

Guide formulation - page 1 of 2

AUTOMOTIVE INDUSTRY**Profile, solid, black****Profile for low temperature flexibility****75 Shore A, EPDM, sulfur cure****Specification BMW**

Guide formulation of Exxon		M 849
Vistalon 3666		175.0
A-C 617		10.0
GPF N-660		170.0
SILLITIN N 82		50.0
Zinc oxide		10.0
Stearic acid		2.0
Rhenogran CaO-80		5.6
PEG 4000		2.0
Sulfur		0.4
Vulkacit MOZ		2.2
TMTD		0.5
DTDM		0.5
DPTT		0.5
Total phr		428.7
Density	g/cm ³	1.26
Monsanto Rheometer, ± 5°, 180°C		
ML, minimum	dNm	30.5
MH, maximum	dNm	100.6
ts ₂	min	1.5
tC ₉₀	min	5.2

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				BMW Spec.
Press cure 6 min @ 180°C				
Hardness		Shore A	74	75 ± 5
Modulus 100 %		MPa	4.6	
Tensile strength		MPa	9.7	≥ 8
Elongation at break		%	250	
Tear resistance	DIN ISO 34-1, B	N/mm	31	≥ 20
Compression set				
22 h @ 100°C, 25 % defl.	ASTM B	%	41	≤ 60
Air aging, 144 h @ 100°C				
Hardness		Shore A	79	
Modulus 100 %		MPa	5.0	
Tensile strength		MPa	10.0	
Tear resistance (Graves)	DIN ISO 34-1, B	N/mm	24	
Torsion modulus G as function of temperature				
G (23°C)		MPa	14	
G (0°C)		MPa	16	
G (-10°C)		MPa	19	
G (-20°C)		MPa	23	
G (-30°C)		MPa	43	
G (-50°C)		MPa	95	
G (-50°C)		MPa	850	
T ₍₅₎		°C	-48	≤ -45

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