

Guide formulation - page 1 of 2

AUTOMOTIVE INDUSTRY**Molding, black****Quarter light gasket****60 Shore A, EPDM, sulfur cure / injection/transfer molding****Specification Renault 2 6 07 B1**

Guide formulation of Exxon		911 C 152
Vistalon 3666		87.5
Vistalon 9500		50.0
SRF N-774		100.0
SILLIKOLLOID P 87		40.0
Grundöl AP/E Core 2500 (ex Flexon 815)		45.0
PEG 3350		3.0
Struktol WB 16		3.0
Kagevest 25 (ex Polyvest 25)		2.0
Stearic acid		1.5
Zinc oxide		8.0
Sulfur		2.0
MBT		1.0
ZBEC		0.5
Vulkalent E/C		0.3
Rheonogran ZAT-70		2.0
Total phr		345.8
Density	g/cm ³	1.17
Mooney Viscosity		
ML (1+4) 100°C	MU	43
ML (1+4) 121°C	MU	33
ODR, ± 3°, 180°C		
ML, minimum	dNm	6
MH, maximum	dNm	52
ts ₂	min	0.8
tc ₉₀	min	3.0

Our applications engineering advice and the information contained in this formulation are based on experience and are made to the best of our knowledge and belief, they must be regarded however as non-binding advice without guarantee. Working and employment conditions over which we have no control exclude any damage claim arising from the use of our data and recommendations. Furthermore we cannot assume any responsibility for patent infringements, which might result from the use of our information.

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Physical properties**Press cure 5 min @ 180°C**

Hardness	Shore A	62
Modulus 100 %	MPa	2.9
Tensile strength	MPa	7.5
Elongation at break	%	380

Compression set**Press cure 8 min @ 180°C**

22 h @ RT, 25 % defl.	ASTM B	%	6
22 h @ 100°C, 25 % defl.	ASTM B	%	38

Injection molding conditions

Pressure	bar	110
Injection time	s	10
Vulcanization temperature	°C	170
Vulcanization time	s	200

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