

SARLINK® X6180 NAT is an engineered material designed primarily for demanding consumer, Building & Construction, and automotive interior applications. Available only in natural, SARLINK® X6180 NAT exhibits excellent compression set and flex fatigue, high and low temperature performance. The material can be processed by injection molding and extrusion for applications such as building profiles, interior car applications, colored applications, translucent products and tube, boots and bellows.

| Typical properties * | Test method | Typical value | Units S.I. |
|---|-------------|-------------------|-------------------|
| Density | ASTM D792 | 930 | Kg/m ³ |
| Hardness shore A | ASTM D2240 | 81 | |
| Stress/strain properties <u>Cross direction</u> Modulus 100% Tensile strength Elongation at break | ASTM D412-C | 3.5 6,9 550 | MPa MPa % |
| Compression set 22h/70°C 22h/100°C | ASTM D395 | 47 55 | % % |

* Tests are conducted on injection-molded plaques unless indicated otherwise.



SARLINK® X6180 NAT is a polypropylene based elastomer, which can be processed on conventional thermoplastic equipment for injection molding, extrusion and blow molding. This product has a wide processing window in most applications. Melt temperatures from 185°C to 220°C can be used. Do not exceed 260°C.

| INJECTION MOULDING CONDITIONS | | | EXTRUSION CONDITIONS | | |
|-------------------------------|-----------------------------------|--|----------------------|--|---|
| Melt temperature | | 185-220°C | Melt temperature | | 195-215°C |
| Barrel Temperatures | Rear Middle Front Nozzle | 180-215°C 180-215°C 180-215°C 187-220°C | Barrel Temperatures | Rear Transition Metering Front Die | 180-200°C 180-205°C 187-210°C 187-210°C 195-215°C |
| Mould temperature | | 10-55°C | | | |
| Screw Speed | | 100-200 RPM | Roll Temperature | | 20-50°C |
| Back Pressure | | 0.1-1 MPa | Screen Pack | | 20 to 60 mesh |
| Screw | General Purpose | | Screw | General Purpose 3:1 compression ratio | |

PURGING

SARLINK® X6180 NAT has excellent melt stability. Empty the barrel for idle periods of 30 minutes or longer. Purge thoroughly before and after use of this product with polyethylene or polypropylene.

RECYCLING/REGRIND

This product can be reprocessed. Physical properties are generally not degraded. Dry regrind prior to reprocessing. Drying is best accomplished in a desiccant dryer.

COLOURING

The use of polyolefin based color concentrates is recommended. Apply backpressure in injection molding to disperse color.

BONDING/ASSEMBLY

Thermal bonding techniques can be used to form high strength bonds. Adhesive bonding can be achieved with specialized adhesives. Adhesive bond strength is limited due to the polypropylene base of this material.

STORAGE & HANDLING

SARLINK® X6180 NAT is available in 20 kg polyethylene bags (1000 kg per pallet). It has a storage life at normal temperatures of several years. Please refer to the Material Safety Data Sheet for this grade prior to first time handling.

