Bergaflex™ BFI 75A-328 Black SO1

Thermoplastic Elastomer

Key Characteristics

Product Description			
Bergaflex™ BFI 75A-328 black SO1 is an easy processing, general purpose thermoplastic elastomer based on styrenic block copolymers. Material is semi filled, opaque and has a medium denisty.			
General			
Material Status	• Commercial: Active		
Regional Availability	• Asia Pacific	• Europe	• North America
Features	• General Purpose	• Good Flow	• Good Processability
Uses	• Appliances • Automotive Applications	• Consumer Applications • General Purpose	• Industrial Applications
RoHS Compliance	• RoHS Compliant		
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Injection Molding		

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	0.970	0.970	ISO 1183
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress [2]			ISO 37
Break, 73°F (23°C), 0.0787 in (2.00 mm)	1490 psi	10.3 MPa	
Tensile Elongation [2]			ISO 37
Break, 73°F (23°C), 0.0787 in (2.00 mm)	710 %	710 %	
Compression Set			ISO 815
73°F (23°C), 72 hr	25 %	25 %	
158°F (70°C), 22 hr	42 %	42 %	
212°F (100°C), 22 hr	81 %	81 %	
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Shore Hardness (Shore A, 10 sec)	75	75	ISO 48-4

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Suggested Max Regrind	20 %	20 %
Rear Temperature	329 to 347 °F	165 to 175 °C
Middle Temperature	347 to 383 °F	175 to 195 °C
Front Temperature	365 to 437 °F	185 to 225 °C
Nozzle Temperature	383 to 437 °F	195 to 225 °C
Mold Temperature	68 to 104 °F	20 to 40 °C
Back Pressure	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

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 75A-328 black SO1 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)

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