

A highly engineered Thermoplastic Elastomer for use in demanding applications. Sarlink® 9775B4 is a UV stable medium hardness grade possessing exceptional tensile strength, superior compression set, chemical resistance and high temperature performance. It can be easily processed by extrusion, injection molding or blow molding for various applications such as glass run channels, waistbelts, weatherstrips, seals and other profiles and articles.

Typical Properties *	Test Method	S.I.		U.S.	
		Typical Value	Units	Typical Value	Units
<b>Hardness shore A</b> (5 sec) Injection moulded sample Extruded sample	ASTM D-2240 5 sec. delay	75		75	
	5 sec. delay	72		72	
<b>Specific gravity</b>	ASTM D-792	0.97		0.97	
<b>Stress/strain properties</b> <u>Cross direction</u>	ASTM D-412 Die C				
Tensile strength		7.8	MPa	1131	Psi
Modulus 100%		3.2	MPa	464	Psi
Elongation at break		679	%	579	%
<b>Tear strength</b> <u>Cross direction</u>	ASTM D-624 Die C				
Unnicked		40	kN/m	228	Pli
<b>Compression set</b> 22h/23°C 22h/70°C	ASTM D-395 Method B	23 30	% %	23 30	% %
<b>Hot air aging</b> 168h/150°C, Cross Direction	ASTM D-573				
Change in hardness		2	-	2	-
Retention tensile strength		87	%	87	%
Retention Modulus at 100%		103	%	103	%
Retention elongation at break		84	%	84	%
<b>Rheology</b> <u>Apparent Shear Viscosity</u> @ 206 1/s, 200°C	ASTM D-3835				
		338	Pa.s	338	Pa.s

\* Tests are conducted on injection moulded plaques unless indicated otherwise.

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Sarlink® 9775B4 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°-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® 9775B4 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® 9775B4 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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DSM Thermoplastic Elastomers B.V.  
P.O. Box 43  
NL-6130 AA Sittard  
The Netherlands  
Tel. +31 (0)46 4763037  
Fax. +31 (0)46 4760040  
Telex 36777

DSM Thermoplastic Elastomers Inc.  
31 Fuller Street  
Leominster, MA 01453  
USA  
Tel. (978) 534 1010  
Fax. (978) 534 1005  
Customer Service 1-800-524-0120

