**OTHER APPLICATION****Extrusion, Profile, solid, light-colored****65 Shore A, EPDM, peroxide cure / LCM cure**

Guide formulation of DSM (now Arlanxeo)		V 4243
Keltan 512x50	)*	120.0
Keltan 778Z	)**	20.0
Stearic acid		1.0
SILLITIN P 87		200.0
Perkasil KS 300		30.0
Mistron Vapor	)***	20.0
Kronos 2056		20.0
Process Oil P 460 (ex Sunpar 2280)		25.0
Struktol WB 16		2.0
Protektor G 3108		5.0
Caloxol W3		10.0
Perkadox 14-40		8.0
EDMA		1.5
Total phr		462.5

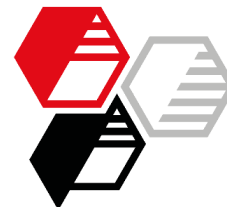
)* No longer available. Recommended: Keltan 4450 + 50 phr paraffin oil

)** No longer available. Recommended: Keltan 5470C

)*** No longer available. Recommended: ImerFlex T10C

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

Overload	%	10
Rotor speed	rpm	35
Mixing method:		
Polymer	min	0
Rest except Caloxol, Perkadox and EDMA	min	1
Discharge	min	4
Indicated discharge temperature	°C	120
Fed to slab-off mill: Caloxol, Perkadox and EDMA		



V 4243

Mooney Viscosity

ML (1+4) 100°C	MU	76
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Rheometer, 180°C

Delta S	Nm	5.32
Optimum time	min	12.9
Scorch time	min	2.5

Berstorff Extruder Ø 90 mm 16D

Extrusion conditions		with vacuum
Barrel	°C	40-40-40
Head	°C	50
Length of salt bath	m	10
Curing temperature	°C	240
Extrusion rate	m/min	7.5
Dimensions of profile	mm	5 x 22

Physical properties

Hardness	Shore A	63
Tensile strength	MPa	6.8
Elongation at break	%	590
Density	g/cm ³	1.45

Compression set

22 h @ 70°C	%	25
22 h @ 100°C	%	33

Air aging, 7 d @ 100°C

Hardness	Shore A	66
Tensile strength	MPa	6.9
Elongation at break	%	410

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.