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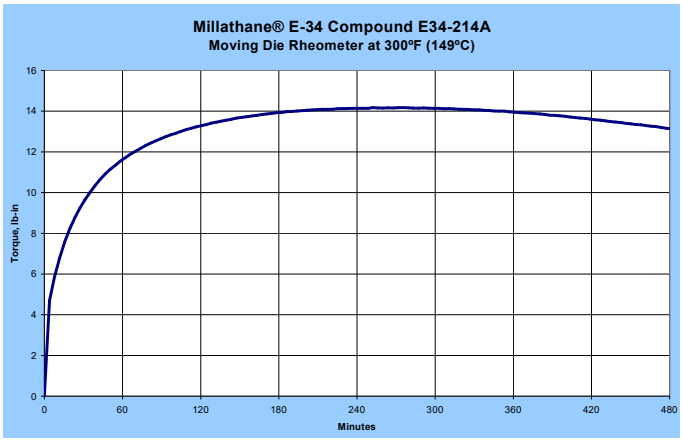
60 Shore A Millathane® E-34 Roll Compound
Cured in Hot-air Autoclave

Formulation

Millathane E-34	100.0
Stearic Acid	0.5
HiSil 233	35.0
Tricresyl Phosphate	10.0
AC 617A Polyethylene	2.0
Blue Akrosperse 630MB	0.5
Varox 130XL	2.5
Di-Cup 40C	0.5
Total	151.0

Physical Properties, Press Cure 10 min./171ºC (340ºF)	
Hardness, Shore A	60
100% Modulus, psi (MPa)	265 (1.8)
200% Modulus, psi (MPa)	510 (3.5)
Tensile Strength, psi (MPa)	2750 (19)
Elongation, %	500
Tear, Die C, lb/in (kN/m)	153 (26.8)



Roll Building Procedure

Calendered stock (1/8 in. [3 mm] thick) was wrapped around a 1 1/8 in. [29 mm] diameter solid roll to a thickness of ¾ in. [19 mm] (2 5/8 in. [67 mm] OD). Roll was previously shot-blasted and one coat of Chemlok 219 was applied. Roll was wrapped with high-shrink Mylar.

Roll Curing Procedure

Roll was cured in a hot-air autoclave with the following conditions:
Air pressure: 60 psi [0.4 MPa]
Temperature cycle: 40’ rise to 300ºF [149ºC], 2 hours at 300F.

Finished Roll Properties

The roll was ground with a taper to check hardness throughout the thickness of the rubber. The roll tested a consistent 58-59 Shore A throughout its thickness and the rubber had a good bond to the core.

Ref: XP3414 E34-214A
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