# Bergaflex™ BFI 70A-3106

## Thermoplastic Elastomer

### Key Characteristics

| Product Description | | |
|---|---|---|
| Bergaflex™ BFI 70A-3106 is an easy processing, general purpose TPE.<br>Material is semi filled,opaque and has therefore a medium density. | | |
| **General** | | |
| Material Status | • Commercial: Active | |
| Regional Availability | • Europe | |
| Features | • General Purpose<br>• Good Flow | • Good Processability<br>• Good Processing Stability |
| RoHS Compliance | • RoHS Compliant | |
| Appearance | • Black | • Natural Color |
| Forms | • Pellets | |
| Processing Method | • Injection Molding | |

### Technical Properties [1]

| Physical | Typical Value (English) | Typical Value (SI) | Test Method |
|---|---|---|---|
| Density / Specific Gravity | 0.990 | 0.990 | ISO 1183 |
| **Elastomers** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Tensile Strength [2, 3] (Break, 73°F (23°C)) | 1160 psi | 8.00 MPa | DIN 53504 |
| Tensile Elongation [2, 3] (Break, 73°F (23°C)) | 650 % | 650 % | DIN 53504 |
| Tear Strength [4] | | | ISO 34-1 |
| 73°F (23°C), 0.0787 in (2.00 mm) | 137 lbf/in | 24.0 kN/m | |
| Compression Set (73°F (23°C), 72 hr) | 35 % | 35 % | ISO 815 |
| **Hardness** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Shore Hardness (Shore A, 10 sec) | 70 | 70 | ISO 48-4 |

### Processing Information

| Injection | Typical Value (English) | Typical Value (SI) |
|---|---|---|
| Rear Temperature | 320 to 338 °F | 160 to 170 °C |
| Middle Temperature | 338 to 374 °F | 170 to 190 °C |
| Front Temperature | 365 to 428 °F | 185 to 220 °C |
| Nozzle Temperature | 374 to 428 °F | 190 to 220 °C |
| Mold Temperature | 86 to 122 °F | 30 to 50 °C |
| Back Pressure [5] | 290 to 1450 psi | 2.00 to 10.0 MPa |
| Screw Speed | 40 to 100 rpm | 40 to 100 rpm |

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| Injection Notes |
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Purge thoroughly before and after use of this product with a low flow (0.5 - 2.5 MFR) polyethylene (PE) or polypropylene (PP).

Bergaflex™ BFI 70A-3106 has excellent melt stability. Maximum residence times may vary, depending on the size of the barrel. Generally, the barrel should be emptied if it is idle for periods of 8 - 10 minutes or longer.

Drying is not Required

Injection Speed: 1 to 3 in/sec
1st Stage - Boost Pressure: 350 to 900 psi
2nd Stage - Hold Pressure: 30% of Boost
Hold Time (Thick Part): 3 to 10 sec
Hold Time (Thin Part): 1 to 3 sec

### Notes

[1] Typical values are not to be construed as specifications.

[2] 7.9 in/min (200 mm/min)

[3] Specimen type S2

[4] Method Ba, Angle (Unnicked), 20 in/min (500 mm/min)

[5] If you use color masterbatches, higher back pressure is necessary.

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