



MOBIUS

M108S MATERIAL SPECIFICATIONS

TABLE OF

CONTENTS

4-5

4140

ALLOY STEEL

1045

CARBON STEEL

6-7

316

STAINLESS STEEL CABLE

UHB SS716

STAINLESS STEEL

8-9

304

STAINLESS STEEL

3003-H14

ALUMINUM

10-11

5052

ALUMINUM (H32)

6063

ALUMINUM (T6)

12-13

Lexan™ MR10

POLYCARBONATE

TX1501HF

TRITAN™ COPOLYESTER

14-15

BASF Ultemid 8202C

POLYAMIDE 6

Dupont Tynex A 612

NYLON

16-17

Closed Cell EPDM

SPONGE RUBBER

HDPE 2 (High-Density

POLYTHYLENE

18

EA E-30

ADHESIVE

ALLOY STEEL 4140

USED IN:

Helical Blade.

DESCRIPTION:

Oil-hardening chromium-molybdenum steel has good strength and wear resistance, excellent toughness and ductility with the ability to resist stress and creep at prolonged high temperatures (up to 1,000°F).

TYPICAL APPLICATIONS:

Drill collars, high temperature bolts, sprockets, kelly bars, reamer bodies, rotary table shafting, oil well tool joints, spindles, stay bolts, tractor axles, tractor arms, axle shafts, valves, bolts, subs, couplings, trailer axles, winch shafts, piston rods, rams, hydraulic machinery shafts, precision lead screws, chain links, zinc die-casting dies.

TREATMENT(S):

The Mobius part this material is used in is liquid nitrided and black oxidized.

CHEMICAL COMPOSITION (% NOMINAL)

C	0.38 / 0.43 Max.
Mn	0.75 / 1.00
P	0.035 Max.
S	0.04 Max.
Si	0.15 / 0.35
Cr	0.80 / 1.10
Mo	0.15 / 0.25

* Chemical Analysis will vary on each heat number.

MECHANICAL PROPERTIES

Tensile Strength	70,000 PSI
Yield Point	60,000 PSI
Elongation***	20
Brinell Hardness	200

** Ranges shown are for 4140 Annealed. All values are minimum values and are representative.

*** % in 2"

CARBON STEEL 1045 CR

USED IN:

Helical Blade.

Carbon steel 1045 is designed to be able to function in areas requiring greater strength and hardness. This steel possesses excellent size accuracy, concentricity, and straightness which together enable to minimize wear in high speed applications.

TYPICAL APPLICATIONS:

Typical uses include gears, shafts, axles, bolts, studs, and black oxidized.

TREATMENT(S):

Typical uses include gears, shafts, axles, bolts, studs, and black oxidized.

CHEMICAL COMPOSITION (% NOMINAL)		MECHANICAL PROPERTIES	
C	0.42 / 0.50	Tensile Strength	90,600 PSI
Mn	0.60 / 0.90	Yield Point	73,900 PSI
P	0.040 Max.	Elongation***	12%
S	0.050 Max.	Brinell Hardness	179

* Chemical Analysis will vary on each heat number.

UHB SS716

STAINLESS STEEL

USED IN:

Bed Knife Cutting Edge

DESCRIPTION:

UHB SS716 is a cold rolled martensitic stainless steel grade designed for applications where toughness and impact fatigue strength are essential (even at temperatures as high as 400°C). The 13% chromium steel is delivered in the hardened and tempered condition and has proven to offer exceptional bending and impact fatigue properties and good corrosion resistance.

TYPICAL APPLICATIONS:

Surgical blades, culinary knives, assembly parts, motor parts.

CHEMICAL COMPOSITION (% NOMINAL)

C	0.38
Mn	0.55
P	0.025
S	0.015
Si	0.45
Cr	13.5
Mo	1.00

PHYSICAL PROPERTIES

Density, ρ	7.7 g/cm ³
Thermal Expansion < 100°C (210°F)	10.6 x 10 ⁻⁶ / °C
Thermal Conductivity, RT	24 W / m °C
Specific Heat Capacity, RT to 100°C (210°F)	460 J/kg °C
Resistivity, RT	0.75 Ω mm ² /m
Damping loss factor, (215 Hz, <105°C)	0.0011

MECHANICAL PROPERTIES

Ultimate Tensile Strength	1810 MPa
Proof Strength, $R_{p0.2}$	1450 MPa
Elongation, A_{50}	4-6 %
Modulus of Elasticity	210 GPa
Hardness	540 HV

MECHANICAL PROPERTIES

Tensile Fatigue Limit Ratio, 0.33 $\sigma_u R_m$, (20°C)
Bending Fatigue Limit Ratio, 0.35 $\sigma_u R_m$, (20°C)
Compressive Residual Stresses -350 ±100 MPa

STAINLESS STEEL

USED IN:

Wire Tumbler Body

DESCRIPTION:

Stainless steel Type 316 is an Austenitic alloy that was developed for added corrosion resistance, when compared to other stainless steels (e.g. Type 304). It generally has a slightly higher nickel content but is distinguished by the addition of molybdenum.

TYPICAL APPLICATIONS:

Often used in marine environments and refrigeration applications, where corrosion resistance is key. General grade for food processing, chemical storage and transport, textile dying equipment, cladding of nuclear fuel, and oil refining equipment as well as some medical implants.

CHEMICAL COMPOSITION (% NOMINAL)		OTHER PROPERTIES	
Cr	16 - 18	Type	Aircraft Cable
Ni	10 - 14	Type Description	Strand
C	0.08	Application	Commercial
Mn	2	Strand Construction	1 x 7
Si	0.75	Material	Pre-formed 316 Stainless Steel
P	0.045	Diameter	1/32 Inch
S	0.03	Minimum Break Strength	150 lbs / 68.03 kg
N	0.10	Coating	Bare
Mo	2.0 - 3.0		

STAINLESS STEEL

USED IN:

Brush Shaft, Separator Housing, Impeller Housing, Input Hopper, Output Chute.

DESCRIPTION:

Stainless steel Type 304 is a commonly used form stainless steel that demonstrates excellent corrosion resistance to most oxidizing acids and is easy to sanitize.

TYPICAL APPLICATIONS:

Kitchen and food applications.

CHEMICAL COMPOSITION (% NOMINAL)		MECHANICAL PROPERTIES	
C	0.08	Tensile Strength	85 ksi
Mn	2	Yield Strength	35 ksi
P	0.045	Elongation in 2 Inches	55%
S	0.03	Reduction of Area	70%
Si	1	Brinell Hardness	150
Cr	18 - 20		

PHYSICAL PROPERTIES	
Density Lb/In ³	0.29
Coefficient of Thermal Expansion 32 - 212°F x 10 ⁻⁶ per °F	9.6
Specific Heat 32 - 212°F BTU/°F/Lb	0.12
Thermal Conductivity at 212°F BTU/FT/FT ² /Hr/°F	9.4
Electrical Resistivity at 70°F Microhm-cm	70

3003-H14

ALUMINUM

USED IN:

Aluminum Honeycomb Screens on Lid Assembly

DESCRIPTION:

General purpose, moderate strength, good workability and weldability, high resistance to corrosion.

TYPICAL APPLICATIONS:

Grilles and guards, architectural and decorative applications, cooking utensils, panels, railings, storage tanks.

TREATMENT(S):

The Mobius parts this material is used in are anodized.

CHEMICAL COMPOSITION (% NOMINAL)

Si	0.6
Fe	0.7
Cu	0.05 - 0.20
Mn	1.0 - 1.5
Zn	0.10

MECHANICAL PROPERTIES

Tensile Strength (ksi)	Ult: 22 / Yld: 21
Elongation % 2" Specimen	1/16" thick: 8 1/2" diam: 16
Brinell Hardness 500 kg Load 10mm Ball	40
Ultimate Shearing Strength	14
Fatigue Endurance Limit (ksi)	9
Modulus of Elasticity (ksi x 10 ³)	10.0

PHYSICAL PROPERTIES

Density Lb/In ³	0.099
Avg. Coefficient of Thermal Expansion 68-212°F x 10 ⁻⁶ per °F	12.9
Melting Range Approximate °F	1190-1210
Temper	H14
Thermal Conductivity at 77 of BTU/Ft/FT ² /HR/°F	92
Electrical Conductivity at 68°F % Int'l Annealed Cu Standard	Vol: 41 / Wt: 134
Electrical Resistivity at 68°F Ohms-Cir/Mil/Ft	92

5052 (H32)

ALUMINUM

USED IN:

Aluminum Flat Plates and Sheet Metal Parts (Mobius Body Tray)

DESCRIPTION:

Excellent resistance to salt water corrosion, good weldability and workability, good finishing characteristics.

TYPICAL APPLICATIONS:

Home appliances, vehicle bodies, small boats, sheet metal parts, fan blades.

TREATMENT(S):

The Mobius parts this material is used in are anodized.

CHEMICAL COMPOSITION (% NOMINAL)

Si	0.25
Fe	0.40
Cu	0.10
Mn	0.10
Mg	2.2-2.8
Cr	0.15-0.35
Zn	0.10
Ti	-

MECHANICAL PROPERTIES

Tensile Strength (ksi)	Ultimate: 35 Yield: 28
Elongation % 2" Specimen	1/16" thick: 12 1/2" diam: 18
Brinell Hardness 500 kg Load 10mm Ball	60
Ultimate Shearing Strength	20
Fatigue Endurance Limit (ksi)	17
Modulus of Elasticity (ksi x 10 ³)	10.2

PHYSICAL PROPERTIES

Density Lb/In ³	0.097
Avg. Coefficient of Thermal Expansion 68-212°F x 10 ⁻⁶ per °F	13.2
Melting Range Approximate °F	1125-1200
Thermal Conductivity at 77 of BTU/Ft/FT ² /HR/°F	80
Electrical Conductivity at 68oF % Int'l Annealed Cu Standard	Vol: 35 / Wt: 116
Electrical Resistivity at 68°F Ohms-Cir/Mil/Ft	30

6063 (T6)

ALUMINUM

USED IN:

Aluminum Extrusion Parts (Lid Extrusions, Bed Knife Bar, and Spacer Bar)

DESCRIPTION:

Solution heat treated, then artificially aged. High corrosion resistance, medium strength, good natural finish.

TYPICAL APPLICATIONS:

Irrigation pipe, store fronts, architectural trim, pipe railing, furniture.

TREATMENT(S):

The Mobius parts this material is used in are anodized or powder coated.

CHEMICAL COMPOSITION (% NOMINAL)

Si 0.20-0.6

Fe 0.35

Cu 0.10

Mn 0.10

Mg 0.45-0.9

Cr 0.10

Zn 0.10

Ti 0.10

MECHANICAL PROPERTIES

Tensile Strength (ksi) Ultimate: 35
Yield: 28

Elongation % in 2".
1/16" Thick Specimen 12

Brinell Hardness 500 kg Load 73
10mm Ball

Ultimate Shearing Strength 22

Fatigue Endurance Limit (ksi) 10

Modulus of Elasticity (ksi x 10³) 10.0

PHYSICAL PROPERTIES

Density Lb/In³ 0.097

Avg. Coefficient of Thermal Expansion 68-212°F x 10⁻⁶ per °F 13.0

Melting Range Approximate °F 1140-1210

Thermal Conductivity at 77 of BTU/Ft/FT²/HR/°F T6

Electrical Conductivity at 68°F % Int'l Annealed Cu Standard Vol: 53 / Wt: 175

Electrical Resistivity at 68°F Ohms-Cir/Mil/Ft 20

HARDENED & COATED (LEXAN™ MR10)

POLYCARBONATE

USED IN:

Transparent Top Lid Shield and Trim Tote Window

DESCRIPTION:

LEXAN™ MR10 sheets are transparent polycarbonate sheets, coated on both sides to be both Mar and UV-resistant.

TYPICAL APPLICATIONS:

Transparent surfaces on equipment, furniture and finishes in high-traffic areas.

MECHANICAL PROPERTIES

Tensile Strength, Ultimate	9,500 psi
Flexural Strength	13,500 psi
Flexural Endurance @ 1,800 Cycles/Min, 73°F, 50% RH	1,000 psi
Compressive Strength	12,500 psi
Modulus of Elasticity	345,000 psi
Drop Ball Impact Strength	>200ft-lbs at all temps. tested

PHYSICAL PROPERTIES

Specific Gravity	1.20
Light Transmission (avg.) 1/8" thick	88%
Chemical Resistance	Gasoline and kerosene: No tackiness, crazing or loss of transparency for a minimum of 48 hours.

THERMAL PROPERTIES

Coefficient of Thermal Expansion	$3 \frac{3}{4} \times 10^{-5} \text{"/in/}^{\circ}\text{F}$
Heat Deflection Temp. @ 264 psi	270°F

FLAMMABILITY

Horizontal Burn (Flame <1 in Spread)	
Ignition Temp.	Flash: 873°F Self: 1,076°F

TX1501HF

TRITAN COPOLYESTER

USED IN:

Tumbler End Caps - Versions E and later.

DESCRIPTION:

Eastman Tritan™ copolyester TX1501HF contains a mold release derived from vegetable-based sources. Features include good toughness, hydrolytic stability, and heat and chemical resistance. It may be used in repeated use food contact articles under US FDA regulations and is certified to NSF/ANSI Standard 51 for Food Equipment Materials and to NSF/ANSI Standard 61 - Drinking Water System Components-Health Effects.

TYPICAL APPLICATIONS:

Appliances, baby bottles, auto plastics, consumer electronics, housewares, tools, toys, water bottles.

PHYSICAL PROPERTIES

Specific Gravity 1.18

Mold Shrinkage 0.005 - 0.007 mm/mm
(0.005 - 0.007 in./in.)

THERMAL PROPERTIES

Deflection Temp.

@ 0.455 MPa (66psi) 94°C (201°F)
@ 1.82 MPa (264 psi) 81°C (178°F)

MECHANICAL PROPERTIES

Tensile Stress at Yield 43 MPa (6200 psi)

Tensile Stress at Break 52 MPa (7500 psi)

Elongation at Yield 7%

Elongation at Break 210%

Tensile Modulus 1575 MPa (2.28 x 10⁵ psi)

Flexural Modulus 1575 MPa (2.28 x 10⁵ psi)

Flexural Yield Strength 64 MPa (9300 psi)

Rockwell Hardness, R Scale 111

Izod Impact Strength, Notched at 23°C (73°F) 860 J/m (16.1 ft lbf/in.)

Impact Strength, Untouched at 23°C (73°F) NB

BASF ULTAMID® 8202C

POLYAMIDE 6

USED IN:

Tumbler Rings

DESCRIPTION:

Ultramid 8202C is a modified crystalline and low viscosity PA6 injection molding homopolymer. Its crystalline structure results in increased strength, stiffness, heat distortion temperature and performance under load as a homopolymer.

TYPICAL APPLICATIONS:

Furniture casters, gears, window hardware and fittings, insulators, valves, relays, wiring devices and other electrical components.

PROPERTIES

Melt Temperature

240-285°C

Mold Temperature

65 - 80°C

Injection & Packing Pressure

35 - 125 bar

DUPONT TYNEX® A 612

NYLON

USED IN:

Bush Bristles

DESCRIPTION:

Tynex® A is an abrasive filament made by extruding a mixture of nylon and abrasive grit. Nylon has several characteristics that make it attractive for abrasive filaments. Nylon is tougher and more durable than common alternative polymers. It is also resistant to abrasion, a fact that helps extend its useful life.

TYPICAL APPLICATIONS:

Industrial brushes for cleaning and equipment applications.

PHYSICAL PROPERTIES

Melting Point

> 200°C

Decomposition Temperature

> 190°C

HDPE 2 (HIGH-DENSITY)

POLYETHYLENE

USED IN:

Trim Tote

DESCRIPTION:

Flexible, translucent/waxy, weatherproof, good low temperature toughness (to -60oC), easy to process by most methods, good chemical resistance.

TYPICAL APPLICATIONS:

Food storage containers, piping, plastic bottles, geomembranes, fuel tanks.

PROPERTIES

Tensile Strength	0.20 - 0.40 N/mm ²
Notched Impact Strength	No break
Thermal Coefficient of Expansion	100 - 200 x10 ⁻⁶
Max. Continued Use Temp.	65°C (149°F)
Melting Point	126°C (259°F)
Density	0.941 - 0.965 g/cm ³

CLOSED CELL EPDM

SPONGE RUBBER

USED IN:

Trim Tote Gasket/Seal

DESCRIPTION:

Exhibits very good aging properties, compressibility, and shows an excellent resistance to UV, ozone and oxidation.

TYPICAL APPLICATIONS:

Various industrial and commercial applications such as HVAC systems, automotive parts and electrical enclosures.

PHYSICAL PROPERTIES

Density	> 200°C
Compression Deflection (CD) to 25%	> 190°C
Heat-Resistance (% change from original CD value after oven-aged 7 days @ 70oC)	-3.9%
Compression Set 22hrs. @ 70°C, 50% deflection with 30 min. recovery	24.6%
Compression Set 22hrs. @ 70°C, 50% deflection with 24 hr. recovery	18.5%
Compression Set 22hrs. @ 23°C, 50% deflection with 24 hr. recovery	5.2%
Fungus Resistance	Pass

EA E-30CL

ADHESIVE

USED IN:

Bed Knife Assembly

DESCRIPTION:

LOCTITE® EA E-30CL, also known as Hysol E-30CL Epoxy ADH Ultra, is a clear, colorless to slightly yellowish, 2-part, low viscosity, industrial grade epoxy adhesive. It cures at room temperature with minor shrinkage to form an ultra clear adhesive bondline with excellent impact resistance. It resists a wide range of chemicals and solvents and bonds most materials including glass, optical fibers, ceramics, metals and many rigid plastics.

TYPICAL APPLICATIONS:

Used in bonding, small potting, staking and laminating applications where optical clarity and excellent structural, mechanical and electrical insulating properties are required.

PROPERTIES

Cure Type	Room Temperature
Fixture Time	3 hours
Full Cure Temperature (°C)	25
Full Cure Temperature (°F)	77
Full Cure Time	24 hours
Key Characteristics	Chemical Resistant, Impact Resistant, Performance: High Performance, Viscosity: Low Viscosity, Work Life: Medium Work Life.
Number of Components	2 Part
Shear Strength, Steel (psi)	3100
Technology	Epoxy
Substrates	Ceramic, Metal, Plastic



