

AUTOMOTIVE INDUSTRY

Profile, solid, black

Door seal, low hardness

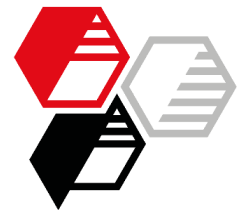
25 Shore A, EPDM, sulfur cure / UHF cure

Specification Renault and VW

Guide formulation of Exxon		M 819
Vistalon 3666		175.00
SILLITIN Z 86		100.00
Perkasil KS 300		30.00
FEF N-550		20.00
Grundöl AP/E Core 600 (ex Flexon 876)		60.00
Jayflex DINA		20.00
Zinc oxide		15.00
Rhenofit C		15.00
PEG 4000		10.00
Kagevest 25 (ex Polyvest 25)		3.00
Stearic acid		1.50
Oleamide		6.00
Sulfur		1.00
MBT		1.50
TMTD		0.75
ZDMC		0.75
DPTT		0.75
DTDM		0.75
Total phr		461.00
Density	g/cm ³	1.13

Monsanto Rheometer, ± 5°, 180°C

ML, minimum	dNm	9.0
MH, maximum	dNm	24.9
ts ₂	min	1.4
tc ₉₀	min	3.0



M 819

			Press	UHF
			5 min @ 180°C	
Physical properties				
Hardness		Shore A	36/33	26/22
Modulus 100 %		MPa	0.8	0.5
Modulus 300 %		MPa	2.0	1.0
Tensile strength		MPa	8.2	4.2
Elongation at break		%	860	760
Compression set				
UHF cured hose				
22 h @ 70°C, 55 % defl.	ASTM B	%		9
7 d @ 70°C, 55 % defl.	ASTM B	%		50
22 h @ -20°C, 55 % defl.	ASTM B	%		54
Renault Spec.				
				≤ 35
				≤ 55

Compression set				
UHF cured hose				
100 h @ RT, 50 % defl.	VW	%		16
100 h @ 70°C, 50 % defl. (relaxation 3 h @ RT)	VW	%		40
VW Spec.				
				≤ 25
				≤ 45

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