



## Bergaflex™ BFI 50D-369

### Thermoplastic Elastomer

#### Key Characteristics

| Product Description                                                |                                           |                                                      |                           |
|--------------------------------------------------------------------|-------------------------------------------|------------------------------------------------------|---------------------------|
| Bergaflex™ BFI 50D-369 is an easy processing, general purpose TPE. |                                           |                                                      |                           |
| General                                                            |                                           |                                                      |                           |
| Material Status                                                    | • Commercial: Active                      |                                                      |                           |
| Regional Availability                                              | • Europe                                  |                                                      |                           |
| Features                                                           | • General Purpose<br>• Good Flow          | • Good Processability<br>• Good Processing Stability |                           |
| Uses                                                               | • Appliances<br>• Automotive Applications | • Consumer Applications<br>• General Purpose         | • Industrial Applications |
| RoHS Compliance                                                    | • RoHS Compliant                          |                                                      |                           |
| Appearance                                                         | • Black                                   | • Natural Color                                      |                           |
| Forms                                                              | • Pellets                                 |                                                      |                           |
| Processing Method                                                  | • Injection Molding                       |                                                      |                           |

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

| Physical                                                | Typical Value (English) | Typical Value (SI) | Test Method |
|---------------------------------------------------------|-------------------------|--------------------|-------------|
| Density / Specific Gravity                              | 1.19                    | 1.19               | ISO 1183    |
| Elastomers                                              | Typical Value (English) | Typical Value (SI) | Test Method |
| Tensile Strength <sup>2, 3</sup> (Break, 73°F (23°C))   | 2470 psi                | 17.0 MPa           | DIN 53504   |
| Tensile Elongation <sup>2, 3</sup> (Break, 73°F (23°C)) | 600 %                   | 600 %              | DIN 53504   |
| Compression Set (73°F (23°C), 72 hr)                    | 25 %                    | 25 %               | ISO 815     |
| Hardness                                                | Typical Value (English) | Typical Value (SI) | Test Method |
| Durometer Hardness (Shore D, 10 sec)                    | 50                      | 50                 | ISO 7619    |

#### Processing Information

| Injection          | Typical Value (English) | Typical Value (SI) |
|--------------------|-------------------------|--------------------|
| Rear Temperature   | 320 to 338 °F           | 160 to 170 °C      |
| Middle Temperature | 338 to 374 °F           | 170 to 190 °C      |
| Front Temperature  | 365 to 428 °F           | 185 to 220 °C      |
| Nozzle Temperature | 374 to 428 °F           | 190 to 220 °C      |
| Mold Temperature   | 86 to 122 °F            | 30 to 50 °C        |
| Back Pressure      | 290 to 1450 psi         | 2.00 to 10.0 MPa   |
| Screw Speed        | 40 to 100 rpm           | 40 to 100 rpm      |

**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 50D-369 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> Specimen type S2



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