

May 2012

820

Product Advantages: Low Die Drool. Great Value.

Nominal Physical Properties	Test Method	Unit	820
Density	ISO 1183	g/cm ³	0.88
Melt Flow (230°C/2.16Kg)	ISO 1133	g/10min	0.5
Durometer Hardness	ISO 868	Shore A	
Instantaneous			80
10 second delay			73
Tensile Modulus (M100 / 100% Modulus)	ISO 37 (500mm/min, Die C)	MPa	3.8
Tensile Strength	ISO 37 (500mm/min, Die C)	MPa	12.0
Tensile Elongation	ISO 37 (500 mm/min, Die C)	%	860
Compression Set (22 hrs at 23 °C)	ASTM D395	%	43
Compression Set (22 hrs at 70 °C)	ASTM D395	%	92
Flexural Modulus	ISO 178	MPa	24

Typical Applications:

- Films / Skins / Foils
- Air Ducts
- Drain Hose

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Extrusion Equipment Recommendations

Extruder Type	Twin Screw or Single Screw with Mixing Zone
Single Screw Type	Full Flight General Purpose with L/D Ratio > 20:1 & 3:1 Compression Ratio

Processing Guidelines

Feed Zone	90 °F – 210 °F
Kneading Zone	360 °F – 395 °F
Die	395 °F – 430 °F

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