Bergaflex™ BFI 60A-3104

Thermoplastic Elastomer

Key Characteristics

Product Description			
Bergaflex BFI 60A-3104 is an easy processing, general purpose TPE. The material is semi filled and has therefore a medium density.			
General			
Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Europe • North America	
Features	• General Purpose	• Good Processability	• Good Processing Stability
Uses	• Consumer Applications	• General Purpose	
RoHS Compliance	• RoHS Compliant		
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density (73°F (23°C), Black)	0.990 g/cm³	0.990 g/cm³	ISO 1183
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress [2]			DIN 53504
Break, 73°F (23°C), 0.0787 in (2.00 mm)	870 psi	6.00 MPa	
Tensile Elongation [2]			DIN 53504
Break, 73°F (23°C), 0.0787 in (2.00 mm)	650 %	650 %	
Compression Set			ISO 815
73°F (23°C), 72 hr	14 %	14 %	
158°F (70°C), 22 hr	55 %	55 %	
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Shore Hardness (Shore A, 10 sec)	60	60	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	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 60A-3104 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 60A-3104 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)

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