

**MACHINERY and EQUIPMENT****Roller cover, light-colored****80 Shore A, EPDM, sulfur cure**

Guide formulations of Degussa (now Evonik)	RRS 24	RRS 25
Buna AP 341)*	100	100
SILLITIN Z 86	130	130
Ultrasil VN 2	50	---
Coupsil 6411	---	55
Zinc oxide RS	5	5
Stearic acid	1	1
Process Oil P 460 (ex Sunpar 2280)	25	25
Koresin	2	2
PEG 6000	5	5
CBS	2	2
ZBEC	---	2
TMTD	1	---
ZEPC	1	---
ZDBC	2	---
Sulfur	1	1
Total phr	325	328

)* No longer available. Recommended: Keltan 4450

Mooney Viscosity

ML (1+4) 100°C	MU	129	101
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Mooney Scorch

MS (t ₅) 130°C	min	4.34	6.11
MS (t ₃₅) 130°C	min	7.13	9.56

Rheometer, 180°C

M _{HF} - M _L	Nm	14.74	12.75
M _L	Nm	2.45	1.65
t _{10%}	min	4.4	4.4
t _{95%}	min	27.5	14.0



			RRS 24	RRS 25
Physical properties				
Cure @ 180°C				
			35 min	20 min
Hardness	DIN ISO 7619-1	Shore A	80	79
Tensile strength	DIN 53504, RI	MPa	7.2	8.9
Modulus 300 %		MPa	4.5	7.8
Elongation at break		%	520	400
Rebound	DIN 53512	%	42	40
Abrasion	DIN ISO 4649	mm ³	446	385
Compression set				
22 h @ 70°C	ASTM D 395 B	%	21	18
100 h @ 70°C	ASTM D 395 B	%	25	20
Air aging, 7 d @ 120°C				
Hardness		Shore A	87	85
Tensile strength		MPa	8.3	10.5
Modulus 200 %		MPa	7.3	9.8
Elongation at break		%	310	230

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