

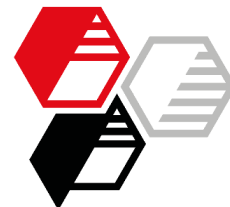
**OTHER APPLICATION****Extrusion, Profile, sponge, black****Ultra-light-weight****Density 0.20 g/cm³, EPDM, sulfur cure / CV cure**

Guide formulation of DSM (now Arlanxéo)	V 3349
Keltan 712)*	100.00
Zinc oxide	5.00
Stearic acid	3.00
Durex 0	70.00
SILLITIN Z 86	55.00
Process Oil P 460 (ex Sunpar 2280)	60.00
Vaseline	10.00
Calcium oxide 75 %	4.00
ZDBC	2.00
MBT	1.00
TDEC	0.60
DPTH	0.40
DNPT	8.00
Sulfur	1.25
Total phr	320.25

)* No longer available. Recommended: Keltan 6460D or Keltan 6950

Monsanto Rheometer 1500S, 160°C

Delta S	Nm	3.2
Optimum time	min	5.8
Scorch time	min	1.8



V 3349

Cure of profile

Length / temperature

Extrusion rate

m/min

salt bath

10 m / 240°C

13

UHF / air

6 m / 250°C

20

Physical properties

Density

g/cm³

0.22

0.16

Water absorption 7 d @ 23°C

%

1.6

2.2

Compression deflection

ASTM 1056

kg/5 cm

14.5

6.6

Compression set

70 h @ 70°C, 50 % deflection

%

89

92

post cured 5 h @ 120°C

%

76

84

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