

Guide formulation - page 1 of 2

**AUTOMOTIVE INDUSTRY****Profile, solid, black****Weatherstrip, nitrosamine reducing****60 Shore A, EPDM, sulfur cure / UHF cure****Specification VW TL 520.15**

Guide formulation of Exxon		911 K 078
Vistalon 3666		35.0
Vistalon 8510 )*		92.0
APF N-683		85.0
SILLITIN Z 86		50.0
Grundöl AP/E Core 600 (ex Flexon 876)		45.0
PEG 3350		3.0
Stearic acid		1.0
Zinc oxide		5.0
Calcium oxide		8.0
Sulfur		1.0
MBT		0.5
MBTS		0.5
ZBEC		0.7
ZBPD		1.0
Rhenogran Geniplex-70		0.8
Perkacit TBzTD		0.5
Vulkalent E/C		0.3
Total phr		329.3
Density	g/cm <sup>3</sup>	1.2

)\* No longer available. Recommended: Vistalon 8800

**Mooney Viscosity**

ML (1+4) 100°C MU 51

**Mooney Scorch**MS (t<sub>5</sub>) 125°C min 6.1**ODR, ± 3°, 180°C**

ML, minimum dNm 7

MH, maximum dNm 45

ts<sub>2</sub> min 0.6tc<sub>90</sub> min 3.3

*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.*

VM-8/0192/01.2014

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

Hardness		Shore A	57
Modulus 100 %		MPa	2.0
Tensile strength		MPa	9.8
Elongation at break		%	415
Tear resistance	DIN ISO 34-1, A	N/mm	5.8

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

22 h @ 70°C, 25 % defl.	ASTM B	%	11
22 h @ 70°C, 25 % defl.	VW	%	39
100 h @ 70°C, 25 % defl.	VW	%	49

**Air aging, 7 d @ 100°C**

Hardness		Shore A	64
Tensile strength		MPa	9.1
Elongation at break		%	300

*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.*

VM-8/0192/01.2014