



# Bergaflex™ BFI 95A-304

## Thermoplastic Elastomer

### Key Characteristics

#### Product Description

Bergaflex™ BFI 95A-304 is an easy processing, general purpose TPE.

#### General

|                       |                      |                 |                       |
|-----------------------|----------------------|-----------------|-----------------------|
| Material Status       | • Commercial: Active |                 |                       |
| Regional Availability | • Asia Pacific       | • Europe        | • North America       |
| Features              | • General Purpose    | • Good Flow     | • Good Processability |
| RoHS Compliance       | • RoHS Compliant     |                 |                       |
| Appearance            | • Black              | • Natural Color |                       |
| Forms                 | • Pellets            |                 |                       |
| Processing Method     | • Injection Molding  |                 |                       |

### Technical Properties <sup>1</sup>

| Physical                                       | Typical Value (English) | Typical Value (SI) | Test Method |
|--|-------------------------|--------------------|-------------|
| Density / Specific Gravity                     | 1.18                    | 1.18               | ISO 1183    |
| Elastomers                                     | Typical Value (English) | Typical Value (SI) | Test Method |
| Tensile Stress <sup>2</sup>                    |                         |                    | ISO 37      |
| Break, 73°F (23°C), 0.0787 in (2.00 mm)        | 1890 psi                | 13.0 MPa           |             |
| Tensile Elongation <sup>2</sup>                |                         |                    | ISO 37      |
| Break, 73°F (23°C), 0.0787 in (2.00 mm)        | 600 %                   | 600 %              |             |
| Compression Set                                |                         |                    | ISO 815     |
| 73°F (23°C), 72 hr                             | 40 %                    | 40 %               |             |
| 158°F (70°C), 22 hr                            | 63 %                    | 63 %               |             |
| Hardness                                       | Typical Value (English) | Typical Value (SI) | Test Method |
| Durometer Hardness <sup>3</sup>                |                         |                    | ISO 7619    |
| Shore A, 10 sec, 73°F (23°C), Injection Molded | 95                      | 95                 |             |

### 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 95A-304 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**

<sup>1</sup> Typical values are not to be construed as specifications.

<sup>2</sup> 7.9 in/min (200 mm/min)

<sup>3</sup> ±5 Sh A

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