

Bergaflex™ BFI 20A-3E1612

Thermoplastic Elastomer

Key Characteristics

Product Description

Bergaflex™ BFI 20A-3E1612 is an easy processing, general purpose TPE.

General

Material Status	• Commercial: Active
Regional Availability	• Europe
Features	<ul style="list-style-type: none"> • General Purpose • Good Flow • Good Processability • Good Processing Stability
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	0.980 g/cm ³	0.980 g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	25 cm ³ /10min	25 cm ³ /10min	ISO 1133
Elastomers	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Stress (Break)	290 psi	2.00 MPa	ISO 37
Tensile Elongation (Break)	750 %	750 %	ISO 37
Compression Set			ISO 815
73°F (23°C), 72 hr	14 %	14 %	
158°F (70°C), 22 hr	78 %	78 %	
Hardness	Typical Value (English)	Typical Value (SI)	Test Method
Shore Hardness (Shore A, 3 sec)	20	20	ISO 868

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Rear Temperature	330 to 350 °F	166 to 177 °C
Middle Temperature	350 to 380 °F	177 to 193 °C
Front Temperature	370 to 440 °F	188 to 227 °C
Nozzle Temperature	380 to 440 °F	193 to 227 °C
Mold Temperature	60 to 100 °F	16 to 38 °C
Back Pressure	0.00 to 120 psi	0.00 to 0.827 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).

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

¹ Typical values are not to be construed as specifications.

The logo for PolyOne, featuring the word "PolyOne" in a stylized, italicized serif font with a trademark symbol (TM) to the right. A horizontal line is drawn underneath the text.

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