



## AUTOMOTIVE INDUSTRY

### Molding, black

#### Quarter light gasket

60 Shore A, EPDM, sulfur cure / injection/transfer molding

Specification Renault 2 6 07 B1

Guide formulation of Exxon		911 C 152
Vistalon 3666		87.5
Vistalon 9500		50.0
SRF N-774		100.0
SILLITIN P 87		40.0
Grundöl AP/E Core 2500 (ex Flexon 815)		45.0
PEG 3350		3.0
Struktol WB 16		3.0
Kagevest 25 (ex Polyvest 25)		2.0
Stearic acid		1.5
Zinc oxide		8.0
Sulfur		2.0
MBT		1.0
ZBEC		0.5
Vulkalent E/C		0.3
Rheonogran ZAT-70		2.0
Total phr		345.8
Density	g/cm <sup>3</sup>	1.17
<b>Mooney Viscosity</b>		
ML (1+4) 100°C	MU	43
ML (1+4) 121°C	MU	33
<b>ODR, ± 3°, 180°C</b>		
ML, minimum	dNm	6
MH, maximum	dNm	52
ts <sub>2</sub>	min	0.8
tc <sub>90</sub>	min	3.0

**Physical properties****Press cure 5 min @ 180°C**

Hardness	Shore A	62
Modulus 100 %	MPa	2.9
Tensile strength	MPa	7.5
Elongation at break	%	380

**Compression set****Press cure 8 min @ 180°C**

22 h @ RT, 25 % defl.	ASTM B	%	6
22 h @ 100°C, 25 % defl.	ASTM B	%	38

**Injection molding conditions**

Pressure	bar	110
Injection time	s	10
Vulcanization temperature	°C	170
Vulcanization time	s	200

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