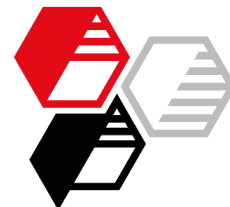
**OTHER APPLICATION****Extrusion, Profile, solid, light-colored****60 Shore A, EPDM, sulfur cure / LCM cure**

Guide formulation of DSM (now Arlanxeo)	V 1662
Keltan 778Z)*	100.0
Zinc oxide	5.0
Stearic acid	2.0
Winnofil S	35.0
SILLITIN N 85	145.0
Silquest A-172NT	2.0
Kronos 2056	15.0
Process Oil P 100 (ex Sunpar 150)	55.0
Protektor G 3108	5.0
Caloxol W3	8.0
TMTD	0.8
TDEC	0.8
DPTT	0.8
MBT	1.5
ETU	1.0
Sulfur	2.0
Total phr	378.9

)* No longer available. Recommended: Keltan 5470C

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	min	1
Discharge	min	5
Indicated discharge temperature	°C	120
Fed to slab-off mill: Caloxol, accelerators, sulfur		



V 1662

Mooney Viscosity

ML (1+4) 100°C	MU	32
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Rheometer, 180°C

Delta S	Nm	3.88
Optimum time	min	6.8
Scorch time	min	2.2

Berstorff Extruder Ø 90 mm 16D

Extrusion conditions		with vacuum
Barrel	°C	40-40-50
Head	°C	55
Length of salt bath	m	10
Curing temperature	°C	240
Extrusion rate	m/min	7.5 / 12.5
Dimensions of profile	mm	7 x 22

Physical properties**Extrusion rate**

		7.5 m/min	12.5 m/min
Hardness	Shore A	57	57
Tensile strength	MPa	6.9	7.0
Elongation at break	%	660	720
Density	g/cm ³	1.41	---

Compression set

22 h @ 70°C	%	56	74
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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.