

Guide formulation - page 1 of 2

**AUTOMOTIVE INDUSTRY****Profile, solid, black****Solid foot roof gutter, bi-extruded****85 Shore A, EPDM, sulfur cure / UHF cure**

Guide formulation of Exxon		E91/551
Vistalon 9500		100.0
SRF N-765		160.0
MT N-990		30.0
SILLITIN Z 86		30.0
Polyethylene wax		15.0
Grundöl AP/E Core 2500 (ex Flexon 815)		40.0
Zinc oxide		8.0
Stearic acid		2.0
PEG 3350		4.0
Rhenogran CaO-80		4.5
Struktol WB 16		3.0
TMQ		1.0
Sulfur		1.0
MBT		0.5
MBTS		1.0
TMTD		0.8
DTDM		1.0
ZDBC		0.7
Total phr		402.5
Density	g/cm <sup>3</sup>	1.3
<b>Mooney Viscosity</b>		
ML (1+4) 100°C	MU	112
<b>Mooney Scorch</b>		
MS (ts <sub>5</sub> ) 125°C	min	4
<b>Monsanto Rheometer, ± 3°, 180°C</b>		
ML, minimum	dNm	20
MH, maximum	dNm	98
ts <sub>2</sub>	min	0.5
tc <sub>90</sub>	min	1.6

*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	88/86
Modulus 100 %	MPa	7.8
Tensile strength	MPa	9.9
Elongation at break	%	145

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

22 h @ 100°C, 25 % defl.	ASTM B	%	51
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**Air aging, 14 d @ 100°C**

Hardness	Shore A	90/89
Tensile strength	MPa	10.6
Elongation at break	%	85
Δ Hardness	μm	+3
Δ Tensile strength	%	+7
Δ Elongation at break	%, rel.	-41

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