



**TSE Industries, Inc.**  
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Formula ID 700      Compound No. V7429C-I      Cure: P  
 Color: NB      Type: Polyester

Application: 80 Shore A Non-Black Millathane® 5004 Seal

Millathane® 5004	100.00	Durometer, Shore A	80	
Stearic Acid	0.25	Durometer, Shore D		
Aerosil 200	26.00	100% Modulus, psi		MPa
Silquest A-172	0.50	200% Modulus, psi		MPa
Struktol WB-222	0.50	300% Modulus, psi	3650	25.2 MPa
DiCup 40C	5.00	Tensile Strength, psi	4650	32.1 MPa
		Elongation, %	360	
		Tear Die C, lb/sq. in.	310	54.3 kN/m
		Specific Gravity, g/cc	1.337	
		CureTime, minutes	20	
		Cure Temp°F	320	160 °C
		Mooney Viscosity, ML4/100°C	127	
		Bashore Resilience, %	40	
		Brittle Point, °C		
		Compression Set 22h/70°C, %		
		Compression Set 70h/70°C, %	12	
		Compression Set 22h/100°C, %		
		Compression Set 70h/100°C, %		
		Compression Set 22h/125°C, %		
		Compression Set 22h/150°C, %		
		Compression Set - Other Conditions:		
			Hrs	°C
				%Set
		<b>Heat Aging</b> 70 Hrs at 100 °C		
		Hardness Change, pts.	1	
		Tensile Change, %	1	
		Elongation Change, %	-3	
		<b>Fluid Aging</b> Water 70 Hrs at 70 °C		
		Hardness Change, pts.	2	
		Tensile Change, %	-15	
		Elongation Change, %	14	
		Volume Change, %		

Other Tests and Info:

Compound was post-cured 35'/135C before testing. Taber Abrasion, H22 wheel, 1000 cycles = 0.002 g lost; 5000 cycles = 0.068 g lost. Struktol WB222 not in formula as tested, but it's recommended for processing.

3/23/2005

The recommendations for the use of our products are based on tests believed to be reliable. However, we do not guarantee the results to be obtained by others under different conditions. Nothing in this literature is intended as a recommendation to use our products so as to infringe on any patent. Millathane, Thanecure and Crystal are registered trademarks of TSE Industries, Inc.