] Type 1, 20 in/min

[3] Method Ba, Angle (Unnicked), 20 in/min

[4] Type A

[5] Type 1

[6] 15 sec

[7] 5 sec

[8] 1 sec

Teknor Apex Company
Corporate Headquarters

In U.S. for Vinyls, TPEs, Colorants, Engineered Thermoplastics (Chem Polymer)
505 Central Avenue
Pawtucket, Rhode Island 02861 U.S.

Phone: 401-725-8000
Fax: 401-725-8095
Toll Free (U.S. only) 800-556-3864

www.teknorapex.com
info@teknorapex.com

Teknor Apex B.V.

Brightlands Chemelot Campus Umonderbaan 22
6167 RD Geleen, Netherlands

Phone: +31 46 7020 950
Fax: +31 46 7020 990

www.teknorapex.com
tpe@teknorapex.com

Teknor Apex (Suzhou) Advanced Polymer Compounds Co. Pte. Ltd.

No. 78 Ping Sheng Road

Suzhou Industrial Park
Jiangsu, China 215126

Phone: (86) 512-6287-1550
Fax: (86) 512-6288-8371

www.teknorapex.com
infotaap@teknoapex.com

Teknor Apex Asia Pacific PTE. LTD.

41 Shipyard Road

Singapore 628134

Phone: (65) 6265-2544
Fax: (65) 6265-1821

www.teknorapex.com
infotaap@teknorapex.com

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