

SARLINK® 4000 series are engineered materials designed primarily for demanding automotive applications. Available in both black and natural, SARLINK® 4155B exhibits excellent compression set and flex fatigue, high and low temperature performance. The material can be processed by injection moulding, blow moulding and extrusion for applications such as seals, gaskets, chemical resistant hose and tube, boots and bellows.

Typical Properties *	Test Method	Typical Value	Units S.I.
Specific gravity	ISO 1183	0.96	g/cm ³
Hardness shore (5 sec) Extruded sample Injection moulded sample	ISO 868	53 57	
Stress/strain properties <u>Flow direction</u> Modulus 100% Tensile strength Elongation at break <u>Cross direction</u> Modulus 100% Tensile strength Elongation at break	ISO 37 (II)	2.7 3.8 280 1.9 5.1 520	MPa MPa % MPa MPa %
Tear strength (Cross direction) trouser Unnicked	ISO 34 A ISO 34 B (a)	7 22	kN/m kN/m
Compression set 72h/23°C 22h/70°C 22h/100°C	ISO 815	22 29 34	% % %
Hot air aging 1000h/125°C Change in hardness Retention tensile strength Retention elongation at break 336h/150°C Change in hardness Retention tensile strength Retention elongation at break	ISO 188	2 90 96 0 90 87	pts % % pts % %
Volume swell 72h/100°C water 168h/100°C ASTM oil 1 168h/100°C ref. fuel B	ISO 1817	+3 +43 +91	% % %

* Tests are conducted on injection moulded plaques unless indicated otherwise.

** With the exception of contact with foods of type V, low moisture fat and oils, as identified in table 1 of 176.170 (c). This material does not comply with any European food contact regulations.

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SARLINK® 4155 is a polypropylene based elastomer which can be processed on conventional thermoplastic equipment for injection moulding, extrusion and blow moulding. This product has a wide processing window in most applications. Melt temperatures from 185°C to 220°C can be used. do not exceed 230°C. Drying is recommended for extrusion and blow moulding (2 hours at 80°C).

INJECTION MOULDING CONDITIONS			EXTRUSION CONDITIONS		
Melt temperature		185-220°C	Melt temperature		195-215°C
Barrel Temperatures	Rear	180-215°C	Barrel Temperatures	Rear	180-200°C
	Middle	180-215°C		Transition	180-205°C
	Front	180-215°C		Metered	187-210°C
	Nozzle	187-220°C		Front	187-210°C
				Die	195-215°C
Mold Temperature		10-55°C			
Screw Speed		100-200 RPM	Roll Temperatures		20-50°C
Back Pressure		0.1-1 MPa	Screen Pack		20 to 60 mesh
Screw	General Purpose 20:1 L/D ratio		Screw	General Purpose 3:1 compression ratio	

PURGING

SARLINK® 4155 has excellent melt stability. Empty the barrel for idle periods of 30 minutes or longer. Purge thoroughly before and after use of this product with polyethylene or polypropylene.

RECYCLING/REGRIND

This product can be reprocessed. Physical properties are generally not degraded. Dry regrind prior to reprocessing.

COLOURING

The use of polyolefin based colour concentrates is recommended. Apply back pressure in injection moulding to disperse colour.

BONDING/ASSEMBLY

Thermal bonding techniques can be used to form high strength bonds. Adhesive bonding can be achieved with specialized adhesives. Adhesive bond strength is limited due to the polypropylene base of this material.

STORAGE & HANDLING

SARLINK® 4155 is available in 20 kg polyethylene bags (up to 1000 kg per pallet). It has a storage life at normal temperatures of several years. Please refer to the Material Safety Data Sheet for this grade prior to first time handling.

DSM Thermoplastic Elastomers Inc. is an ISO 9001 registered company

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