Bergaflex™ BFI F 40A-3E1196 Transparent

Thermoplastic Elastomer

Key Characteristics

Product Description			
Bergaflex™ BFI F 40A-3E1196 Transparent is an easy processing, easy coloring, general purpose TPE designed for a wide variety of applications.High resistance against acids and bases and alcohols. High ozone and UV resistance.			
General			
Material Status	• Commercial: Active		
Regional Availability	• Europe		
Features	• General Purpose	• Good Processability	• UV Resistant
RoHS Compliance	• RoHS Compliant		
Appearance	• Clear/Transparent		
Forms	• Pellets		
Processing Method	• Injection Molding		

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	0.890	0.890	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/5.0 kg)	6.0 cm³/10min	6.0 cm³/10min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow : 73°F (23°C), 24 hr, 0.0787 in (2.00 mm)	1.0 %	1.0 %	
Flow : 73°F (23°C), 24 hr, 0.0787 in (2.00 mm)	3.1 %	3.1 %	
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Strength (Break, 73°F (23°C))	899 psi	6.20 MPa	ISO 37
Tensile Elongation (Break, 73°F (23°C))	670 %	670 %	ISO 37
Compression Set			ISO 815
73°F (23°C), 72 hr	22 %	22 %	
158°F (70°C), 23 hr	60 %	60 %	
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Shore Hardness [2] (Shore A, 10 sec)	40	40	ISO 48-4
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec^-1	11.1 Pa·s	11.1 Pa·s	

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Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Rear Temperature	338 to 347 °F	170 to 175 °C
Middle Temperature	347 to 374 °F	175 to 190 °C
Front Temperature	374 to 428 °F	190 to 220 °C
Nozzle Temperature	383 to 428 °F	195 to 220 °C
Mold Temperature	86 to 122 °F	30 to 50 °C
Back Pressure [3]	290 to 1450 psi	2.00 to 10.0 MPa
Screw Speed	40 to 100 rpm	40 to 100 rpm

Injection Notes

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

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] +-5 Sh. A

[3] If color materbatches are used, higher back pressure is necessary.

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