

Guide formulation - page 1 of 2

AUTOMOTIVE INDUSTRY**Profile, solid, black****Door seal, low hardness****20 Shore A, EPDM, sulfur cure / UHF cure****Specification Renault and VW**

Guide formulation of Exxon		M 818
Vistalon 3666		175.00
GPF N-650		130.00
SILLITIN Z 86		50.00
Grundöl AP/E Core 600 (ex Flexon 876)		130.00
Rhenogran CaO-80		16.88
Zinc oxide		15.00
PEG 4000		10.00
Stearic acid		1.50
Oleamide		6.00
Jayflex DINA		20.00
Sulfur		1.50
MBT		1.50
TMTD		0.75
ZDMC		0.75
DPTT		0.75
TDEC		0.75
Total phr		560.38
Density	g/cm ³	1.13

Physical properties**UHF cure**

Hardness	Shore A	24/22
Modulus 100 %	MPa	0.8
Modulus 300 %	MPa	3.2
Tensile strength	MPa	7.8
Elongation at break	%	600

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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				M 818	
Compression set					Renault Spec.
22 h @ 70°C, 55 % defl.	ASTM B	%		8	≤ 35
7 d @ 70°C, 55 % defl.	ASTM B	%		54	≤ 55
22 h @ -20°C, 55 % defl.	ASTM B	%		40	---
Compression set					VW Spec.
100 h @ RT, 50 % defl.	VW	%		15	≤ 25
100 h @ 70°C, 50 % defl. (relaxation 3 h @ RT)	VW	%		34	≤ 45

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