

# Product Information

## Automotive and Transportation



DOW CORNING

# Multiflex<sup>®</sup> TPO 4504 SW BLK 23804 Thermoplastic Elastomer

### FEATURES & BENEFITS

- Black

### APPLICATIONS

- Multiflex<sup>®</sup> TPO 4504 SW BLK 23804 is designed for injected molded, paintable airbag covers and inflatable-restraint components

### TYPICAL PROPERTIES

Specification Writers: These values are not intended for use in preparing specifications. Please contact your local Dow Corning sales office or your Global Dow Corning Connection before writing specifications on this product.

Test*	Property	Unit	Result
ISO 868	Hardness	Sh.D	40
ISO 1183/A	Density	g/cm <sup>3</sup>	0.91
ISO 1133	MVR (2.16 kg / 230°C)	cm <sup>3</sup> /10 mn	6
MDA 179	Spiral flow condition A	cm	36
ISO 178	Flexural modulus 3 points	MPa	500
ISO 180	Notched Izod Impact at -30°C	KJ/m <sup>2</sup>	52
ISO 527-2/5A/500	Tensile strength at break	MPa	16
ISO 527-2/5A/500	Elongation at break	%	80
ISO 34	Tear strength	kN/m	100
ISO 527-2/5A/500	Tensile strength at break at -35°C	MPa	29.0
ISO 527-2/5A/500	Elongation at break at -35°C	%	32
ISO 34	Tear strength at -35°C	kN/m	182
ISO 178	Flexural modulus 3 points at 85°C	MPa	145
ISO 527-2/5A/500	Tensile strength at break at 85°C	MPa	8
ISO 527-2/5A/500	Elongation at break at 85°C	%	250
ISO 34	Tear strength at 85°C	kN/m	73
ISO 294.4	Shrinkage flow direction at 23°C	%	1

\*ISO: International Standardization Organization

MDA (Méthode d'Analyse): Issued from ISO Standards

### GUIDELINES FOR INJECTION MOLDING

**Drying:** Multiflex<sup>®</sup> TPO 4504 SW BLK 23804 is not moisture sensitive, therefore drying is not needed. However, if this material is stored in high humidity conditions, it is recommended to dry for two hours at maximum 80°C.

Barrel temperature °C	Feed	200°C +/-20°C
	Zone	210°C +/-20°C
	Zone 1	210°C +/-20°C
	Zone 2	220°C +/-20°C
	Nozzle	
Back Pressure Bars	10 +/- 5	
Injection Speed	medium	
Holding Pressure	as low as possible	
Mold Temperature °C	30–40°C (fixed part) - 15–20°C (moving part) <sup>1</sup>	

<sup>1</sup>Lower T° on moving part is better for easier injection

## HANDLING

### PRECAUTIONS

#### PRODUCT SAFETY

**INFORMATION REQUIRED FOR SAFE USE IS NOT INCLUDED IN THIS DOCUMENT. BEFORE HANDLING, READ PRODUCT AND SAFETY DATA SHEETS AND CONTAINER LABELS FOR SAFE USE, PHYSICAL AND HEALTH HAZARD INFORMATION. THE SAFETY DATA SHEET IS AVAILABLE ON THE DOW CORNING WEBSITE AT DOWCORNING.COM, OR FROM YOUR DOW CORNING SALES APPLICATION ENGINEER, OR DISTRIBUTOR, OR BY CALLING DOW CORNING CUSTOMER SERVICE.**

## USABLE LIFE AND STORAGE

Refer to product label for storage temperature conditions. Containers should be kept tightly closed and kept in cold storage at all times to extend shelf life. Shelf life is indicated by the "Use Before" date found on the product label.

## PACKAGING INFORMATION

This product is available in a variety of container sizes. Contact your local Dow Corning sales representative for information about container sizes available in your area.

## LIMITATIONS

This product is neither tested nor represented as suitable for medical or pharmaceutical uses.

## HEALTH AND ENVIRONMENTAL INFORMATION

To support customers in their product safety needs, Dow Corning has an extensive Product Stewardship organization and a team of Product Safety and Regulatory Compliance (PS&RC) specialists available in each area.

For further information, please see our website, [dowcorning.com](http://dowcorning.com) or consult your local Dow Corning representative.

## LIMITED WARRANTY INFORMATION – PLEASE READ CAREFULLY

The information contained herein is offered in good faith and is believed to be accurate. However, because conditions and methods of use of our products are beyond our control, this information should not be used in substitution for customer's tests to ensure that our products are safe, effective, and fully satisfactory for the intended end use. Suggestions of use shall not be taken as inducements to infringe any patent.

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Your exclusive remedy for breach of such warranty is limited to refund of purchase price or replacement of any product shown to be other than as warranted.

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