TSE INDUSTRIES, INC.
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Formula ID 1686 Compound XP-6122-K Cure: P Color: NB

Urethane Type: Polyether Blend

Application: 67 Shore A Non-Black Millathane® 26 Molding Compound - FDA Compliant*

Millathane® 26	90.00
Pliolite S6B	10.00
Stearic Acid	0.24
Hi-Sil 233**	25.00
DBEEA (TP-95)	2.00
Struktol WB-222	1.00
AC617A Polyethylene	2.00
DiCup 40C	5.00
Total	135.24

Durometer, Shore A	67	
Durometer, Shore D		
Durometer, Asker C		
25% Modulus, psi		MPa
50% Modulus, psi		MPa
100% Modulus, psi	250	1.7 MPa
200% Modulus, psi	420	2.9 MPa
300% Modulus, psi	655	4.5 MPa
Tensile Strength, psi	2920	20.1 MPa
Elongation,%	635	
Tear Die C, lb/in.	182	31.9 kN/m
Tear Die B, lb/in.	307	53.7 kN/m
Tear Die T, lb/in.		kN/m
Specific Gravity, g/cc	1.160	
CureTime, minutes	8	
Cure Temp°F	320	160 °C
Mooney Viscosity, ML4/100°C	57	

Brittle Point, °C	
TR10, °C (ASTM D1329)	
Bashore Resilience, %	47
DIN Abrasion, mm³ loss	91

Compression Set 22h/70°C, %	38
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 of this document's creation. **Note: compound as mixed and tested used Ultrasil VN3 which is NOT FDA-compliant; HiSil 233 should give roughly similar properties. Pliolite S6B, a high styrene resin, needs to be fluxed into the Millathane 26, preferably in an internal mixer at temps of 200+F (92C+)

10/1/2020