



OTHER APPLICATION

Extrusion, Profile, solid, light-colored

60 Shore A, EPDM, sulfur cure / LCM cure

Guide formulation of DSM (now Arlanxeo)	V 610
Keltan 512)*	50.0
Keltan 578Z)**	50.0
Zinc oxide	5.0
Stearic acid	1.0
SILLITIN N 85	145.0
Kronos 2056	15.0
Winnofil S	35.0
Process Oil P 460 (ex Sunpar 2280)	55.0
Protektor G 3108	5.0
Caloxol W3	10.0
TMTD	0.8
TDEC	0.8
DPTT	0.8
MBT	1.5
ETU	1.0
Sulfur	2.0
Total phr	377.9

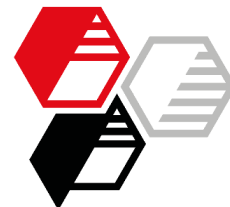
)* No longer available. Recommended: Keltan 4450

)** No longer available. Recommended: Keltan 5470 or Keltan 5470Q

Compound preparation

3-D Branbury mixer, volume 47.5 l

Overload	%	5
Rotor speed	rpm	35
Mixing method:		
Polymer	min	0
Rest except Caloxol, accelerators, sulfur	min	1
Discharge	min	6.5
Indicated discharge temperature	°C	approx. 110
Fed to slab-off mill: Caloxol, accelerators, sulfur		



V 610

Berstorff Extruder Ø 90 mm 16D

Extrusion conditions		with vacuum
Barrel	°C	30-30-40
Head	°C	40
Length of salt bath	m	10
Curing temperature	°C	240
Extrusion rate	m/min	5
Dimensions of profile	mm	7 x 22

Physical properties

Density	g/cm ³	1.40
Hardness	Shore A	61
Tensile strength	MPa	6.5
Elongation at break	%	620

Compression set

72 h @ 20°C	%	14
-------------	---	----

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.