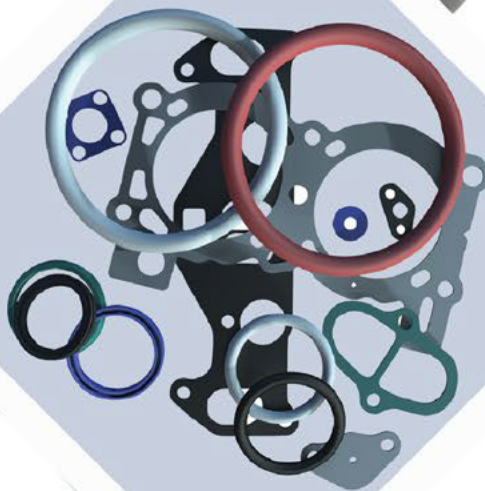


FLUONOX[®]

Fluoroelastomers

Engineered for demanding applications.



Product Selection Guide

Grades	Fluorine Content (%)	TR 10 (°C/°F)	Mooney Viscosity ML (1+10) @ 121°C (250 °F)	Hardness (Shore A)	Tensile Strength* MPa (psi)	Elongation at Break* (%)	Compression Set* (%)	Product suggested uses/applications
	Internal NMR	ASTM D 1329	ASTM D 1646	ASTM D 2240	ASTM D 412C	ASTM D 412C	ASTM D 395 Method B	

Bisphenol Curable

Cure Incorporated Copolymers								
KB 2250Z	66.0	-18 (-0.4)	23	74	14.0 (2031)	240 240	20 20	Injection molding of complex shapes - Metal bonding
KB 2252	66.0	-18 (-0.4)	23	73	13.0 (1885)	260 260	18 18	Injection molding of complex or extruded shapes.
KB 2253	66.0	-18 (-0.4)	23	76	14.0 (2031)	200 200	17 17	Injection molding, O-rings, gaskets.
KB 2255	66.0	-18 (-0.4)	23	76	13.0 (1885)	180 180	16 16	Injection molding, O-rings, gaskets. Improved Cset than KB 2253.
KB 2400Z	66.0	-18 (-0.4)	40	75	13.0 (1885)	250 250	23 23	Injection/ compression molding of metal-bonded parts
KB 2402	66.0	-18 (-0.4)	40	74	14.0 (2031)	250 250	18 18	Injection/ compression molding of complex shapes.
KB 2403	66.0	-18 (-0.4)	40	77	14.0 (2031)	190 190	17 17	Compression, transfer or injection molding of O-rings.
KB 2450Z	66.0	-18 (-0.4)	45	73	13.0 (1885)	230 230	23 23	Injection/ compression molding of metal-bonded parts
KB 2452	66.0	-18 (-0.4)	45	74	14.0 (2031)	250 250	17 17	Injection/ compression molding of complex shapes.
KB 2453	66.0	-18 (-0.4)	45	77	15.0 (2176)	190 190	15 15	Compression, transfer or injection molding of O-rings.

Bisphenol/Diamine Curable Terpolymer Raw Gums

KR 325	68.0	-14 (7)	25	75	13.0 (1885)	230 230	25 25	Low viscosity general purpose grade. Better chemical resistance vs. copolymers
KR 370	68.0	-14 (7)	70	74	14.0 (2031)	230 230	25 25	High viscosity general purpose grade. Better chemical resistance vs. copolymers.
KR 435	68.5	-13 (9)	30	73	13.0 (1885)	230 230	23 23	Medium-low viscosity general purpose grade. Better chemical resistance vs. copolymers.
KR 470	68.5	-13 (9)	65	73	14.0 (2031)	230 230	23 23	High viscosity general purpose grade. Better chemical resistance vs. copolymers.

Cure Incorporated Terpolymers

KR 3300Z	68.0	-14 (7)	30	73	11.0 (1595)	280 280	27 27	Injection molding of oil seals, metal bonding
KB 4303	68.5	-13 (9)	30	75	12.0 (1740)	190 190	23 23	Injection molding of O-rings, gaskets. Better chemical resistance vs. copolymers
KB 4602	68.5	-13 (9)	60	75	13.0 (1885)	250 250	25 25	Compression molding of complex shapes
KB 4603	68.5	-13 (9)	60	75	14.0 (2031)	200 200	23 23	Compression molding of O-rings, gaskets

Low Temperature Terpolymers

KR 630	65.8	-19 (-2)	30	75	13.0 (1885)	170	18	Injection molding, general purpose
KB 6253	65.8	-19 (-2)	25	72	13.0 (1885)	190	16	Compression, transfer or injection molding of O-rings

Peroxide Curable

Terpolymers								
KR 320P	67.0	-15 (5)	20	70	19.0 (2756)	250	22	Injection molding - General purpose
KR 340P	67.0	-15 (5)	45	70	19.0 (2756)	280	22	Compression molding - General purpose
KR 520P	70.4	-5 (23)	20	76	20.0 (2901)	210	17	Injection molding - General purpose. Best chemical resistance among FKMs
KR 545P	70.4	-5 (23)	45	72	21.0 (3046)	210	17	Injection or compression molding - General purpose. Best chemical resistance among FKMs
KR 565P	70.4	-5 (23)	65	72	21.0 (3046)	180	20	Compression molding - General purpose. Best chemical resistance among FKMs

* Press cure condition: 10 min at 170°C (338°F), Post cure conditions: for bisphenol curable grades: (8+16) hours at 230°C (446°F) / for peroxide curable grades: 4 hours at 230°C (446°F)

Test Compounds :

Using Bisphenol Curable Raw Gum			Using Bisphenol Cure incorporated Copolymers/Terpolymers			Using peroxide curable Terpolymer raw gum		
Raw Polymer	100	Remarks	Precompound	100	Remarks	Peroxide curable raw gum	100	Remarks
Bisphenol AF	2 phr	>99.5	N-990 carbon black	30 phr	Thermax N-990	N-990 carbon black	30 phr	Thermax N-990
BenzylTriphenylPhosphonium Chloride	0.5 phr	>99.5	Magnesium oxide	3 phr	Kyowamag 1 50	Luperox 101 XL45	3 phr	Arkema
N-990 carbon black	30 phr	Thermax N-990	Calcium hydroxide	6 phr	OMM-2	TAIC (100%)	3 phr	>99.0%
Magnesium oxide	3 phr	Kyowamag 1 50				Zinc Oxide (ZnO)	5 phr	>99.0%
Calcium hydroxide	6 phr	OMM-2						



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