Bergaflex™ BFI 85A-6E331

Thermoplastic Elastomer

Key Characteristics

Product Description			
Bergaflex™ BFI 85A-6E331 is an easy processing, general purpose TPE. Material is filled, opaque and has therefore a high density.			
General			
Material Status	• Commercial: Active		
Regional Availability	• Asia Pacific	• Europe	• North America
Features	• General Purpose	• Good Processability	
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 / Specific Gravity	1.17	1.17	ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/5.0 kg)	12 g/10 min	12 g/10 min	ISO 1133
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)	870 psi	6.00 MPa	
Tensile Elongation [2]			ISO 37
Break, 73°F (23°C), 0.0787 in (2.00 mm)	500 %	500 %	
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness [3]			ISO 7619
Shore A, 10 sec, 73°F (23°C), Injection Molded	85	85	

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).

Bergaflex™ BFI 85A-6E331 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] ±5 Sh A

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