

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.

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

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

GUIDELINES FOR INJECTION MOLDING

Drying		Not needed
Barrel temperature °C	Feed Zone	150 +/- 10
	Transition	170 +/- 10
	Front	190 +/- 10
	Nozzle	200 +/- 10
Melt temperature °C		200 +/- 10
Back Pressure Bars		10 +/- 5
Injection Speed		70 +/- 10% max
Holding Pressure		30 +/- 10% of Max Injection Pressure
Mold Temperature °C		40 +/- 20
Hot runner °C		180 +/- 10

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.

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