Bergaflex™ BFI 35A-322

Thermoplastic Elastomer

Key Characteristics

Product Description
Bergaflex thermoplastic elastomer compounds are based on hydrogenated styrenic block copolymers. This range of compounds are formulated to deliver a great cost/performance ratio in addition to typical Bergaflex properties such as a wide hardness range, good mechanical properties, good processability, good colourability and a wide temperature operating range. BFI 35-322 is filled and is therefore opaque and has a moderate high density.

General			
Material Status	• Commercial: Active		
Regional Availability	• Europe		
Features	• General Purpose		
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	1.18 g/cm³	1.18 g/cm³	ISO 1183
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress (Break)	653 psi	4.50 MPa	ISO 37
Tensile Elongation (Break)	750 %	750 %	ISO 37
Compression Set			ISO 815
73°F (23°C), 72 hr	16 %	16 %	
158°F (70°C), 22 hr	47 %	47 %	
212°F (100°C), 22 hr	80 %	80 %	
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Shore Hardness (Shore A, 10 sec)	35	35	ISO 48-4

Additional Information
Properties are measured using injection molded plaques.

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Rear Temperature	338 to 347 °F	170 to 175 °C
Middle Temperature	347 to 374 °F	175 to 190 °C
Front Temperature	374 to 428 °F	190 to 220 °C
Nozzle Temperature	383 to 428 °F	195 to 220 °C
Mold Temperature	86 to 140 °F	30 to 60 °C
Back Pressure [2]	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).

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] If color masterbatches are used, higher back pressure is necessary

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