

A NSF* certified, low hardness and multi-purpose thermoplastic elastomer featuring excellent fluid resistance and high temperature performance. It can be processed by injection molding, blow molding or extrusion for applications in contact with potable water, such as pipes, fittings and appurtenances.

Typical Properties**	Test Method	S.I.		U.S.	
		Typical Value	Units	Typical Value	Units
Hardness shore A (5 sec) Injection moulded sample Extruded sample	ASTM D-2240 5 sec. delay 5 sec. delay	84 80		84 80	
Specific gravity	ASTM D-792	0.95		0.95	
Stress/strain properties <u>Flow direction</u> Tensile strength Modulus 100% Elongation at break <u>Cross direction</u> Tensile strength Modulus 100% Elongation at break	ASTM D-412 Die C	7.1 5.1 430 9.3 4.5 676	MPa MPa % MPa MPa %	1030 740 430 1349 653 676	Psi Psi % Psi Psi %
Tear strength <u>Cross direction</u> Unnicked	ASTM D-624 Die C	51	kN/m	291	Pli
Compression set 22h/23°C 22h/70°C 22h/100°C	ASTM D-395 Method B	32 46 52	% % %	32 46 52	% % %

* Complies with NSF standards 61: Piping related system components for drinking water with surface area to volume ratio of 100 square inches per liter at hot temperature.

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



Certified to
ANSI/NSF 61

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Sarlink® 3480 is a polypropylene based elastomer, which can be processed on conventional thermoplastic equipment for injection molding and extrusion. This product has a wide processing window in most applications. Melt temperatures from 360°-430°F can be used. Do not exceed 450°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.

INJECTION MOULDING CONDITIONS			EXTRUSION CONDITIONS		
Melt temperature		360-430°F	Melt temperature		380-420°F
Barrel Temperatures	Rear	350-420°F	Barrel Temperatures	Rear	360-400°F
	Middle	350-420°F		Transition	360-400°F
	Front	350-420°F		Metered	370-410°F
	Nozzle	370-430°F		Front	370-410°F
			Die	380-420°F	
Mold Temperature		50-150°F			
Screw Speed		100-200 RPM	Roll Temperatures		70-120°F
Back Pressure		10-150 psi	Screen Pack		20 to 60 mesh
Screw	General Purpose 20:1 L/D ratio		Screw	General Purpose 3:1 compression ratio	

PURGING

Sarlink® 3480 has excellent 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.

COLORING

The use of polyolefin based color concentrates is recommended. Apply back pressure in injection molding prior 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® 3480 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.

DSM Thermoplastic Elastomers Inc. is an ISO 9001 registered company
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