Product Information
Automotive and Transportation

Multiflex® TPO D4006 M1 NERO
808 Thermoplastic Elastomer

FEATURES & BENEFITS
- Color: Black

APPLICATIONS
- Multiflex® TPO D4006 M1 NERO 808 is designed for injected molded, unpainted 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.

<table>
<thead>
<tr>
<th>Test*</th>
<th>Property</th>
<th>Unit</th>
<th>Result</th>
</tr>
</thead>
<tbody>
<tr>
<td>ISO 868</td>
<td>Hardness</td>
<td>Sh.D</td>
<td>42</td>
</tr>
<tr>
<td>ISO 1183/A</td>
<td>Density</td>
<td>g/cm³</td>
<td>0.88</td>
</tr>
<tr>
<td>ISO 1133</td>
<td>MVR (2.16 kg/230°C)</td>
<td>cm³/10 mn</td>
<td>16</td>
</tr>
<tr>
<td>MDA 179</td>
<td>Spiral flow condition A</td>
<td>cm</td>
<td>45</td>
</tr>
<tr>
<td>ISO 178</td>
<td>Flexural modulus 3 points</td>
<td>MPa</td>
<td>370</td>
</tr>
<tr>
<td>ISO 180</td>
<td>Notched Izod Impact at -30°C</td>
<td>KJ/m²</td>
<td>9</td>
</tr>
<tr>
<td>ISO 527-2/5A/500</td>
<td>Tensile strength at break</td>
<td>MPa</td>
<td>16</td>
</tr>
<tr>
<td>ISO 527-2/5A/500</td>
<td>Elongation at break</td>
<td>%</td>
<td>200</td>
</tr>
<tr>
<td>ISO 34</td>
<td>Tear strength at -35°C</td>
<td>kN/m</td>
<td>100</td>
</tr>
<tr>
<td>ISO 527-2/5A/500</td>
<td>Tensile strength at -35°C</td>
<td>MPa</td>
<td>27</td>
</tr>
<tr>
<td>ISO 527-2/5A/500</td>
<td>Elongation at break at -35°C</td>
<td>%</td>
<td>35</td>
</tr>
<tr>
<td>ISO 34</td>
<td>Tear strength at -35°C</td>
<td>kN/m</td>
<td>179</td>
</tr>
<tr>
<td>ISO 178</td>
<td>Flexural modulus 3 points at 85°C</td>
<td>MPa</td>
<td>113</td>
</tr>
<tr>
<td>ISO 527-2/5A/500</td>
<td>Tensile strength at 85°C</td>
<td>MPa</td>
<td>7</td>
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<tr>
<td>ISO 527-2/5A/500</td>
<td>Elongation at break at 85°C</td>
<td>%</td>
<td>510</td>
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<tr>
<td>ISO 34</td>
<td>Tear strength at 85°C</td>
<td>kN/m</td>
<td>66</td>
</tr>
<tr>
<td>ISO 294.4</td>
<td>Shrinkage flow direction at 23°C</td>
<td>%</td>
<td>1.2</td>
</tr>
</tbody>
</table>

*ISO: International Standardization Organization
MDA (Méthode d’Analyse): Issued from ISO Standards

GUIDELINES FOR INJECTION MOLDING

Drying: Multiflex® TPO D4006 M1 NERO 808 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.

<table>
<thead>
<tr>
<th>Barrel temperature °C</th>
<th>Feed Zone</th>
<th>Zone 1</th>
<th>Zone 2</th>
<th>Nozzle</th>
</tr>
</thead>
<tbody>
<tr>
<td>220°C +/- 20°C</td>
<td>230°C +/- 20°C</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>230°C +/- 20°C</td>
<td>230°C +/- 20°C</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>240°C +/- 20°C</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Back Pressure Bars: 10 +/- 5
Injection Speed: medium
Holding Pressure: as low as possible
Mold Temperature °C: 150°C (fixed part) - 30°C (moving part)

1Lower 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 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.

Dow Corning’s sole warranty is that
our products will meet the sales
specifications in effect at the time of
shipment.

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.

TO THE FULLEST EXTENT
PERMITTED BY APPLICABLE
LAW, DOW CORNING
SPECIFICALLY DISCLAIMS
ANY OTHER EXPRESS OR
IMPLIED WARRANTY OF
FITNESS FOR A PARTICULAR
PURPOSE OR
MERCHANTABILITY.

DOW CORNING DISCLAIMS
LIABILITY FOR ANY
INCIDENTAL OR
CONSEQUENTIAL DAMAGES.

We help you invent the future.

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