Bergaflex™ BFI K F 50A-3E625

Thermoplastic Elastomer

Key Characteristics

Product Description
Bergaflex BFI K F 50A-3E625 is an easy processing TPE, compatabilized to provide excellent adhesion to polyamide polymers and may be appropriate where FDA and EU 10/2011 compliances are required. Material is filled, opaque and has therefore a moderate high density.

General			
Material Status	• Commercial: Active		
Regional Availability	• Europe		
Features	• Food Contact Acceptable	• General Purpose	• Good Adhesion
Uses	• Appliances • Consumer Applications	• General Purpose • Non-specific Food Applications	
Agency Ratings	• EU 10/2011 [1]	• FDA 21 CFR 177.1210 [1]	• FDA 21 CFR 177.2600 [1]
RoHS Compliance	• RoHS Compliant		
Appearance	• Yellow		
Forms	• Pellets		
Processing Method	• Injection Molding		

Technical Properties [2]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density	1.18 g/cm³	1.18 g/cm³	ISO 1183
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress (Break)	580 psi	4.00 MPa	ISO 37
Tensile Elongation (Break)	400 %	400 %	ISO 37
Compression Set			ISO 815
73°F (23°C), 72 hr	28 %	28 %	
158°F (70°C), 22 hr	71 %	71 %	
212°F (100°C), 22 hr	80 %	80 %	
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Shore Hardness (Shore A, 10 sec)	50	50	ISO 48-4

Additional Information
Properties are measured using injection molded plaques.

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	212 °F	100 °C
Drying Time	2.0 hr	2.0 hr
Rear Temperature	356 to 374 °F	180 to 190 °C
Middle Temperature	374 to 410 °F	190 to 210 °C
Front Temperature	401 to 464 °F	205 to 240 °C
Nozzle Temperature	410 to 464 °F	210 to 240 °C
Mold Temperature	86 to 140 °F	30 to 60 °C
Injection Rate	Fast	Fast
Back Pressure [3]	290 to 1450 psi	2.00 to 10.0 MPa

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Injection	Typical Value (English)	Typical Value (SI)
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).

Bergaflex™ BFI K F 50A-3E625 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.

In general, the fill time should not be more than 1-2 seconds.

Notes

[1] Product rating may be influenced by end product design and/or conditions of use. Please contact GLS Thermoplastic Elastomers for information addressing EU (EU, 10/2011) and FDA (21 CFR 177.1210 & 21 CFR 177.2600) compliance.

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

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

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