

OTHER APPLICATION

Extrusion, Profile, solid, light-colored

60 Shore A, EPDM, peroxide cure / LCM cure

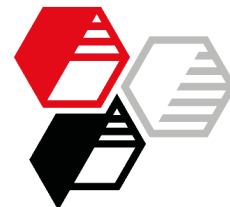
Guide formulation of DSM (now Arlanxeo)	V 1663
Keltan 778Z)*	100.00
Zinc oxide	5.00
Stearic acid	2.00
Winnofil S	35.00
SILLITIN N 85	145.00
Silquest A-172NT	2.00
Kronos 2056	15.00
Process Oil P 100 (ex Sunpar 150)	55.00
Protektor G 3108	5.00
Caloxol W3	8.00
DCP 40 %	8.75
TAC	1.50
Total phr	382.25

)* 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 and TAC	min	1
Discharge	min	4
Indicated discharge temperature	°C	125
Fed to slab-off mill: Caloxol, TAC and peroxide		



V 1663

Mooney Viscosity

ML (1+4) 100°C	MU	32
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Rheometer, 180°C

Delta S	Nm	4.06
Optimum time	min	9.1
Scorch time	min	2.9

Berstorff Extruder Ø 90 mm 16D

Extrusion conditions		with vacuum
Barrel	°C	40-60-70
Head	°C	70
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 speed**

		7.5 m/min	12.5 m/min
Hardness	Shore A	58	59
Tensile strength	MPa	5.9	5.6
Elongation at break	%	570	580
Density	g/cm ³	1.42	---

Compression set

22 h @ 70°C	%	30	28
22 h @ 100°C	%	38	42

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