



## MACHINERY and EQUIPMENT

### Appliance, Hose, light-colored

#### Washing machine drain hose

80 Shore A, EPDM, sulfur cure

Guide formulation of DSM (now Arlanxeo)	V 5390
Keltan 578Z )*	100.0
Zinc oxide	5.0
Stearic acid	3.0
SILLIKOLLOID P 87	250.0
Mistron Vapor )**	35.0
Process Oil P 460 (ex Sunpar 2280)	50.0
Titanium dioxide	20.0
Paraffin wax	5.0
Dispergator DS	5.0
TMTD	2.0
ZDMC	3.0
ZDBC	3.0
DTDM	1.5
Sulfur	0.5
Total phr	483.0

)\* No longer available. Recommended: Keltan 5470 or Keltan 5470Q

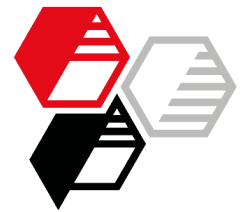
\*\* No longer available. Recommended: ImerFlex T10C

### Compound preparation

#### 3-D Branbury mixer

Volume load	%	90
Batch size	kg	67.4
Rotor speed	rpm	35
Mixing method:		
Polymer	min	0
Rest except accelerators and sulfur	min	1
Discharge	min	6.5
Indicated discharge temperature	°C	114

Fed to slab-off mill: accelerators and sulfur



V 5390

**Mooney Viscosity**

ML (1+4) 100°C MU 85

**Monsanto Rheometer 1500S, 160°C**

Delta S Nm 5  
 Optimum time min 13.0  
 Scorch time min 2.7

**Extrusion conditions**

Barrel °C 50-50-55-55  
 Head °C 65  
 Compound extrusion temperature °C 100-110  
 Extrusion rate m/min 24

**Profile type**

Shape ribbed hose  
 Inside diameter mm 19  
 Outside diameter mm 27

**Physical properties**

Hardness Shore A 75  
 Tensile strength MPa 6.4  
 Elongation at break % 540

**Compression set**

24 h @ 70°C, 25 % deflection % 25  
 24 h @ 100°C, 25 % deflection % 45

**Air aging**

		<b>3 d @ 70°C</b>	<b>3 d @ 120°C</b>
Hardness	Shore A	81	83
Tensile strength	MPa	5.4	6.4
Elongation at break	%	475	250

**Chemical resistance, 3 d @ 100°C**

			<b>Miele TLK 2007</b>
Water		good	
Prodixan, 15 g/l		Hardness +5	+5 max.
NaOH, 10 g/l		good	
Sodium-dichloro-isocyanurate, 0.1 g/l		good	
Bayer AS		Hardness +6	+5 max.

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