Bergaflex™ BFI 60D-3E497 Transparent

Thermoplastic Elastomer

Key Characteristics

Product Description		
Bergaflex™ BFI 60D-3E497 Transparent is an easy processing, general purpose TPE.		
General		
Material Status	• Commercial: Active	
Regional Availability	• Europe	
Features	• General Purpose • Good Flow	• Good Processability • Good Processing Stability
RoHS Compliance	• RoHS Compliant	
Appearance	• Clear/Transparent	
Forms	• Pellets	
Processing Method	• Injection Molding	

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	0.890	0.890	ISO 1183
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Strength [2, 3] (Break, 73°F (23°C))	5080 psi	35.0 MPa	DIN 53504
Tensile Elongation [2, 3] (Break, 73°F (23°C))	490 %	490 %	DIN 53504
Compression Set (73°F (23°C), 72 hr)	25 %	25 %	ISO 815
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Shore Hardness (Shore D, 10 sec)	60	60	ISO 48-4

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Rear Temperature	320 to 338 °F	160 to 170 °C
Middle Temperature	338 to 374 °F	170 to 190 °C
Front Temperature	365 to 428 °F	185 to 220 °C
Nozzle Temperature	374 to 428 °F	190 to 220 °C
Mold Temperature	86 to 122 °F	30 to 50 °C
Back Pressure [4]	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).

Bergaflex™ BFI 60D-3E497 Transparent 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: 350 to 900 psi
2nd Stage - Hold Pressure: 30% 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] 7.9 in/min (200 mm/min)

[3] Specimen type S2

[4] If you use color masterbatches, higher back pressure are necessary.

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