Bergaflex™ BFI 70A-302 Natural

Thermoplastic Elastomer

Key Characteristics

Product Description		
Bergaflex™ BFI 70A-302 Natural is an easy processing, general purpose TPE. Material is filled,opaque and has therefore a high density.		
General		
Material Status	• Commercial: Active	
Regional Availability	• Europe	
Features	• General Purpose • Good Flow	• Good Processability • Good Processing Stability
RoHS Compliance	• RoHS Compliant	
Appearance	• Natural Color	
Forms	• Pellets	
Processing Method	• Injection Molding	

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.17	1.17	ISO 1183
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Strength [2, 3] (Break, 73°F (23°C))	899 psi	6.20 MPa	DIN 53504
Tensile Elongation [2, 3] (Break, 73°F (23°C))	650 %	650 %	DIN 53504
Compression Set			ISO 815
73°F (23°C), 72 hr	19 %	19 %	
158°F (70°C), 22 hr	42 %	42 %	
212°F (100°C), 22 hr	80 %	80 %	
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Shore Hardness (Shore A, 10 sec)	70	70	ISO 48-4

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Rear Temperature	320 to 338 °F	160 to 170 °C
Middle Temperature	338 to 374 °F	170 to 190 °C
Front Temperature	365 to 428 °F	185 to 220 °C
Nozzle Temperature	374 to 428 °F	190 to 220 °C
Mold Temperature	86 to 122 °F	30 to 50 °C
Back Pressure [4]	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 70A-302 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)

[3] Specimen type S2

[4] If you use color masterbatches, higher back pressure is necessary.

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