



Formula ID 1684 Compound XP-6122-E Cure: P Color: NB
Urethane Type: Polyether

Application: 60 Shore A Non-Black Millathane® 26 Molding Compound - FDA Compliant*

Millathane® 26	100.00	Durometer, Shore A	60	
Stearic Acid	0.30	Durometer, Shore D		
Hi-Sil 233**	25.00	Durometer, Asker C		
DBEEA (TP-95)	2.00	25% Modulus, psi		MPa
Struktol WB-222	1.00	50% Modulus, psi		MPa
AC617A Polyethylene	2.00	100% Modulus, psi	195	1.3 MPa
DiCup 40C	5.00	200% Modulus, psi	310	2.1 MPa
		300% Modulus, psi	500	3.4 MPa
		Tensile Strength, psi	3340	23.0 MPa
		Elongation, %	625	
		Tear Die C, lb/in.	150	26.3 kN/m
		Tear Die B, lb/in.	255	44.6 kN/m
		Tear Die T, lb/in.		kN/m
		Specific Gravity, g/cc	1.160	
		CureTime, minutes	9	
		Cure Temp°F	320	160 °C
		Mooney Viscosity, ML4/100°C	65	
Total	135.30			

Brittle Point, °C	
TR10, °C (ASTM D1329)	
Bashore Resilience, %	53
DIN Abrasion, mm³ loss	91

Compression Set 22h/70°C, %	30
Compression Set 70h/70°C, %	
Compression Set 22h/100°C, %	
Compression Set 70h/100°C, %	
Compression Set 22h/125°C, %	
Compression Set 22h/150°C, %	
Compression Set, Other conditions:	
h/ °C, %	

Heat Aging Hrs at °C

Hardness Change, pts.	
Tensile Change, %	
Elongation Change, %	

Fluid Aging Hrs at °C

Hardness Change, pts.	
Tensile Change, %	
Elongation Change, %	
Volume Change, %	
Surface Resistivity, ohm/cm²	
Volume Resistivity, ohm-cm	
UL 94 Rating:	

Other Tests and Info:

*Compound contains ingredients compliant with 21CFR177.2600 to the best of our knowledge at the time this document was prepared. **Note: compound as mixed and tested used Ultrasil VN3 which is NOT FDA-compliant; HiSil 233 should give roughly similar properties. The addition of Irganox 1076 (0.25-1.0 phr) will improve heat aging characteristics significantly and reduce 'sticky' mold flash.