

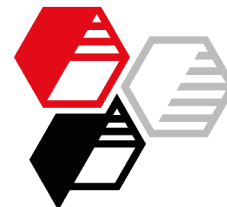
AUTOMOTIVE INDUSTRY

Profile, solid, black

Solid foot roof gutter, bi-extruded

85 Shore A, EPDM, sulfur cure / UHF cure

Guide formulation of Exxon		E91/551
Vistalon 9500		100.0
SRF N-765		160.0
MT N-990		30.0
SILLITIN Z 86		30.0
Polyethylene wax		15.0
Grundöl AP/E Core 2500 (ex Flexon 815)		40.0
Zinc oxide		8.0
Stearic acid		2.0
PEG 3350		4.0
Rhenogran CaO-80		4.5
Struktol WB 16		3.0
TMQ		1.0
Sulfur		1.0
MBT		0.5
MBTS		1.0
TMTD		0.8
DTDM		1.0
ZDBC		0.7
Total phr		402.5
Density	g/cm ³	1.3
Mooney Viscosity		
ML (1+4) 100°C	MU	112
Mooney Scorch		
MS (ts ₅) 125°C	min	4
Monsanto Rheometer, ± 3°, 180°C		
ML, minimum	dNm	20
MH, maximum	dNm	98
ts ₂	min	0.5
tC ₉₀	min	1.6



E91/551

Physical properties**Press cure 4 min @ 180°C**

Hardness	Shore A	88/86
Modulus 100 %	MPa	7.8
Tensile strength	MPa	9.9
Elongation at break	%	145

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

22 h @ 100°C, 25 % defl.	ASTM B	%	51
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Air aging, 14 d @ 100°C

Hardness	Shore A	90/89
Tensile strength	MPa	10.6
Elongation at break	%	85
Δ Hardness	Shore A	+3
Δ Tensile strength	%	+7
Δ Elongation at break	%, rel.	-41

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