Preliminary Product Data Sheet
Sarlink® X6180 NAT

SARLINK® X6180 NAT is an engineered material designed primarily for demanding consumer, Building & Construction, and automotive interior applications. Available only in natural, SARLINK® X6180 NAT exhibits excellent compression set and flex fatigue, high and low temperature performance. The material can be processed by injection molding and extrusion for applications such as building profiles, interior car applications, colored applications, translucent products and tube, boots and bellows.

Typical properties*	Test method	Typical value	Units S.I.
Density	ASTM D792	930	Kg/m^3
Hardness shore A	ASTM D2240	81	
Stress/strain properties Cross direction Modulus 100% Tensile strength Elongation at break	ASTM D412-C	 3.5 6,9 550	 MPa MPa %
Compression set 22h/70°C 22h/100°C	ASTM D395	 47 55	 % %

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

SARLINK® X6180 NAT 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 185°C to 220°C can be used. Do not exceed 260°C.

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	

PURGING
SARLINK® X6180 NAT 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® X6180 NAT 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.