

**MACHINERY and EQUIPMENT****Appliance, Gasket, black****Washing machine bellow****50 Shore A, EPDM, sulfur cure**

Guide formulation of Exxon	VI 034 1.1
Vistalon 7500	100.0
FEF N-550	100.0
SILLITIN P 87	20.0
Grundöl AP/E Core 2500 (ex Flexon 815)	110.0
Zinc oxide	5.0
Stearic acid	1.0
Kagevest 25 (ex Polyvest 25)	0.5
PEG 3350	2.0
Sulfur	1.0
MBTS	0.7
ZDBC	0.7
ZEPC	0.5
CBS	2.0
Total phr	343.4

Mooney Viscosity

ML (1+4) 100°C	MU	25
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ODR, ± 3°, 180°C

ML, minimum	dNm	2
MH, maximum	dNm	34
ts ₂	min	1.7
tc ₉₀	min	3.4



VI 034 1.1

Physical properties**Press cure 4 min @ 180°C**

Hardness		Shore A	51/48
Modulus 100 %		MPa	1.9
Tensile strength		MPa	11.2
Elongation at break		%	630
Tear resistance	DIN ISO 34-1, A	N/mm	10

Compression set

22 h @ 100°C, 25 % defl.	ASTM B	%	39
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Immersion in phosphate-free detergent solution, 72 h @ 95°C

Δ Hardness		Shore A	+2
Δ Tensile strength		%	0
Δ Elongation at break		%, rel.	-20
Δ Volume		%	+1

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