Bergaflex™ BFI K 65A-3E842

Thermoplastic Elastomer

Key Characteristics

Product Description			
Bergaflex BFI K 65A-3E842 is compatabilized to provide excellent adhesion to polyamide polymers.			
General			
Material Status	• Commercial: Active		
Regional Availability	• Europe		
Features	• General Purpose	• Good Adhesion	
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 [2]	1.24 g/cm³	1.24 g/cm³	ISO 1183
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress (Break)	885 psi	6.10 MPa	ISO 37
Tensile Elongation (Break)	240 %	240 %	ISO 37
Compression Set (158°F (70°C), 22 hr)	89 %	89 %	ISO 815
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Shore Hardness (Shore A, 10 sec)	65	65	ISO 48-4

Additional Information

Properties are measured using injection molded plaques.

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	212 °F	100 °C
Drying Time	2.0 hr	2.0 hr
Rear Temperature	356 to 374 °F	180 to 190 °C
Middle Temperature	374 to 410 °F	190 to 210 °C
Front Temperature	401 to 464 °F	205 to 240 °C
Nozzle Temperature	410 to 464 °F	210 to 240 °C
Mold Temperature	86 to 140 °F	30 to 60 °C
Injection Rate	Fast	Fast
Back Pressure [3]	290 to 1450 psi	2.00 to 10.0 MPa
Screw Speed	40 to 100 rpm	40 to 100 rpm

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).

Bergaflex™ BFI K 65A-3E842 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.

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Notes

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

[2] ±0.02

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

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