

Vistalon™ 8600 EPDM rubber

0.46 density single-pass sponge weatherseal

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Model formulation	Phr ¹
Vistalon™ 8600	100
Spheron™ 5000 carbon black	65
Omya™ BSH CaCO ₃	30
Flexon™ 815 paraffinic oil	55
Stearic acid	0.5
Zinc oxide	4.0
PEG 3350	2.0
Rhenocure™ CaO-80	2.0
Sulfur	1.7
MBT (80%)	2.0
ZBEC (70%)	1.0
Rhenocure™ S/G (80%)	0.5
Rhenogran™ Geniplex-80	1.5
Celogen™ OT	1.0
Genitron™ AC4	1.0
Total (phr)	267.2

¹ Parts per hundred dry rubber.

Rheology	Test methods (based on)	Unit	Typical values*
Mooney viscosity, ML (1+4), 100°C	ASTM D1646	MU	50
Mooney scorch, 125°C	ASTM D1646		
t5		minutes	5.5
Rheometer (MDR), 180°C, 0.5 degree arc	ASTM D5289		
ML		dN/m	1.3
MH		dN/m	18.1
ts2		minutes	0.5
t90		minutes	3.8

* Values given are typical and should not be interpreted as a specification.

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Extrusion and continuous vulcanization	Test methods (based on)	Unit	Typical values*
Profile shape			omega die
Extrusion rate		m/min	3
UHF tunnel temperature		°C	200
UHF power/reflection		%/%	20/3
Hot air tunnel temperature		°C	240
Profile temperature			
Extruder outlet		°C	98
UHF outlet		°C	185
Hot air outlet		°C	167

Properties	Test methods (based on)	Unit	Typical values*
Density	ASTM D297	g/cm ³	0.46
Compression load deflection force	ExxonMobil Test Method TS 03-20		
40% deflection at 23°C		N/20 cm	86
Compression set	ASTM D395-B		
40% compression, 22 hours at 70°C		%	10

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Vistalon™ EPDM rubber enables low density single-pass sponge compounds with improved scorch. For detailed product information, please consult the individual grade datasheets available at vistalon.com.

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