Bergaflex™ BFI K 50A-3E625

Thermoplastic Elastomer

Key Characteristics

Product Description
Bergaflex BFI K 50A-3E625 is an easy processing TPE, compatabilized to provide excellent adhesion to polyamide polymers. Material is filled, opaque and has therefore a moderate high density.

General			
Material Status	• Commercial: Active		
Regional Availability	• Europe		
Features	• General Purpose	• Good Adhesion	
Uses	• Appliances • Automotive Applications	• Consumer Applications • General Purpose	• Industrial Applications
RoHS Compliance	• RoHS Compliant		
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density	1.18 g/cm³	1.18 g/cm³	ISO 1183
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress (Break)	580 psi	4.00 MPa	ISO 37
Tensile Elongation (Break)	400 %	400 %	ISO 37
Compression Set			ISO 815
73°F (23°C), 72 hr	28 %	28 %	
158°F (70°C), 22 hr	71 %	71 %	
212°F (100°C), 22 hr	80 %	80 %	
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Shore Hardness [2]			ISO 7619
Shore A, 10 sec, 0.236 in (6.00 mm), Injection Molded	50	50	

Additional Information
Properties are measured using injection molded plaques.

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	212 °F	100 °C
Drying Time	2.0 hr	2.0 hr
Rear Temperature	356 to 374 °F	180 to 190 °C
Middle Temperature	374 to 410 °F	190 to 210 °C
Front Temperature	401 to 464 °F	205 to 240 °C
Nozzle Temperature	410 to 464 °F	210 to 240 °C
Mold Temperature	86 to 140 °F	30 to 60 °C
Injection Rate	Fast	Fast
Back Pressure [3]	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 K 50A-3E625 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.

In general, the fill time should not be more than 1-2 seconds.

Notes

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

[2] test specimen conditioned for >1h at room temperature prior testing

[3] If color masterbatches are used, higher back pressure is necessary.

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