Bergaflex™ BFI 65A-3E1668

Thermoplastic Elastomer

Key Characteristics

Product Description		
Bergaflex™ BFI 65A-3E1668 is an easy processing, general purpose TPE.		
General		
Material Status	• Commercial: Active	
Regional Availability	• Asia Pacific	• Europe
Features	• General Purpose • Good Flow	• Good Processability • Good Processing Stability
RoHS Compliance	• RoHS Compliant	
Appearance	• Grey	
Forms	• Pellets	
Processing Method	• Injection Molding	

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.20	1.20	ASTM D792
Melt Volume-Flow Rate (MVR) (190°C/5.0 kg)	8.0 to 35 cm³/10min	8.0 to 35 cm³/10min	ISO 1133
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Strength [2, 3] (Break, 73°F (23°C))	725 psi	5.00 MPa	ASTM D412
Tensile Elongation [2, 3] (Break, 73°F (23°C))	550 %	550 %	ASTM D412
Tear Strength	183 lbf/in	32.0 kN/m	ISO 34-1
Compression Set			ASTM D395
73°F (23°C), 72 hr	28 %	28 %	
158°F (70°C), 22 hr	90 %	90 %	
212°F (100°C), 22 hr	100 %	100 %	
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	60 to 70	60 to 70	ASTM D2240
Shore Hardness	64 to 70	64 to 70	ISO 48-4
Flammability	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Burning Rate (0.0591 in (1.50 mm))	1.6 in/min	40 mm/min	FMVSS

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Rear Temperature	330 to 350 °F	166 to 177 °C
Middle Temperature	350 to 380 °F	177 to 193 °C
Front Temperature	370 to 440 °F	188 to 227 °C
Nozzle Temperature	380 to 440 °F	193 to 227 °C
Mold Temperature	60 to 100 °F	16 to 38 °C
Back Pressure	0.00 to 120 psi	0.00 to 0.827 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 65A-3E1668 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] Die C

[3] 2 hr

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