

Guide formulation - page 1 of 2

AUTOMOTIVE INDUSTRY**Profile, solid, black****Door seal, low hardness****25 Shore A, EPDM, sulfur cure / UHF cure****Specification Renault and VW**

Guide formulation of Exxon		M 819
Vistalon 3666		175.00
SILLITIN Z 86		100.00
Perkasil KS 300		30.00
FEF N-550		20.00
Grundöl AP/E Core 600 (ex Flexon 876)		60.00
Jayflex DINA		20.00
Zinc oxide		15.00
Rhenofit C		15.00
PEG 4000		10.00
Kagevest 25 (ex Polyvest 25)		3.00
Stearic acid		1.50
Oleamide		6.00
Sulfur		1.00
MBT		1.50
TMTD		0.75
ZDMC		0.75
DPTT		0.75
DTDM		0.75
Total phr		461.00
Density	g/cm ³	1.13

Monsanto Rheometer, ± 5°, 180°C

ML, minimum	dNm	9.0
MH, maximum	dNm	24.9
ts ₂	min	1.4
tC ₉₀	min	3.0

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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			Press	UHF	
			5 min @ 180°C		
Physical properties					
Hardness		Shore A	36/33	26/22	
Modulus 100 %		MPa	0.8	0.5	
Modulus 300 %		MPa	2.0	1.0	
Tensile strength		MPa	8.2	4.2	
Elongation at break		%	860	760	
Compression set					
UHF cured hose					
22 h @ 70°C, 55 % defl.	ASTM B	%		9	≤ 35
7 d @ 70°C, 55 % defl.	ASTM B	%		50	≤ 55
22 h @ -20°C, 55 % defl.	ASTM B	%		54	---
Compression set					
UHF cured hose					
100 h @ RT, 50 % defl.	VW	%		16	≤ 25
100 h @ 70°C, 50 % defl. (relaxation 3 h @ RT)	VW	%		40	≤ 45

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