



Bergaflex™ BFI 70A-302 Natural

Thermoplastic Elastomer

Key Characteristics

Product Description

Bergaflex™ BFI 70A-302 Natural is an easy processing, general purpose TPE. Material is filled, opaque and has therefore a high density.

General

Material Status	• Commercial: Active
Regional Availability	• Europe
Features	• 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 / Specific Gravity	1.17	1.17	ISO 1183
Elastomers	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength ^{2, 3} (Break, 73°F (23°C))	899 psi	6.20 MPa	DIN 53504
Tensile Elongation ^{2, 3} (Break, 73°F (23°C))	650 %	650 %	DIN 53504
Compression Set			ISO 815
73°F (23°C), 72 hr	19 %	19 %	
158°F (70°C), 22 hr	42 %	42 %	
212°F (100°C), 22 hr	80 %	80 %	
Hardness	Typical Value (English)	Typical Value (SI)	Test Method
Durometer Hardness (Shore A, 10 sec)	70	70	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 ⁴	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 70A-302 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

¹ Typical values are not to be construed as specifications.

² 7.9 in/min (200 mm/min)

³ Specimen type S2

⁴ If you use color masterbatches, higher back pressure is necessary.

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