

Vistalon™ 8600 EPDM rubber

0.63 density two-pass sponge weatherseal

Energy lives here™

Model formulation	Phr ¹
Vistalon™ 8600	100
Spheron™ 5000 carbon black	75
Omya™ BSH CaCO ₃	30
Flexon™ 815 paraffinic oil	70
Stearic acid	1.5
Zinc oxide	4.0
PEG 3350	1.0
Rhenocure™ ZAT (70%)	1.5
Rhenocure™ TP/G (50%)	1.5
Finalization	
Rhenogran™ CaO-80	2.0
Sulfur	1.5
MBTS (80%)	0.7
MBT (80%)	0.7
DOTG	0.3
ZBEC (70%)	2.5
Celogen™ OT	2.0
Total (phr)	294.2

¹ Parts per hundred dry rubber.

Rheology	Test methods (based on)	Unit	Typical values*
Mooney viscosity, ML (1+4), 100°C	ASTM D1646	MU	44
Mooney scorch, 125°C	ASTM D1646		
t5		minutes	3.1
Rheometer (MDR), 180°C, 0.5 degree arc	ASTM D5289		
ML		dN/m	1.2
MH		dN/m	14.9
ts2		minutes	0.3
t90		minutes	2.7

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

Vistalon™ 8600 EPDM rubber
0.63 density two-pass sponge weatherseal

Extrusion and continuous vulcanization	Test methods (based on)	Unit	Typical values*
Profile shape			omega die
Extrusion rate		m/min	3
UHF tunnel temperature		°C	250
UHF power/reflection		%/%	33/3
Hot air tunnel temperature		°C	232
Profile temperature			
Extruder outlet		°C	100
UHF outlet		°C	185-190
Hot air outlet		°C	180

Properties	Test methods (based on)	Unit	Typical values*
Density	ASTM D297	g/cm ³	0.63
Surface roughness	ExxonMobil Test Method TS 05-14		
Ra		µm	2.2
Rt		µm	19.6
Ri		µm	4.2
Compression load deflection force	ExxonMobil Test Method TS 03-20		
40% deflection at 23°C		N/20 cm	99
Compression set	ASTM D395-B		
40% compression, 7 days at 70°C		%	31

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

Vistalon™ EDPM rubber enables two-pass sponge compounds with very good extrusion characteristics. For detailed product information, please consult the individual grade datasheets available at vistalon.com.

©2016 ExxonMobil. ExxonMobil, the ExxonMobil logo, the interlocking "X" device and other product or service names used herein are trademarks of ExxonMobil, unless indicated otherwise. This document may not be distributed, displayed, copied or altered without ExxonMobil's prior written authorization. To the extent ExxonMobil authorizes distributing, displaying and/or copying of this document, the user may do so only if the document is unaltered and complete, including all of its headers, footers, disclaimers and other information. You may not copy this document to or reproduce it in whole or in part on a website. ExxonMobil does not guarantee the typical (or other) values. Any data included herein is based upon analysis of representative samples and not the actual product shipped. The information in this document relates only to the named product or materials when not in combination with any other product or materials. We based the information on data believed to be reliable on the date compiled, but we do not represent, warrant, or otherwise guarantee, expressly or impliedly, the merchantability, fitness for a particular purpose, freedom from patent infringement, suitability, accuracy, reliability, or completeness of this information or the products, materials or processes described. The user is solely responsible for all determinations regarding any use of material or product and any process in its territories of interest. We expressly disclaim liability for any loss, damage or injury directly or indirectly suffered or incurred as a result of or related to anyone using or relying on any of the information in this document. This document is not an endorsement of any non-ExxonMobil product or process, and we expressly disclaim any contrary implication. The terms "we," "our," "ExxonMobil Chemical" and "ExxonMobil" are each used for convenience, and may include any one or more of ExxonMobil Chemical Company, Exxon Mobil Corporation, or any affiliate either directly or indirectly stewarded.

Contact your ExxonMobil Chemical representative for more information:
vistalon.com

S0916-019E50 Eclipse 404201004

ExxonMobil
 Energy lives here™