

SARLINK® 4000 series are engineered materials designed primarily for demanding automotive applications. SARLINK® X4765-42 BLK exhibits excellent compression set and weatherability. The material is developed especially for injection-molded applications featuring high flow and UV-stability. Applications include window encapsulation, spoiler extensions and other intricate and high flow demanding applications.

Typical properties*	Test method	Typical value	Units S.I.
Density	ISO 1183	905	Kg/m ³
Hardness shore A (5 sec)	ISO 868	65	
Stress/strain properties <u>Cross direction</u> Modulus 100% Tensile strength Elongation at break	ISO 37 (II)	2.2 4.8 500	MPa MPa %
Compression set 72h/23°C 22h/70°C	ISO 815	29 30	% %
Hot air aging <u>28 days/125°C</u> Change in hardness Retention tensile strength Retention elongation at break <u>14 days/150°C</u> Change in hardness Retention tensile strength Retention elongation at break	ISO 188	-2 92 98 +2 95 98	pts % % pts % %
Spiral flow ratio X4765-42 BLK/regular 4165	DSM method	3.0	

* Tests are conducted on injection-molded plaques unless indicated otherwise.

SARLINK® X4765-42 BLK is a polypropylene based elastomer which can be processed on conventional thermoplastic equipment for injection molding. This product has a wide processing window in most applications. Melt temperatures from 185°C to 210°C can be used. Do not exceed 260°C.

INJECTION MOULDING CONDITIONS		
Melt temperature		185-210°C
Barrel Temperatures	Rear Middle Front Nozzle	180-205°C 180-205°C 180-205°C 185-210°C
Mould temperature		10-55°C
Screw speed		100-200 rpm
Back pressure		0.1-1 MPa
Screw		General purpose

PURGING

SARLINK® X4765-42 BLK 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 (3 hours/80°C). Drying is best accomplished in a desiccant dryer.

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® X4765-42 BLK is available in 20 kg polyethylene bags (1000 kg per pallet) and in black color only. 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.