Bergaflex™ BFI G 25A Natural

Thermoplastic Elastomer

Key Characteristics

Product Description			
BFI G 35-322 is an easy processing TPE with excellent mechanical properties and low odor. Material is filled, opaque and has a moderate high density.			
General			
Material Status	• Commercial: Active		
Regional Availability	• Asia Pacific	• Europe	
Features	• General Purpose	• Low Odor	
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)	334 psi	2.30 MPa	ISO 37
Tensile Elongation (Break)	650 %	650 %	ISO 37
Compression Set			ISO 815
73°F (23°C), 72 hr	20 %	20 %	
158°F (70°C), 22 hr	85 %	85 %	
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Shore Hardness (Shore A, 10 sec)	25	25	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 polypopylene (PP).

BFI G 35A-322 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: 200 to 900 psi
2nd Stage - Hold Pressure: 50% 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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