Bergaflex™ BFI KH 65A-3E1638

Thermoplastic Elastomer

Key Characteristics

Product Description
Bergaflex BFI KH 65A-3E1638 is an easy processing TPE with excellent mechanical properties, excellent compression set and heat stability. The grade is compatabilized to provide excellent adhesion to polyamide polymers.

General			
Material Status	• Commercial: Active		
Regional Availability	• Europe		
Features	• General Purpose • Good Adhesion	• Good Compression Set • Good Heat Resistance	
Uses	• Appliances • Automotive Applications	• Consumer Applications • General Purpose	• Industrial Applications
RoHS Compliance	• RoHS Compliant		
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Injection Molding		

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density	1.17 g/cm³	1.17 g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	3.0 to 20 cm³/10min	3.0 to 20 cm³/10min	ISO 1133
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress (Break)	870 psi	6.00 MPa	ISO 37
Tensile Elongation (Break)	450 %	450 %	ISO 37
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Shore Hardness (Shore A, 10 sec)	60 to 70	60 to 70	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	290 to 1450 psi	2.00 to 10.0 MPa
Screw Speed	40 to 100 rpm	40 to 100 rpm

Notes

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

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