Bergaflex™ BFI 85A-6E331

Thermoplastic Elastomer

Key Characteristics

Product Description			
Bergaflex™ BFI 85A-6E331 is an easy processing, general purpose TPE. Material is filled, opaque and has therefore a high density.			
General			
Material Status	• Commercial: Active		
Regional Availability	• Asia Pacific	• Europe	• North America
Features	• General Purpose	• Good Processability	
Uses	• Appliances • Automotive Applications	• Consumer Applications • 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	1.17	1.17	ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/5.0 kg)	12 g/10 min	12 g/10 min	ISO 1133
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)	870 psi	6.00 MPa	
Tensile Elongation [2]			ISO 37
Break, 73°F (23°C), 0.0787 in (2.00 mm)	500 %	500 %	
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Shore Hardness (Shore A, 10 sec)	85	85	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 85A-6E331 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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