

SARLINK® X3250 is a soft thermoplastic elastomer which complies with FDA regulation 21 CFR 177.2600, rubber articles intended for repeated use \*\*. SARLINK® X3250 can be processed by injection molding or extrusion for food packaging and house ware applications such as seals, dispensing valves, gaskets and profiles.

Typical properties *	Test method	Typical value	Units S.I.
<b>Density</b>	ISO 1183	950	Kg/m <sup>3</sup>
<b>Hardness shore A (5 sec)</b>	ISO 868	55	
<b>Stress/strain properties</b> <u>Cross direction</u> Modulus 20% Modulus 100% Tensile strength Elongation at break	ISO 37 (II)	0,8 3,0 4.0 450	MPa MPa Pa
<b>Compression set</b> 22h/70°C	ISO 815	35	%

\* Tests are conducted on injection-molded 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.

SARLINK® X3250 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 180°C to 215°C can be used. Do not exceed 260°C. Drying is recommended for extrusion and blow molding. Any time the material is used from an unsealed package, dry 3 hours at 80°C. Drying is best accomplished in a desiccant dryer.

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

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#### PURGING

SARLINK® X3250 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. Drying is best accomplished in a desiccant dryer.

#### COLOURING

The use of polyolefin based color concentrates is recommended. Apply backpressure 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. Adhesive bond strength is limited due to the polypropylene base of this material.

#### STORAGE & HANDLING

SARLINK® X3250 is available in 20 kg polyethylene bags (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.