**Product Information**

**Automotive and Transportation**

**Multiflex® TES A 2509 SL1 GRE PL25364 Thermoplastic Elastomer**

**FEATURES & BENEFITS**
- Excellent compression set
- Meets odor and fogging requirement for interior
- Grey
- Compatibility: PP

**APPLICATIONS**
- *Multiflex® TES A 2509 SL1 GRE PL25364* is designed for use in injection molding

**TYPICAL PROPERTIES**

Specification Writers: These values are not intended for use in preparing specifications. Please contact your local Dow Corning sales office or your Global Dow Corning Connection before writing specifications on this product.

<table>
<thead>
<tr>
<th>Test</th>
<th>Property</th>
<th>Unit</th>
<th>Result</th>
</tr>
</thead>
<tbody>
<tr>
<td>ISO 868</td>
<td>Hardness</td>
<td>Sh.A</td>
<td>25</td>
</tr>
<tr>
<td>ISO R1183</td>
<td>Density</td>
<td></td>
<td>1.03</td>
</tr>
<tr>
<td>MDA 179</td>
<td>Spiral flow condition A</td>
<td>cm</td>
<td>&gt; 85</td>
</tr>
<tr>
<td>MDA 179</td>
<td>Spiral flow condition C</td>
<td>cm</td>
<td>69</td>
</tr>
<tr>
<td>ISO 37 Type 1</td>
<td>Tensile strength at 100% elongation cross direction</td>
<td>MPa</td>
<td>0.5</td>
</tr>
<tr>
<td>v = 500 mm/min</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>ISO 37 Type 1</td>
<td>Tensile strength at break cross direction</td>
<td>MPa</td>
<td>4.2</td>
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<tr>
<td>v = 500 mm/min</td>
<td></td>
<td></td>
<td></td>
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<tr>
<td>ISO 37 Type 1</td>
<td>Elongation at break cross direction</td>
<td>%</td>
<td>820</td>
</tr>
<tr>
<td>v = 500 mm/min</td>
<td></td>
<td></td>
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<tr>
<td>ISO 34</td>
<td>Tear strength cross direction</td>
<td>kN/m</td>
<td>17</td>
</tr>
<tr>
<td>MDA 129</td>
<td>Compression set 24h/23°C without annealing</td>
<td>%</td>
<td>11</td>
</tr>
<tr>
<td>MDA 129</td>
<td>Compression set 24h/70°C without annealing</td>
<td>%</td>
<td>35</td>
</tr>
<tr>
<td>MDA 129</td>
<td>Compression set 24h/100°C without annealing</td>
<td>%</td>
<td>72</td>
</tr>
</tbody>
</table>

*ISO: International Standardization Organization
MDA (Méthode d’Analyse): Issued from ISO Standards

**GUIDELINES FOR INJECTION MOLDING**

<table>
<thead>
<tr>
<th>Drying</th>
<th>Not needed</th>
</tr>
</thead>
<tbody>
<tr>
<td>Barrel temperature °C</td>
<td></td>
</tr>
<tr>
<td>Feed Zone</td>
<td>150 +/- 10</td>
</tr>
<tr>
<td>Transition</td>
<td>170 +/- 10</td>
</tr>
<tr>
<td>Front</td>
<td>190 +/- 10</td>
</tr>
<tr>
<td>Nozzle</td>
<td>200 +/- 10</td>
</tr>
<tr>
<td>Melt temperature °C</td>
<td>200 +/- 10</td>
</tr>
<tr>
<td>Back Pressure Bars</td>
<td>10 +/- 5</td>
</tr>
<tr>
<td>Injection Speed</td>
<td>70 +/- 10% max</td>
</tr>
<tr>
<td>Holding Pressure</td>
<td>30 +/- 10% of Max Injection Pressure</td>
</tr>
<tr>
<td>Mold Temperature °C</td>
<td>40 +/- 20</td>
</tr>
<tr>
<td>Hot runner °C</td>
<td>180 +/- 10</td>
</tr>
</tbody>
</table>
HANDLING PRECAUTIONS
PRODUCT SAFETY
INFORMATION REQUIRED FOR
SAFE USE IS NOT INCLUDED IN
THIS DOCUMENT. BEFORE
HANDLING, READ PRODUCT
AND SAFETY DATA SHEETS
AND CONTAINER LABELS FOR
SAFE USE, PHYSICAL AND
HEALTH HAZARD
INFORMATION. THE SAFETY
DATA SHEET IS AVAILABLE ON
THE DOW CORNING WEBSITE
AT DOWCORNING.COM, OR
FROM YOUR DOW CORNING
SALES APPLICATION
ENGINEER, OR DISTRIBUTOR,
OR BY CALLING
DOW CORNING CUSTOMER
SERVICE.

USABLE LIFE AND
STORAGE
Refer to product label for storage
temperature conditions. Containers
should be kept tightly closed and kept
in cold storage at all times to extend
shelf life. Shelf life is indicated by the
“Use Before” date found on the
product label.

PACKAGING
INFORMATION
This product is available in a variety
of container sizes. Contact your local
Dow Corning sales representative for
information about container sizes
available in your area.

LIMITATIONS
This product is neither tested nor
represented as suitable for medical or
pharmaceutical uses.

HEALTH AND
ENVIRONMENTAL
INFORMATION
To support customers in their product
safety needs, Dow Corning has an
extensive Product Stewardship
organization and a team of Product
Safety and Regulatory Compliance
(PS&RC) specialists available in each
area.

For further information, please see our
website, dowcorning.com or consult
your local Dow Corning
representative.

LIMITED WARRANTY
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The information contained herein is
offered in good faith and is believed to
be accurate. However, because
conditions and methods of use of our
products are beyond our control, this
information should not be used in
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ensure that our products are safe,
effective, and fully satisfactory for the
intended end use. Suggestions of use
shall not be taken as inducements to
infringe any patent.

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specifications in effect at the time of
shipment.

Your exclusive remedy for breach of
such warranty is limited to refund of
purchase price or replacement of any
product shown to be other than as
warranted.

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