# Bergaflex™ BFI 65A-3105

## Thermoplastic Elastomer

## Key Characteristics

| Product Description | | | |
|---|---|---|---|
| Bergaflex™ BFI 65A-3105 is an easy processing, general purpose thermoplastic elastomer based on styrenic block copolymers.<br>Material is semi filled and is therefore opaque and has a medium density. | | | |
| **General** | | | |
| Material Status | • Commercial: Active | | |
| Regional Availability | • Asia Pacific | • Europe | • North America |
| Features | • General Purpose | • Good Flow | • Good Processability |
| Uses | • Appliances<br>• Automotive Applications | • Consumer Applications<br>• General Purpose | • Industrial Applications |
| RoHS Compliance | • RoHS Compliant | | |
| Appearance | • Black | | |
| Forms | • Pellets | | |
| Processing Method | • Injection Molding | | |

## Technical Properties [1]

| Physical | Typical Value (English) | Typical Value (SI) | Test Method |
|---|---|---|---|
| Density / Specific Gravity | 0.990 | 0.990 | ISO 1183 |
| **Elastomers** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Tensile Stress [2] | | | ISO 37 |
| Break, 73°F (23°C), 0.0787 in (2.00 mm) | 1230 psi | 8.50 MPa | |
| Tensile Elongation [2] | | | ISO 37 |
| Break, 73°F (23°C), 0.0787 in (2.00 mm) | 780 % | 780 % | |
| Compression Set | | | ISO 815 |
| 73°F (23°C), 72 hr | 13 % | 13 % | |
| 158°F (70°C), 22 hr | 50 % | 50 % | |
| 212°F (100°C), 22 hr | 89 % | 89 % | |
| **Hardness** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Durometer Hardness [3] | | | ISO 7619 |
| Shore A, 10 sec, 73°F (23°C), Injection Molded | 65 | 65 | |

## 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 |

## 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).

Regrind levels up to 20% can be used with Bergaflex™ BFI 65A-3105 with minimal property losses, provided that the regrind is free of
contamination. To minimize losses during molding, the melt temperature should be as low as possible. The final determination of regrind
effectiveness should be determined by the customer.

Bergaflex BFI 65A-3105 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

## Notes

[1] Typical values are not to be construed as specifications.

[2] 7.9 in/min (200 mm/min)

[3] ±5 Sh A

*Beyond Polymers.*

*Better Business Solutions.* [SM]