SARLINK® 4339D is a highly engineered thermoplastic elastomer for use in demanding applications. SARLINK® 4339D is a flame retardant, high hardness grade processing exceptional chemical resistance, compression set and high temperature performance. This product can be processed by injection molding or extrusion. Applications include wire and cable insulation, electrical connectors, seals gaskets and boots. This product is designed as an alternate to thermoset elastomers like EPDM and chlorosulfonated polyethylene.

Typical properties*	**Test method**	**S.I.**		**English**	
		Typical value	**Units**	**Typical value**	**Units**
Hardness Shore D (5 sec)	ASTM D-2240	40	--	40	--
Specific Gravity	ASTM D-792	1.26	--	1.26	--
Modulus @ 100% Elongation	ASTM D-412	7.4	MPa	1070	Psi
Tear Strength	ASTM D-624	53.7	kN/m	305	Pli
Ultimate Elongation	ASTM D-412	510	%	510	%
Oil Resistance – Volume Change (IRM 903 Oil – 24 hrs @ 125°C)	ASTM D-471	+50	%	+50	%
Tensile Strength	ASTM D-412	13.6	MPa	1980	Psi
Brittle Point	D-2137	-43	°C	.-45	°F
Compression Set	D-395	57	%	57	%
Electrical Properties					
UL Flammability (UL94 V-0)	UL 94	1.2	mm	.047	inches
Oxygen Index	D-2863	30	%	30	%
Dielectric Constant (1MHz)	D-150	2.3	--	2.3	--
Dissipation Factor (1MHz)	D-150	0.003	--	0.003	--
Dielectric Strength (1" electrode in air)	D-149	25.20	Kv/mm	640	volts/mil

* Tests are conducted on injection molded plaques.
Test temperature 25°C (77°F) except where indicated otherwise.

Rev:8/00

SARLINK® 4339D is a polypropylene based elastomer, which can be processed on conventional thermoplastic equipment for injection molding, extrusion and blow molding. This product has a wide processing window in most applications. Melt temperatures from 360°F to 420°F can be used. Do not exceed 430°F. Drying is recommended for extrusion and blow molding and any time the material is used from an unsealed package. Dry three (3) hours at 180°F. Drying is best accomplished in a desiccant dryer.

INJECTION MOULDING CONDITIONS		
Melt temperature		360-420°F
Barrel Temperatures	Rear Middle Front Nozzle	350-400°F 350-400°F 350-410°F 390-420°F
Mould temperature		50-150°F
Screw Speed		100-200 RPM
Back Pressure		10-150 psi
Screw	General Purpose 20:1 L/D ratio	

EXTRUSION CONDITIONS		
Melt temperature		380-410°F
Barrel Temperatures	Rear Transition Metering Front Die	360-400°F 360-400°F 370-400°F 370-400°F 380-410°F
Roll Temperature		70-120°F
Screen Pack		20 to 60 mesh
Screw	General Purpose 3:1 compression ratio	

PURGING
SARLINK® 4339D has good melt stability. Empty the barrel for idle periods of thirty (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. Drying is best accomplished in a desiccant dryer.

COLORING
The use of polyolefin based color concentrates is recommended. Apply back pressure in injection molding to disperse color.

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

STORAGE & HANDLING
SARLINK® 4339D is available in 55 lb. foil lined bags (up to 2,200 lbs. per pallet) or 1,100 lb. polyethylene lined gaylords. 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.