



OTHER APPLICATION

Extrusion, Profile, sponge, black

Good collapse resistance

Density 0.45 g/cm³, EPDM, sulfur cure / LCM cure

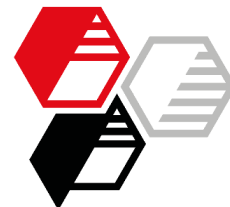
Guide formulation of DSM (now Arlanxeo)	V 2981 B
Keltan 512x50)*	150.00
Zinc oxide	5.00
Stearic acid	3.00
Durex 0	90.00
SILLITIN Z 86	55.00
Process Oil P 460 (ex Sunpar 2280)	30.00
Vaseline	10.00
Crodamide SR	1.00
Calcium oxide 75 %	4.00
ZDMC	3.00
DBTU	3.00
MBT	1.00
TDEC	1.00
Sulfur	1.25
Genitron CR	6.00
Total phr	363.25

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

Compound preparation

3-D Branbury mixer, volume 50 l

Overload	%	10
Rotor speed	rpm	35
Mixing method:		
Polymer	min	0
Zinc oxide, stearic acid, Durex 0, vaseline, Crodamide, calcium oxide, Genitron, Sunpar and SILLITIN in that order	min	1
Discharge	min	3
Indicated discharge temperature	°C	105
Fed to slab-off mill: accelerators and sulfur		



V 2981 B

Mooney Viscosity

ML (1+4) 100°C	MU	49
----------------	----	----

Rheometer, 160°C

Delta S	Nm	4.7
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
Length of salt bath	m	10
Curing temperature	°C	250
Extrusion rate	m/min	10

Profile type

Diameter inside before curing	mm	10
Diameter outside before curing	mm	14
Diameter inside after curing	mm	13.5
Diameter outside after curing	mm	19.5

Physical properties

Density	g/cm ³	0.44
Water absorption	%	none

Compression set

100 h @ 70°C, 50 % deflection	%	70
after post cure 4 h @ 130°C	%	25
after post cure 45 min @ 140°C	%	40

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.