

Guide formulation - page 1 of 2

**AUTOMOTIVE INDUSTRY****Molding, black****Quarter light gasket****50 Shore A, EPDM, sulfur cure**

Guide formulation of Exxon		A.4.0.003
Vistalon 3666		175.00
FEF N-550		135.00
SILLITIN Z 86		50.00
Grundöl AP/E Core 600 (ex Flexon 876)		85.00
Zinc oxide		5.00
Stearic acid		2.00
PEG 3350		2.00
Sulfur		1.50
MBT		1.50
TMTD		0.75
DTDM		0.75
ZDMC		0.75
ZDBC		0.75
Total phr		460.00
Density	g/cm <sup>3</sup>	1.14
<b>Mooney Viscosity</b>		
ML (1+4) 100°C	MU	35
<b>Monsanto Rheometer, ± 5°, 180°C</b>		
ML, minimum	dNm	7
MH, maximum	dNm	45
ts <sub>2</sub>	min	1.0
tc <sub>90</sub>	min	3.5
<b>Physical properties</b>		
<b>Press cure 6 min @ 180°C</b>		
Hardness	Shore A	51
Modulus 100 %	MPa	1.5
Modulus 300 %	MPa	4.5
Tensile strength	MPa	8.5
Elongation at break	%	480

*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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**Compression set**

22 h @ 70°C, 25 % deflection	ASTM B	%	19
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