Bergaflex™ BFI 35A-322

Thermoplastic Elastomer

Key Characteristics

Product Description			
Bergaflex thermoplastic elastomer compounds are based on hydrogenated styrenic block copolymers. This range of compounds are formulated to deliver a great cost/performance ratio in addition to typical Bergaflex properties such as a wide hardness range, good mechanical properties, good processability, good colourability and a wide temperature operating range. BFI 35-322 is filled and is therefore opaque and has a moderate high density.			
General			
Material Status	• Commercial: Active		
Regional Availability	• Europe		
Features	• General Purpose		
Uses	• Appliances • Automotive Applications	• Consumer Applications • General Purpose	• Industrial Applications
RoHS Compliance	• RoHS Compliant		
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)	653 psi	4.50 MPa	ISO 37
Tensile Elongation (Break)	750 %	750 %	ISO 37
Compression Set			ISO 815
73°F (23°C), 72 hr	16 %	16 %	
158°F (70°C), 22 hr	47 %	47 %	
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	35	35	

Additional Information

Properties are measured using injection molded plaques.

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Rear Temperature	338 to 347 °F	170 to 175 °C
Middle Temperature	347 to 374 °F	175 to 190 °C
Front Temperature	374 to 428 °F	190 to 220 °C
Nozzle Temperature	383 to 428 °F	195 to 220 °C
Mold Temperature	86 to 140 °F	30 to 60 °C
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).

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.

[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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