



## AUTOMOTIVE INDUSTRY

### Profile, sponge, black

#### Door seal tube

Density 0.55 g/cm<sup>3</sup>, EPDM, sulfur cure / LCM cure

Guide formulation of Exxon		M 704
Vistalon 6630	)*	130.00
FEF N-550		70.00
SILLITIN N 82	)**	30.00
Paraffin oil		40.00
Zinc oxide		8.00
Stearic acid		1.00
Rhenogran CaO-80		2.25
Genitron CR		2.50
Celogen OT		1.50
Carbowax PEG 4000		2.00
Sulfur		1.00
MBT		2.50
TMTD		0.80
ZDMC		0.80
ZDEC		1.00
ZDBC		0.80
Total phr		294.15
Density	g/cm <sup>3</sup>	1.14

)\* No longer available. Recommended: 100 phr Vistalon 8700 + 30 phr plasticizer

)\*\* No longer available. Recommended: SILLITIN N 75

#### Monsanto Rheometer, ± 5°

		120°C	200°C
ML, minimum	dNm	14.3	10
MH, maximum	dNm	---	50
ts <sub>2</sub>	min	3.4	0.3
tc <sub>90</sub>	min	---	1.4



M 704

**Physical properties, Renault 16 door seal tubing profile****LCM cure 45 s @ 225°C**

Density		g/cm <sup>3</sup>	0.53
Tensile strength		MPa	2.8
Elongation at break		%	410
Water absorption	ASTM D 1056	%	50
Water absorption	Renault method	%	2.5

**Compression deflection**

		(Nx10)/5 cm	1.3
50 % deflection, speed 2 "/min, 5. force recorded			
Wall thickness		mm	2.5

**Compression set**

			<b>original</b>	<b>post cured 1 h @ 130°C</b>
22 h @ 70°C, 50 % deflection	ASTM B	%	21	16
7 d @ 70°C, 50 % deflection	ASTM B	%	59	54

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