#### **Technical Data**

**Product Description** 



The AD1 series is your material solution for applications with adhesion to polar thermoplastics such as ABS, PC and PC/ABS. The compounds are available in black and natural colors. Natural color variants can be colored in many different ways.

Typical applications

- · Thumb wheels
- · Bumpers
- Seals
- · Door sills
- · Function and design elements
- · Handles (hand tools and power tools etc.)
- · Grommets
- · Soft touch surface (thumb wheels, push buttons, switches)

Material advantages

- · Adhesion to PC, ABS, PC/ABS, ASA, SAN
- · Insert molding possible

THERMOLAST® K TC6MLB (Series: AD1)

- · Soft touch surface · Controlled level of emission and odor, suitable for automotive interior
- Colorable
- · Soft, non-sticky haptic

Regulations / Approvals

- DIN 75201-B Fogging
- VDA 270 B3 Odor
- 49 CFR §571.302 (FMVSS 302)
- DIN EN ISO 105-B06 Methode 3
- VW 50123
- BMW GS 93042
- Mercedes-Benz DBL 5562
- Stellantis B62 0300
- Renault 03-10-104
- Ford WSS-M2D507
- UL 94 HB

Generic

This data represents typical values that have been calculated from all products classified as: Generic TPE

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TP	F	

This information is provided for comparative purposes only.

General	THERMOLAST® K TC6MLB (Series: AD1)	Generic TPE	
Manufacturer / Supplier	KRAIBURG TPE	Generic	
Generic Symbol	• TPE	• TPE	
Material Status	Commercial: Active	Commercial: Active	
Literature <sup>1</sup>	<ul> <li>Technical Datasheet (English)</li> </ul>		
UL Yellow Card <sup>2</sup>	<ul> <li>E353857-101117933</li> <li>E214822-586863</li> <li>E488345-102949528</li> </ul>		
Search for UL Yellow Card	<ul> <li>KRAIBURG TPE</li> <li>THERMOLAST® K</li> </ul>		



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General	THERMOLAST® K TC6MLB (Series: AD1)	Generic TPE
Availability	<ul> <li>Africa &amp; Middle East</li> <li>Asia Pacific</li> <li>Europe</li> <li>Latin America</li> <li>North America</li> </ul>	<ul> <li>Africa &amp; Middle East</li> <li>Asia Pacific</li> <li>Europe</li> <li>Latin America</li> <li>North America</li> </ul>
Features	<ul> <li>Good Adhesion</li> <li>Good Colorability</li> <li>Soft</li> <li>UV Resistant</li> </ul>	
Uses	<ul> <li>Automotive Bumper</li> <li>Grommets</li> <li>Handles</li> <li>Seals</li> <li>Soft Touch Applications</li> </ul>	
Agency Ratings	• DIN 75201B	
Appearance	Natural Color	
Processing Method	<ul><li>Extrusion</li><li>Injection Molding</li></ul>	

Melt Mass-Flow Rate (MFR)	Physical	THERMOLAST® K TC6MLB (Series: AD1)	Generic TPE	Unit	Test Method
-         1.10         0.828 to 1.21         g/cm³         ISO 188             0.870 to 1.18         g/cm³         ASTM D1508           Melt Mass-Flow Rate (MFR)          0.870 to 1.18         g/r0 min         ASTM D1238           230°C/2.16 kg          0.20 to 18         g/r0 min         ISO 1183           Melt Volume-Flow Rate (MVR) (230°C/2.16 kg)          0.20 to 18         g/r0 min         ISO 1133           Spiral Flow          22.9 to 107         cm²         133           Molding Shrinkage          0.47 to 2.3         %         ASTM D1555           Across Flow          0.10 to 2.3         %         ASTM D955            -         0.47 to 2.3         %         ASTM D955            -         0.10 to 2.3         %         ASTM D955            -         0.10 to 2.3         %         ASTM D538           Across Flow          0.10 to 8.60         MPa         ASTM D638           Tensile Modulus          0.10 to 8.60         MPa         ASTM D638           Tensile Strength          2.52 to 32.5         MPa         ASTM D638	Density / Specific Gravity				
0.870 to 1.18         g/cm³         ASTM D1504           Melt Mass-Flow Rate (MFR)          0.10 to 22         g/10 min         ASTM D1234           230°C/2.16 kg          0.20 to 18         g/10 min         ISO 1133           Melt Volume-Flow Rate (MVR) (230°C/2.16 kg)          4.8 to 8.6         cm³/10min         ISO 1133           Spiral Flow          0.47 to 2.3         %         ASTM D555           Across Flow          0.47 to 2.3         %         ASTM D555            0.10 to 2.3         %         ASTM D555            1.4 to 1.8         %         ISO 294.4           Mechanical         THERMOLAST® K TC6ML8 (Series: AD1)         Generic TPE         Unit         Test Method           Tensile Modulus          0.100 to 8.60         MPa         ASTM D638           Tensile Strength          2.52 to 32.5         MPa         ASTM D638           Yield			0.785 to 1.34	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR)         -         0.10 to 22         g/10 min         ASTM D1234           190°C/2.16 kg          0.20 to 18         g/10 min         ISO 1133           Melt Volume-Flow Rate (MVR) (230°C/2.16 kg)          4.8 to 8.6         cm³/10min         ISO 1133           Spiral Flow          22.9 to 107         cm         Molding Shrinkage          22.9 to 107         cm           Flow          0.47 to 2.3         %         ASTM D955         Across Flow          0.10 to 2.3         %         ASTM D955             1.4 to 1.8         %         ISO 294.4         ISO 294.4           Mechanical         THERMOLAST® K TC6MLB (Series: AD1)         Generic TPE         Unit         Test Method           Tensile Modulus          0.100 to 8.60         MPa         ASTM D638           Tensile Strength          0.100 to 8.60         MPa         ISO 527-2           Break          2.90 to 48.3         MPa         ASTM D638           Generic          0.0414 to 13.8         MPa         ASTM D638           Yield          2.52 to 32.5         MPa         ASTM D638     <		1.10	0.828 to 1.21	g/cm³	ISO 1183
190°C/2.16 kg          0.10 to 22         g/10 min         ASTM D1233           230°C/2.16 kg          0.20 to 18         g/10 min         ISO 1133           Melt Volume-Flow Rate (MVR) (230°C/2.16 kg)          4.8 to 8.6         cm²/10min         ISO 1133           Spiral Flow          22.9 to 107         cm         cm           Molding Shrinkage          0.47 to 2.3         %         ASTM D955           Across Flow          0.10 to 2.3         %         ASTM D955            0.10 to 2.3         %         ASTM D955            1.4 to 1.8         %         ISO 294.4           Mechanical         THERMOLAST® K C66MLB (Series: AD1)         Generic TPE         Unit         Test Method           Tensile Modulus          0.10 to 8.60         MPa         ASTM D638           Tensile Strength          0.10 to 36.0         MPa         ISO 527-2           Yield          2.90 to 48.3         MPa         ASTM D638           Break          1.70 to 48.0         MPa         ISO 527-2             0.0414 to 13.8         MPa         ASTM D638 <t< td=""><td></td><td></td><td>0.870 to 1.18</td><td>g/cm³</td><td>ASTM D1505</td></t<>			0.870 to 1.18	g/cm³	ASTM D1505
230°C/2.16 kg          0.20 to 18         g/10 min         ISO 1133           Melt Volume-Flow Rate (MVR) (230°C/2.16 kg)          4.8 to 8.6         cm³/10min         ISO 1133           Spiral Flow          22.9 to 107         cm            Molding Shrinkage          0.47 to 2.3         %         ASTM D955           Across Flow          0.10 to 2.3         %         ASTM D955             1.4 to 1.8         %         ISO 294.4           Mechanical         THERMOLAST® K TC6MLB (Series: AD1)         Generic TPE         Unit         Test Method           Tensile Modulus          0.10 to 8.60         MPa         ASTM D638           Tensile Strength          2.52 to 32.5         MPa         ASTM D638           Yield          2.90 to 48.3         MPa         ASTM D638           Break          1.70 to 48.0         MPa         ISO 527-2             0.0414 to 13.8         MPa         ASTM D638           Break          1.90 to 9.09         MPa         ISO 527-2             0.0414 to 13.8         MPa	Melt Mass-Flow Rate (MFR)				
Melt Volume-Flow Rate (MVR) (230°C/2.16 kg)          4.8 to 8.6         cm³/10min         ISO 1133           Spiral Flow          22.9 to 107         cm           Molding Shrinkage          0.47 to 2.3         %         ASTM D955           Flow          0.47 to 2.3         %         ASTM D955           Across Flow          0.10 to 2.3         %         ASTM D955            1.4 to 1.8         %         ISO 294-4           Acchanical         THERMOLAST® K TC6MLB (Series: AD1)         Generic TPE         Unit         Test Method           Tensile Modulus          0.100 to 8.60         MPa         ASTM D638           Tensile Strength          2.52 to 32.5         MPa         ASTM D638           Yield          2.90 to 48.3         MPa         ISO 527-2           Break          1.70 to 48.0         MPa         ISO 527-2             1.90 to 9.09         MPa         ISO 527-2             1.90 to 9.09         MPa         ISO 527-2             1.90 to 9.09         MPa         ISO 527-2           Ensile Elong	190°C/2.16 kg		0.10 to 22	g/10 min	ASTM D1238
Spiral Flow          22.9 to 107         cm           Molding Shrinkage          0.47 to 2.3         %         ASTM D955           Flow          0.10 to 2.3         %         ASTM D955           Across Flow          0.10 to 2.3         %         ASTM D955            1.4 to 1.8         %         ISO 294-4           Acchanical         THERMOLAST® K TC6MLB (Series: AD1)         Generic TPE         Unit         Test Method           Tensile Modulus          0.100 to 8.60         MPa         ASTM D638           Tensile Strength          0.100 to 8.60         MPa         ASTM D638           Yield          2.52 to 32.5         MPa         ASTM D638           Yield          2.90 to 48.3         MPa         ISO 527-2           Break          1.70 to 48.0         MPa         ISO 527-2             0.0414 to 13.8         MPa         ASTM D638             1.90 to 9.09         MPa         ISO 527-2           Tensile Elongation          320 to 820         % ASTM D638           Break          79 to 850 <td>230°C/2.16 kg</td> <td></td> <td>0.20 to 18</td> <td>g/10 min</td> <td>ISO 1133</td>	230°C/2.16 kg		0.20 to 18	g/10 min	ISO 1133
Molding Shrinkage          0.47 to 2.3         %         ASTM D955           Across Flow          0.10 to 2.3         %         ASTM D955             1.4 to 1.8         %         ISO 294-4           Across Flow          1.4 to 1.8         %         ISO 294-4           Acchanical         THERMOLAST® K TCGMLB (Series: AD1)         Generic TPE         Unit         Test Method           Tensile Modulus          0.100 to 8.60         MPa         ASTM D638           Tensile Strength          2.52 to 32.5         MPa         ASTM D638           Yield          5.00 to 36.0         MPa         ISO 527-2           Break          1.70 to 48.0         MPa         ISO 527-2             0.0414 to 13.8         MPa         ASTM D638           Break          1.90 to 9.09         MPa         ISO 527-2             1.90 to 9.09         MPa         ISO 527-2             1.90 to 9.09         MPa         ISO 527-2             1.90 to 9.09         MPa         ISO 527-2           Tensi	Melt Volume-Flow Rate (MVR) (230°C/2.16 kg)		4.8 to 8.6	cm <sup>3</sup> /10min	ISO 1133
Flow          0.47 to 2.3         %         ASTM D955           Across Flow          0.10 to 2.3         %         ASTM D955             1.4 to 1.8         %         ISO 294-4           Mechanical         THERMOLAST® K COMBB (Series: AD1)         Generic TPE         Unit         Test Method           Tensile Modulus          0.100 to 8.60         MPa         ASTM D638           Tensile Strength          0.100 to 8.60         MPa         ASTM D638           Yield          2.52 to 32.5         MPa         ASTM D638           Yield          2.90 to 48.3         MPa         ASTM D638           Break          1.70 to 48.0         MPa         ISO 527-2             0.0414 to 13.8         MPa         ASTM D638             1.90 to 9.09         MPa         ISO 527-2             1.90 to 9.09         MPa         ISO 527-2             1.90 to 9.09         MPa         ISO 527-2             1.90 to 9.09         MPa         ISO 527-2           Tensile Elongation	Spiral Flow		22.9 to 107	cm	
Across Flow          0.10 to 2.3         %         ASTM D955             1.4 to 1.8         %         ISO 294-4           Acchanical         THERMOLAST® K TC6MLB (Series: AD1)         Generic TPE         Unit         Test Method           Tensile Modulus          0.100 to 8.60         MPa         ASTM D638           Tensile Strength          0.100 to 8.60         MPa         ASTM D638           Yield          2.52 to 32.5         MPa         ASTM D638           Yield          5.00 to 36.0         MPa         ISO 527-2           Break          1.70 to 48.0         MPa         ISO 527-2           Break          0.0414 to 13.8         MPa         ASTM D638             1.90 to 9.09         MPa         ISO 527-2             1.70 to 48.0         MPa         ISO 527-2             1.90 to 9.09         MPa         ISO 527-2             1.90 to 9.09         MPa         ISO 527-2           Tensile Elongation          320 to 820         %         ASTM D638           Break<	Molding Shrinkage				
1.4 to 1.8%ISO 294-4MechanicalTHERMOLAST® K TC6MLB (Series: AD1)Generic TPEUnitTest MethodTensile Modulus0.100 to 8.60MPaASTM D638Tensile Strength2.52 to 32.5MPaASTM D638Yield5.00 to 36.0MPaISO 527-2Break2.90 to 48.3MPaASTM D638Break1.70 to 48.0MPaISO 527-21.90 to 9.09MPaISO 527-2Break320 to 820%ASTM D638Break320 to 820%ASTM D638Break79 to 850%ISO 527-2	Flow		0.47 to 2.3	%	ASTM D955
MechanicalTHERMOLAST® K TC6MLB (Series: AD1)Generic TPEUnitTest MethodTensile Modulus0.100 to 8.60MPaASTM D638Tensile Strength2.52 to 32.5MPaASTM D638Yield5.00 to 36.0MPaISO 527-2Break2.90 to 48.3MPaASTM D638Break1.70 to 48.0MPaISO 527-21.90 to 9.09MPaISO 527-2Tensile Elongation320 to 820%ASTM D638Break79 to 850%ISO 527-2	Across Flow		0.10 to 2.3	%	ASTM D955
Tensile Modulus0.100 to 8.60MPaASTM D638Tensile StrengthYield2.52 to 32.5MPaASTM D638Yield5.00 to 36.0MPaISO 527-2Break2.90 to 48.3MPaASTM D638Break1.70 to 48.0MPaISO 527-21.70 to 48.0MPaISO 527-21.90 to 9.09MPaISO 527-2320 to 820%ASTM D638Break320 to 820%ISO 527-279 to 850%ISO 527-2			1.4 to 1.8	%	ISO 294-4
Tensile Strength          2.52 to 32.5         MPa         ASTM D638           Yield          5.00 to 36.0         MPa         ISO 527-2           Break          2.90 to 48.3         MPa         ASTM D638           Break          1.70 to 48.0         MPa         ISO 527-2            1.90 to 9.09         MPa         ISO 527-2            1.90 to 9.09         MPa         ISO 527-2           Tensile Elongation          1.90 to 9.09         MPa         ISO 527-2           Break          320 to 820         %         ASTM D638           Break          79 to 850         %         ISO 527-2	Nechanical			Unit	Test Method
Yield        2.52 to 32.5       MPa       ASTM D638         Yield        5.00 to 36.0       MPa       ISO 527-2         Break        2.90 to 48.3       MPa       ASTM D638         Break        1.70 to 48.0       MPa       ISO 527-2          1.70 to 48.0       MPa       ISO 527-2           0.0414 to 13.8       MPa       ASTM D638           1.90 to 9.09       MPa       ISO 527-2         Tensile Elongation        1.90 to 9.09       MPa       ASTM D638         Break        320 to 820       %       ASTM D638         Break        79 to 850       %       ISO 527-2	Tensile Modulus		0.100 to 8.60	MPa	ASTM D638
Yield        5.00 to 36.0       MPa       ISO 527-2         Break        2.90 to 48.3       MPa       ASTM D638         Break        1.70 to 48.0       MPa       ISO 527-2          0.0414 to 13.8       MPa       ASTM D638           0.0414 to 13.8       MPa       ASTM D638          1.90 to 9.09       MPa       ISO 527-2         Tensile Elongation        320 to 820       %       ASTM D638         Break        79 to 850       %       ISO 527-2	Tensile Strength				
Break        2.90 to 48.3       MPa       ASTM D638         Break        1.70 to 48.0       MPa       ISO 527-2          0.0414 to 13.8       MPa       ASTM D638          1.90 to 9.09       MPa       ISO 527-2          1.90 to 9.09       MPa       ISO 527-2          1.90 to 9.09       MPa       ISO 527-2         Tensile Elongation        1.90 to 9.09       MPa       ISO 527-2         Break        320 to 820       %       ASTM D638         Break        79 to 850       %       ISO 527-2	Yield		2.52 to 32.5	MPa	ASTM D638
Break          1.70 to 48.0         MPa         ISO 527-2             0.0414 to 13.8         MPa         ASTM D638            1.90 to 9.09         MPa         ISO 527-2           Tensile Elongation          3.20 to 820         %         ASTM D638           Break          320 to 820         %         ASTM D638           Break          79 to 850         %         ISO 527-2	Yield		5.00 to 36.0	MPa	ISO 527-2
0.0414 to 13.8         MPa         ASTM D638            1.90 to 9.09         MPa         ISO 527-2           Tensile Elongation          320 to 820         %         ASTM D638           Break          320 to 820         %         ASTM D638           Break          79 to 850         %         ISO 527-2	Break		2.90 to 48.3	MPa	ASTM D638
1.90 to 9.09         MPa         ISO 527-2           Tensile Elongation          320 to 820         %         ASTM D638           Break          79 to 850         %         ISO 527-2	Break		1.70 to 48.0	MPa	ISO 527-2
Tensile Elongation          320 to 820         %         ASTM D638           Break          79 to 850         %         ISO 527-2			0.0414 to 13.8	MPa	ASTM D638
Break          320 to 820         %         ASTM D638           Break          79 to 850         %         ISO 527-2			1.90 to 9.09	MPa	ISO 527-2
Break 79 to 850 % ISO 527-2	Tensile Elongation				
	Break		320 to 820	%	ASTM D638
Nominal Tensile Strain at Break 530 to 1000 % ISO 527-2	Break		79 to 850	%	ISO 527-2
	Nominal Tensile Strain at Break		530 to 1000	%	ISO 527-2



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Mechanical	THERMOLAST® K TC6MLB (Series: AD1)	Generic TPE	Unit	Test Method
Flexural Modulus	. , ,			
		1.86 to 338	MPa	ASTM D790
		2.40 to 638	MPa	ISO 178
Flexural Stress		2.40 to 19.3	MPa	ISO 178
Taber Abrasion Resistance		1.18 to 370	mg	ASTM D1044
Films	THERMOLAST® K TC6MLB (Series: AD1)	Generic TPE	Unit	Test Method
Oxygen Permeability		380 to 550	cm³·mm/m²/atm 24 hr	ASTM D3985
Oxygen Transmission Rate (Wet)		422 to 516	cm <sup>3</sup> /m <sup>2</sup> /24 hr	ASTM F1927
Water Vapor Transmission Rate		31 to 520	g/m²/24 hr	ASTM F1249
Elastomers	THERMOLAST® K TC6MLB (Series: AD1)	Generic TPE	Unit	Test Method
Tensile Set		2 to 26	%	ASTM D412
Tensile Stress				
20% Strain		0.500 to 3.10	MPa	ISO 37
50% Strain		0.0242 to 5.80	MPa	ASTM D412
100% Strain		0.0193 to 4.64	MPa	ASTM D412
100% Strain		0.100 to 4.35	MPa	ISO 37
200% Strain		0.0440 to 3.82	MPa	ASTM D412
300% Strain		0.0429 to 6.78	MPa	ASTM D412
300% Strain		0.720 to 6.30	MPa	ISO 37
Tensile Strength				
Yield		1.20 to 10.4	MPa	ASTM D412
Yield		1.63 to 13.3	MPa	ISO 37
Break		2.46 to 12.9	MPa	ASTM D412
Break		1.00 to 15.1	MPa	ISO 37
Break <sup>4</sup>	5.00		MPa	ISO 37
		0.300 to 14.0	MPa	ASTM D412
Tensile Elongation				
Yield		500 to 1000	%	ASTM D412
Break		330 to 900	%	ASTM D412
Break		290 to 930	%	ISO 37
Break <sup>4</sup>	580		%	ISO 37
Tear Strength				
		2.94 to 1880	kN/m	ASTM D624
		8.47 to 44.6	kN/m	ISO 34-1
5	17.0		kN/m	ISO 34-1
Compression Set	17.0		NIN/111	100 04-1
		8 0 to 67	0/	
		8.9 to 67 8.0 to 81	%	ASTM D395
			%	ISO 815
Impact	THERMOLAST® K TC6MLB (Series: AD1)	Generic TPE	Unit	Test Method
Notched Izod Impact				
		40 to 950	J/m	ASTM D256
		7.0 to 71	kJ/m²	ISO 180

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Hardness	THERMOLAST® K TC6MLB (Series: AD1)	Generic TPE	Unit	Test Method
Durometer Hardness				
		29 to 93		ASTM D2240
		30 to 91		ISO 868
Shore Hardness				ISO 48-4
		28 to 91		
Shore A	60			
IRHD Hardness		49 to 78		ISO 48
Thermal	THERMOLAST® K TC6MLB (Series: AD1)	Generic TPE	Unit	Test Method
Continuous Use Temperature		105 to 107	°C	ASTM D794
Brittleness Temperature				
		-65.2 to -54.9	°C	ASTM D746
		-67.9 to -64.9	°C	ISO 812
Glass Transition Temperature		-57.2 to -39.0	°C	DSC
Vicat Softening Temperature		40.0 to 207	°C	ASTM D1525
Melting Temperature		160 to 218	°C	
Specific Heat		1600 to 3100	J/kg/°C	ASTM C351
Thermal Conductivity		0.15 to 0.23	W/m/K	ASTM C177
RTI Elec		50.0 to 90.0	°C	UL 746B
RTI Str		50.0 to 90.0	°C	UL 746B
Aging	THERMOLAST® K TC6MLB (Series: AD1)	Generic TPE	Unit	Test Method
Change in Tensile Strength in Air				
		-22 to 29	%	ASTM D573
		-13 to 22	%	ISO 188
Change in Ultimate Elongation in Air				
		-26 to 5.2	%	ASTM D573
		-17 to 21	%	ISO 188
Change in Shore Hardness in Air		-0.16 to 4.7		ISO 188
Change in Tensile Strength				
		-32 to -0.98	%	ASTM D471

-5.0 to 1.0

%

Change in Ultimate Elongation

	 -44 to 5.4	%	ASTM D471
	 -5.0 to 4.0	%	ISO 1817
Change in Shore Hardness	 1.0 to 1.1		ISO 1817
Change in Volume			
	 -12 to 74	%	ASTM D471
	 -12 to 23	%	ISO 1817

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ISO 1817

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Electrical	THERMOLAST® K TC6MLB (Series: AD1)	Generic TPE	Unit	Test Method
Surface Resistivity		6.0E+2 to 2.5E+14	ohms	ASTM D257
Volume Resistivity		5.1E+5 to 9.7E+16	ohms∙cm	ASTM D257
Dielectric Strength		20 to 46	kV/mm	ASTM D149
Dielectric Constant				
		2.10 to 2.53		ASTM D150
		4.28		IEC 60250
Dissipation Factor				
		7.0E-5 to 0.050		ASTM D150
		0.013 to 0.069		IEC 60250
Flammability	THERMOLAST® K TC6MLB (Series: AD1)	Generic TPE	Unit	Test Method
Burning Rate		100	mm/min	ISO 3795
Flame Rating	HB			UL 94
Glow Wire Flammability Index		952 to 960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature		650 to 850	°C	IEC 60695-2-13
Oxygen Index				
		17 to 32	%	ASTM D2863
		25 to 40	%	ISO 4589-2
Dptical	THERMOLAST® K TC6MLB (Series: AD1)	Generic TPE	Unit	Test Method
Light Transmittance		91.0 to 94.0	%	ASTM D1003
Haze		1.00 to 36.2	%	ASTM D1003
Fill Analysis	THERMOLAST® K TC6MLB (Series: AD1)	Generic TPE	Unit	Test Method
Apparent Viscosity		0.116 to 41.5	Pa·s	ASTM D3835
Melt Viscosity		6.50 to 138	Pa⋅s	ASTM D3835
Additional Information	THERMOLAST® K TC6MLB (Series: AD1)	Generic TPE	Unit	Test Method
Adhesion to ABS - (D) $^{6}$	6.0		kN/m	VDI 2019
Adhesion to PC - (D) $^{6}$	3.8		kN/m	VDI 2019
njection	THERMOLAST® K TC6MLB (Series: AD1)	Generic TPE	Unit	
Drying Temperature		59 to 101	°C	

	TCOIVILD (Series, ADT)	IPE		
Drying Temperature		59 to 101	°C	
Drying Time		2.0 to 3.6	hr	
Dew Point		-18	°C	
Suggested Max Moisture		0.020 to 0.081	%	
Suggested Max Regrind		20	%	
Hopper Temperature		25 to 163	°C	
Rear Temperature		135 to 209	°C	
Middle Temperature		156 to 213	°C	
Front Temperature		169 to 213	°C	
Nozzle Temperature		185 to 226	°C	
Processing (Melt) Temp		116 to 230	°C	
Mold Temperature		22 to 47	°C	
Injection Pressure		0.686 to 9.94	MPa	

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Injection	THERMOLAST® K TC6MLB (Series: AD1)	Generic TPE	Unit	
Holding Pressure		2.94 to 56.4	MPa	
Back Pressure		0.170 to 1.07	MPa	
Screw Speed		69 to 75	rpm	
Clamp Tonnage		3.8	kN/cm <sup>2</sup>	
Cushion		14.4 to 14.6	mm	
Vent Depth		0.019 to 0.026	mm	
niection Notes				

#### Injection Notes

Generic TPE

This data represents typical values that have been calculated from all products classified as: Generic TPE

This information is provided for comparative purposes only.

Extrusion	THERMOLAST® K TC6MLB (Series: AD1)	Generic TPE	Unit	
Drying Temperature		67 to 82	°C	
Drying Time		1.9 to 3.0	hr	
Hopper Temperature		168 to 169	°C	
Cylinder Zone 1 Temp.		78 to 208	°C	
Cylinder Zone 2 Temp.		178 to 214	°C	
Cylinder Zone 3 Temp.		79 to 3581	°C	
Cylinder Zone 4 Temp.		171 to 232	°C	
Cylinder Zone 5 Temp.		177 to 224	°C	
Adapter Temperature		193 to 205	°C	
Melt Temperature		189 to 217	°C	
Die Temperature		191 to 226	°C	

#### Extrusion Notes

Generic

TPE

This data represents typical values that have been calculated from all products classified as: Generic TPE

This information is provided for comparative purposes only.

### Notes

<sup>1</sup> These links provide you with access to supplier literature. We work hard to keep them up to date; however you may find the most current literature from the supplier.

<sup>2</sup> A UL Yellow Card contains UL-verified flammability and electrical characteristics. UL Prospector continually works to link Yellow Cards to individual plastic materials in Prospector, however this list may not include all of the appropriate links. It is important that you verify the association between these Yellow Cards and the plastic material found in Prospector. For a complete listing of Yellow Cards, visit the UL Yellow Card Search.

<sup>3</sup> Typical properties: these are not to be construed as specifications.

<sup>4</sup> Type S2, 200 mm/min

<sup>5</sup> Method Bb, Angle (Nicked)

<sup>6</sup> Two-component injection molding

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### Where to Buy

Supplier	
THERMOLAST® K TC6MLB (Series: AD1)	KRAIBURG TPE Buford, Buford USA Telephone: 678-584-5020 Web: http://www.kraiburgtpe.com/
Generic TPE	Generic
Distributor	
THERMOLAST® K TC6MLB (Series: AD1)	Conventus Polymers Telephone: 973-343-7669 Web: http://www.conventuspolymers.com/ Availability: North America Lenorplastics Zug Telephone: +41-41-798-02-11 Web: https://www.lenorplastics.ch Availability: Switzerland Plastoplan Telephone: +43-1-25040-0 Web: https://www.plastoplan.com/ Availability: Austria, Hungary, Poland
	PolySource PolySource is a North American resin and plastics distributor. Please feel to reach out to your Technical Sales Account Manager. https://polysource.net/our-team/ Telephone: 816-540-5300 Web: http://www.polysource.net/ Availability: Canada, Mexico, United States

Generic TPE

Please contact the supplier to find a distributor for Generic TPE

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