AUTOMOTIVE INDUSTRY
Profile, sponge, black

Expanded part of snap-on-profile for bonnet and trunkseals, good collapse
Density 0.60 g/cm³, EPDM, sulfur cure / UHF cure

Guide formulation of DSM (now Arlanxeo)	V 2658
Keltan 512x50)*	120.0
Keltan 312)**	20.0
Zinc oxide	5.0
Stearic acid	3.0
Durex 0	90.0
SILLITIN Z 86	55.0
Vaseline	10.0
Process Oil P 460 (ex Sunpar 2280)	30.0
Caloxol W3	4.0
MBT	1.0
TDEC	1.0
ZDMC	3.0
DBTU	3.0
Sulfur	1.5
Genitron CR	6.0
Total phr	352.5

)* No longer available. Recommended: Keltan 4450 + 50 phr paraffin oil
)** No longer available. Recommended: Keltan 2450

Compound preparation

3-D Branbury mixer, volume 47.5 l

Overload	%	10
Rotor speed	rpm	35
Mixing method:		
Polymer	min	0
Rest except Caloxol, accelerators, sulfur and blowing agent	min	1
Caloxol W3	min	3
Discharge	min	4
Indicated discharge temperature	°C	120

Fed to slab-off mill: accelerators, sulfur and blowing agent

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			V 2658
Mooney Viscosity ML (1+4) 100°C	MU		62
Mooney Cure rate			
V 30 120°C	MU		10.7
V 30 140°C	MU		31.6
Rheometer		**160°C**	**180°C**
Delta S	Nm	5.49	6.42
Optimum time	min	17.3	5.6
Scorch time	min	1.8	---

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V 2658

Berstorff Extruder ∅ 90 mm 16D			
Extrusion conditions		with vacuum	
Barrel	°C	40-40-50	
Head	°C	50	
UHF curing, Hertz-four GLH FAT 2x2.5 kW			
Energy Magnetron I	A	0.33	0.5
Energy Magnetron II	A	0.33	0.5
Temperature in air tunnel (6 m)	°C	250	250
Profile type		O	O
Extrusion rate	m/min	7.5	12.5

		original	post cured 2 h @ 130°C	original	post cured 2 h @ 130°C
Physical properties					
Density	g/cm³	0.61	0.63	0.60	0.62
Water absorption	%	6.8	11.2	7.4	10.0
Tensile strength (profile)	MPa	2.2	---	2.0	---
Elongation at break	%	230	---	190	---
Compression set					
100 h @ RT, after 5 min	%	19	15	18	18
100 h @ RT, after 60 min	%	13	12	13	12
100 h @ 70°C, after 5 min	%	60	42	60	41
100 h @ 70°C, after 60 min	%	61	40	59	38
Compression deflection					
ASTM 1056	kg/20cm	3.0	3.7	3.1	3.6
Air aging, 48 h @ 70°C					
Tensile strength (profile)	MPa	2.0	---	1.9	---
Elongation at break	%	200	---	200	---

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