

Sunprene® FA 66104-**High Quality Extrusion Elastomer****Automotive Exterior Sealing Lip**

Chrysler: MC DC 543 CPN 4567

Ford: WSK-M4D689A-6

GM: GMW 16048 Type 2 Class C (formerly GMP PVC .061)

PRODUCT BULLETIN

Sunprene® FA 66104-

Flexible PVC elastomer extrusion formulation used for profiles requiring ease of processing, excellent weathering, abrasion resistance and a Class "A" surface appearance. Nominal 5 – 10 gloss surface.

Property	Test Method	Value - English		Value - Metric (SI)	
Hardness, Shore A	ASTM D2240 15 sec. Delay	65		65	
Specific Gravity	ASTM D792	1.25		1.25	
Tensile Strength	ASTM D638 20 in/min (500 mm/min), Type IV	2292	psi	15.8	MPa
Elongation	ASTM D638 20 in/min (500 mm/min), Type IV	384	%	384	%
100% Modulus	ASTM D638 20 in/min (500 mm/min), Type IV	1100	psi	7.6	MPa
Tear Strength	ASTM D1004 2 in/min (50 mm/min) Die C	198	ppi	34.7	kN/m
Compression Set	ASTM D395 22 hrs. @ 158°F (70°C)	53	%	53	%



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Process Parameters

Barrel Temperatures

Zone - Rear	305 ℉
Zone - Center	315 ℉
Zone - Center	325 ℉
Zone - Front	330 ℉
Adaptor	335 ℉
Dies	335 ℉

Melt Temperature 335 ℉

Screen Pack 20/40/20

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