Bergaflex™ BFI G 75A-328

Thermoplastic Elastomer

Key Characteristics

Product Description			
BFI G 75A-328 is an easy processing TPE with excellent mechanical properties and low odor. Material is semi filled, opaque and has a medium density			
General			
Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
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	0.990 g/cm³	0.990 g/cm³	ISO 1183
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress (Break)	1490 psi	10.3 MPa	ISO 37
Tensile Elongation (Break)	710 %	710 %	ISO 37
Compression Set			ISO 815
73°F (23°C), 72 hr	18 %	18 %	
158°F (70°C), 22 hr	38 %	38 %	
212°F (100°C), 22 hr	81 %	81 %	
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Shore Hardness (Shore A, 10 sec)	75	75	ISO 48-4
Additional Information	**Typical Value (English)**	**Typical Value (SI)**	
Generic Material Type	Styrenic Thermoplastic Elastomer (TES)	Styrenic Thermoplastic Elastomer (TES)	

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 122 °F	30 to 50 °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 75A-328 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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