



AUTOMOTIVE INDUSTRY

Profile, solid, black

Dual hardness extrusion

55/80 Shore A, EPDM, sulfur cure

Guide formulations of Exxon	M 645	M 646
Vistalon 3666	175.00	---
Vistalon 7001	---	100.00
SRF N-774	110.00	125.00
Grundöl AP/E Core 600 (ex Flexon 876)	35.00	40.00
SILLITIN Z 86	100.00	---
PEG 4000	2.00	2.00
Zinc oxide	10.00	7.00
Stearic acid	1.50	1.50
Rhenogran CaO-80	11.25	5.63
Sulfur	1.00	1.00
MBT	1.50	1.50
TMTD	0.75	0.75
ZDMC	0.75	0.75
TDEC	0.75	0.75
DPTT	0.75	0.75
Total phr	450.25	286.63
Density	g/cm ³	
	1.26	1.18

ODR, ± 5°, 180°C

ML, minimum	dNm	19.2	24.9
MH, maximum	dNm	71.2	151.4
ts ₂	min	0.9	0.5
tc ₉₀	min	2.2	2.0



M 645

M 646

Physical properties**Hot air cure 8 min @ 200°C**

Hardness	Shore A	54	80
Modulus 100 %	MPa	2.0	6.9
Modulus 300 %	MPa	4.7	9.7
Tensile strength	MPa	8.5	9.9
Elongation at break	%	540	330

Compression set**Press cure 3.5 min @ 180°C**

22 h @ 70°C, 25 % deflection	ASTM B	%	26	23
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Air aging, 7 d @ 70°C

Δ Hardness	Shore A	+1	+1
Tensile strength	MPa	8.6	10.2
Elongation at break	%	510	300

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