



OTHER APPLICATION

Extrusion, Profile, sponge, light-colored

Draught excluder

Density 0.60 g/cm³, EPDM, sulfur cure / LCM cure

Guide formulation of DSM (now Arlanxeo)	V 9664 B
Keltan 509x100)*	200.0
Zinc oxide	5.0
Stearic acid	2.0
Supercarborex	100.0
SILLITIN Z 86	80.0
Titanium dioxide	20.0
PEG 4000	2.0
Process Oil P 460 (ex Sunpar 2280)	80.0
MBT	1.0
ZDBC	2.0
DPTH	0.4
Sulfur	1.5
Genitron CR	5.0
Total phr	498.9

)* No longer available. Recommended: Keltan 4869

Compound preparation

3-D Branbury mixer

Overload	%	32.5
Rotor speed	rpm	35
Mixing method:		
Polymer, zinc oxide, stearic acid and accelerators	min	0
Rest except blowing agent	min	2.5
Discharge	min	6.5
Indicated discharge temperature	°C	88
Fed to slab-off mill: blowing agent		



V 9664 B

LCM cure

Length of salt bath	m	10
Curing temperature	°C	240
Extrusion rate	m/min	10 / 12.5

Physical properties**Extrusion speed**

		10 m/min	12.5 m/min
Density	g/cm ³	0.56	0.64

Compression set

24 h @ 70°C, 25 % deflection	%	46	56
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