



# Bergaflex™ BFI 75A-320

## Thermoplastic Elastomer

### Key Characteristics

#### Product Description

Bergaflex™ BFI 75A-320 is an easy processing, general purpose thermoplastic elastomer based on styrenic block copolymers. Material is filled, opaque and has a high density.

#### General

Material Status	• Commercial: Active		
Regional Availability	• Asia Pacific	• Europe	• North America
Features	• General Purpose	• Good Flow	• Good Processability
Uses	• Appliances • Automotive Applications	• Consumer Applications • General Purpose	• Industrial Applications
RoHS Compliance	• RoHS Compliant		
Forms	• Pellets		
Processing Method	• Injection Molding		

### Technical Properties <sup>1</sup>

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.18	1.18	ISO 1183
Elastomers	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Stress <sup>2</sup>			ISO 37
Break, 73°F (23°C), 0.0787 in (2.00 mm)	1170 psi	8.10 MPa	
Tensile Elongation <sup>2</sup>			ISO 37
Break, 73°F (23°C), 0.0787 in (2.00 mm)	620 %	620 %	
Compression Set			ISO 815
73°F (23°C), 72 hr	25 %	25 %	
158°F (70°C), 22 hr	42 %	42 %	
Hardness	Typical Value (English)	Typical Value (SI)	Test Method
Durometer Hardness <sup>3</sup>			ISO 7619
Shore A, 10 sec, 73°F (23°C), Injection Molded	75	75	

### Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Suggested Max Regrind	20 %	20 %
Rear Temperature	329 to 347 °F	165 to 175 °C
Middle Temperature	347 to 383 °F	175 to 195 °C
Front Temperature	365 to 437 °F	185 to 225 °C
Nozzle Temperature	383 to 437 °F	195 to 225 °C
Mold Temperature	68 to 104 °F	20 to 40 °C
Back Pressure	290 to 1450 psi	2.00 to 10.0 MPa
Screw Speed	40 to 100 rpm	40 to 100 rpm

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**Injection Notes**

Purge thoroughly before and after use of this product with a low flow (0.5 - 2.5 MFR) polyethylene (PE) or polypropylene (PP).

Bergaflex™ BFI 75A-320 has excellent melt stability. Maximum residence times may vary, depending on the size of the barrel. Generally, the barrel should be emptied if it is idle for periods of 8 - 10 minutes or longer.

Drying is not Required

Injection Speed: 1 to 3 in/sec  
 1st Stage - Boost Pressure: 350 to 900 psi  
 2nd Stage - Hold Pressure: 30% of Boost  
 Hold Time (Thick Part): 3 to 10 sec  
 Hold Time (Thin Part): 1 to 3 sec

**Notes**

<sup>1</sup> Typical values are not to be construed as specifications.

<sup>2</sup> 7.9 in/min (200 mm/min)

<sup>3</sup> ±5 Sh A

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