

Guide formulation - page 1 of 2

AUTOMOTIVE INDUSTRY**Molding, black****Quarter light gasket, nitrosamine reducing
65 Shore A, EPDM, sulfur cure / injection molding**

Guide formulation of Exxon	K 91-59
Vistalon 9500	40.0
Vistalon 3666	105.0
Grundöl AP/E Core 600 (ex Flexon 876)	50.0
FEF N-550	90.0
SILLITIN Z 86	90.0
PEG 3350	5.0
Polyethylene wax	4.0
Stearic acid	1.5
Zinc oxide	10.0
Kagevest 25 (ex Polyvest 25)	3.0
Sulfur	2.0
MBTS	1.0
Vulkalant E/C	0.3
Perkacit TBzTD	0.5
Deovulc BG 187	2.0
ZBEC	0.5
Total phr	404.8

Mooney Viscosity

ML (1+4) 100°C MU 41

Monsanto Rheometer, ± 3°, 180°C

ML, minimum	dNm	6
MH, maximum	dNm	53
ts ₂	min	1.4
tc ₉₀	min	4.7

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 8 min @ 180°C**

Hardness		Shore A	67
Modulus 100 %		MPa	4.0
Tensile strength		MPa	10.1
Elongation at break		%	300
Tear resistance	DIN ISO 34-1, A	N/mm	6.4

Compression set**Press cure 12 min @ 180°C**

22 h @ 70°C, 25 % deflection	ASTM B	%	41
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