# Bergaflex™ BFI 75A-320

## Thermoplastic Elastomer

### Key Characteristics

| Product Description | | | |
|---|---|---|---|
| Bergaflex™ BFI 75A-320 is an easy processing, general purpose thermoplastic elastomer based on styrenic block copolymers. Material is filled, opaque and has a high denisty. | | | |
| **General** | | | |
| Material Status | • Commercial: Active | | |
| Regional Availability | • Asia Pacific | • Europe | • North America |
| Features | • General Purpose | • Good Flow | • Good Processability |
| Uses | • Appliances<br>• Automotive Applications | • Consumer Applications<br>• General Purpose | • Industrial Applications |
| RoHS Compliance | • RoHS Compliant | | |
| Forms | • Pellets | | |
| Processing Method | • Injection Molding | | |

### Technical Properties [1]

| Physical | Typical Value (English) | Typical Value (SI) | Test Method |
|---|---|---|---|
| Density / Specific Gravity | 1.18 | 1.18 | 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) | 1170 psi | 8.10 MPa | |
| Tensile Elongation [2] | | | ISO 37 |
| Break, 73°F (23°C), 0.0787 in (2.00 mm) | 620 % | 620 % | |
| Compression Set | | | ISO 815 |
| 73°F (23°C), 72 hr | 25 % | 25 % | |
| 158°F (70°C), 22 hr | 42 % | 42 % | |
| **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-320 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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