

Guide formulation - page 1 of 2

**AUTOMOTIVE INDUSTRY****Profile, solid, black****Sun roof seal**

55 Shore A, EPDM, sulfur cure / UHF cure

Specification Renault 2 5 07 B1

Guide formulation of Exxon		911 E 507
Vistalon 3666		175.0
SRF N-774		110.0
SILLITIN Z 86		100.0
Grundöl AP/E Core 600 (ex Flexon 876)		35.0
Zinc oxide		10.0
Stearic acid		1.5
PEG 3350		5.0
Calcium oxide		10.0
Kagevest 25 (ex Polyvest 25)		3.0
Sulfur		1.5
MBT		1.5
TMTD		0.6
DPTT		1.0
ZDBC		1.0
TDEC		0.8
Total phr		455.9
Density	g/cm <sup>3</sup>	1.26
<b>Mooney Viscosity</b>		
ML (1+4) 100°C	MU	46
<b>Mooney Scorch</b>		
MS (t <sub>5</sub> ) 125°C	min	6
<b>ODR, ± 3°, 180°C</b>		
ML, minimum	dNm	8
MH, maximum	dNm	35
ts <sub>2</sub>	min	0.6
tc <sub>90</sub>	min	1.8

*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 4 min @ 180°C**

Hardness		Shore A	55/53
Modulus 100 %		MPa	2.0
Tensile strength		MPa	9.8
Elongation at break		%	480
Tear resistance	ASTM C	N/mm	34
Tear resistance	DIN ISO 34-1, A	N/mm	11.3
Tear resistance	Delft	N/mm	9

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

22 h @ 70°C, 25 % deflection	ASTM B	%	22
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**Air aging, 7 d @ 70°C**

Hardness		Shore A	60/61
Modulus 100 %		MPa	3.0
Tensile strength		MPa	9.6
Elongation at break		%	350

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