**OTHER APPLICATION****Extrusion, Profile, sponge, black****Density 0.50 g/cm³, EPDM, sulfur cure / UHF cure**

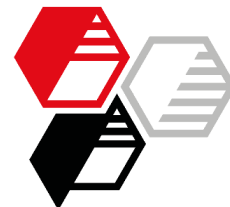
Guide formulation of DSM (now Arlanxeo)	V 2981
Keltan 512x50)*	150.00
Zinc oxide	5.00
Stearic acid	3.00
Durex 0	90.00
SILLITIN Z 86	55.00
Vaseline	10.00
Process Oil P 460 (ex Sunpar 2280)	30.00
Caloxol W3	4.00
MBT	1.00
TDEC	1.00
ZDMC	3.00
DBTU	3.00
Sulfur	1.25
Genitron CR	6.00
Oleamide	1.00
Total phr	363.25

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

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 and blowing agent	min	1
Caloxol W3	min	3
Discharge	min	4
Indicated discharge temperature	°C	105

Fed to slab-off mill: accelerators, sulfur and blowing agent



V 2981

Mooney Viscosity

ML (1+4) 100°C	MU	49
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Rheometer, 160°C

Delta S	Nm	4.75
Optimum time	min	16.0
Scorch time	min	2.2

Berstorff-Extruder Ø 90 mm 16D

Extrusion conditions		with vacuum
Barrel	°C	40-40-50
Head	°C	50

UHF cure, Hertz-four GLH FAT 2x2.5 kW

Energy Magnetron I	A	0.38
Energy Magnetron II	A	0.38
Temperature in air channel (6 m)	°C	250

Profile type

Height	mm	19.5
Inner diameter	mm	13.5
Extrusion rate	m/min	8

Physical properties

Density	g/cm ³	0.53
Water absorption	%	1.0

Compression set

24 h @ RT	%	9
24 h @ 70°C	%	54

Compression deflection

ASTM 1056	kg/100mm	15.5
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