



AUTOMOTIVE INDUSTRY

Profile, solid, black

Weatherstrip

60 Shore A, EPDM, sulfur cure / UHF cure

Specification VW TL 520.15

Guide formulation of Exxon		911 K 077
Vistalon 3666		35.0
Vistalon 8510)*		92.0
APF N-683		85.0
SILLITIN Z 86		50.0
Grundöl AP/E Core 600 (ex Flexon 876)		45.0
PEG 3350		3.0
Stearic acid		1.0
Zinc oxide		5.0
Calcium oxide		8.0
Sulfur		0.5
MBT		1.0
TMTD		0.5
ZDBC		1.4
ZEPC		0.8
TDEC		0.4
DPTT		1.0
Total phr		329.6
Density	g/cm ³	1.2

)* No longer available. Recommended: Vistalon 8800

Mooney Viscosity

ML (1+4) 100°C MU 50

Mooney Scorch

MS (t₅) 125°C min 6.2

ODR, ± 3°, 180°C

ML, minimum dNm 8

MH, maximum dNm 46

ts₂ min 0.6

tC₉₀ min 2.2

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

Hardness		Shore A	57
Modulus 100 %		MPa	1.8
Tensile strength		MPa	10.7
Elongation at break		%	490
Tear resistance	DIN ISO 34-1, A	N/mm	6.2

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

22 h @ 70°C, 25 % defl.	ASTM B	%	19
22 h @ 70°C, 25 % defl.	VW	%	46
100 h @ 70°C, 25 % defl.	VW	%	54

Air aging, 7 d @ 100°C

Hardness		Shore A	65
Tensile strength		MPa	9.7
Elongation at break		%	240

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.