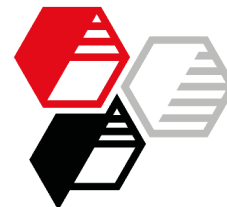
**OTHER APPLICATION****Extrusion, Profile, solid, light-colored****50 Shore A, EPDM, sulfur cure / LCM cure**

Guide formulation of DSM (now Arlanxeo)	V 2092
Keltan 512x50)*	150.0
Zinc oxide	5.0
Stearic acid	1.0
SILLITIN P 87	150.0
Kronos 2056	20.0
Process Oil P 460 (ex Sunpar 2280)	35.0
Caloxol W3	6.0
ETU	1.0
TMTD	0.8
DPTT	0.8
TDEC	0.8
MBT	1.5
Sulfur	1.5
Total phr	373.4

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

Compound preparation**3-D Branbury mixer, volume 47.5 l**

Overload	%	20
Rotor speed	rpm	35
Mixing method:		
Polymer	min	0
Rest except Caloxol, accelerators, sulfur	min	1
Discharge	min	4.5
Indicated discharge temperature	°C	approx. 122
Fed to slab-off mill: Caloxol, accelerators, sulfur		

**Mooney Viscosity**

ML (1+4) 100°C	MU	53
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Rheometer, 160°C

Delta S	Nm	4.09
Optimum time	min	24.5
Scorch time	min	3.0

Berstorff Extruder Ø 90 mm 16D

Extrusion conditions		with vacuum
Barrel	°C	40-60-60
Head	°C	70
Length of salt bath	m	10
Curing temperature	°C	240
Extrusion rate	m/min	7.5
Dimensions of profile	mm	4 x 22

Physical properties

Hardness	Shore A	47
Tensile strength	MPa	7.7
Elongation at break	%	750
Density	g/cm ³	1.33

Compression set

22 h @ 70°C	%	40
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Air aging, 7 d @ 100°C

Hardness	Shore A	54
Tensile strength	MPa	6.9
Elongation at break	%	525

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.