# Bergaflex™ BFI 65A-3E1809

## Thermoplastic Elastomer

### Key Characteristics

| Product Description | | | |
|---|---|---|---|
| Bergaflex™ BFI 65A-3E1809 is an easy processing, general purpose thermoplastic elastomer based on styrenic block copolymers.<br>Material is filled and is therefore opaque and has a high density. | | | |
| **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 | | |
| Appearance | • Black | | |
| 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 | ISO 1183 |
| Melt Volume-Flow Rate (MVR) (190°C/5.0 kg) | > 14 cm³/10min | > 14 cm³/10min | 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) | 653 psi | 4.50 MPa | |
| Tensile Elongation [2] | | | ISO 37 |
| Break, 73°F (23°C), 0.0787 in (2.00 mm) | 420 % | 420 % | |
| **Hardness** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Shore Hardness (Shore A, 10 sec) | 65 | 65 | 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).

Regrind levels up to 20% can be used with Bergaflex™ BFI 65A-3E1809 with minimal property losses, provided that the regrind is free of
contamination. To minimize losses during molding, the melt temperature should be as low as possible. The final determination of regrind
effectiveness should be determined by the customer.

Bergaflex BFI 65A-3E1809 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

## Notes

[1] Typical values are not to be construed as specifications.

[2] 7.9 in/min (200 mm/min)

## CONTACT INFORMATION

**North America**
Avon Lake, United States
33587 Walker Road
Avon Lake, OH, United States , 44012
+1 440 930 1000
+1 844 4AVIENT

**South America**
Sao Paulo, Brazil
Av. Francisco Nakasato, 1700
13295-000 Itupeva
Sao Paulo, Brazil
+55 11 4593 9200

**Asia**
Shanghai, China
2F, Block C
200 Jinsu Road
Pudong, 201206
Shanghai, China
+86 (0) 21 6028 4888

**Europe**
Pommerloch, Luxembourg
19 Route de Bastogne
Pommerloch, Luxembourg , L-9638
+352 269 050 35

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