



A Product of DuPont Dow Elastomers

Nordel® IP 3670

Description: Slightly crystalline, ethylene-propylene-diene (EPDM) terpolymer designed for calendering; offers excellent processing characteristics. Low unsaturation level provides stability during long-term exposures to heat and ultraviolet (UV) light and allows the polymer to be either sulfur or peroxide cured.

Form: Bales

Requirements at Time of Manufacture

Property	Specification Limits	Test Method
Mooney Viscosity (ML 1 + 4 at 125°C [257°F])	65–75	ASTM D-1646
Total Volatiles, mass %	<0.4	DuPont Dow Method PQ-E-007
Ethylene, mass %	56.7–59.7	ASTM D-3900
ENB, mass %	1.4–2.2	ASTM D-6047
Yellowness Index	<7	ASTM E-313
Contamination, specks/300 g	<20	DuPont Dow Method PQ-E-030

Cure Characteristics

MDR at 160°C [320°F], 1.7 Hz, 0.5° arc, 30 min motor		ASTM D-5289
Minimum Torque, M _L [dN·m]	TBE*	
Maximum Torque, M _H [dN·m]	TBE	
t _{s1} , min	TBE	
t'90, min	TBE	
ASTM D-3568 mixed recipe as below:		
Nordel IP NDR 3670	100 phr	
Zinc Oxide	5	
Stearic Acid	1	
IRB #7 Black	80	
ASTM Type 103 Oil	50	
MBT	0.5	
TMTD	1	
Sulfur	1.5	

*To be established based upon statistically meaningful production data

Other Typical Property Characteristics**

Property	Typical Value	Test Method
Specific Gravity	0.86	ASTM D-297
Total Ash, mass %	< 0.1	ASTM D-5667
Transition Metals, ppm	<10	DuPont Dow Method

**These are typical values only, not to be used as sales specifications.