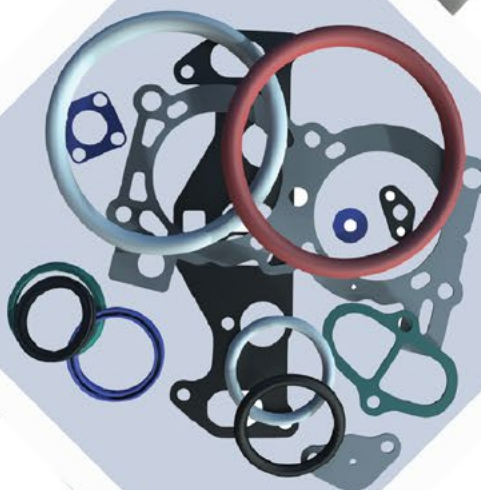


FLUONOX[®]

Fluoroelastomers

Engineered for demanding applications.



Product Selection Guide



GUJARAT FLUORO CHEMICALS
VALUE THROUGH GREEN CHEMISTRY

Grades	Fluorine Content (%)	TR 10 (°C/°F)	Mooney Viscosity ML (1+10) @ 121°C (250 °F)	Hardness (Shore A)	Tensile Strength* MPa (psi)
	Internal NMR	ASTM D 1329	ASTM D 1646	ASTM D 2240	ASTM D 412C

Bisphenol Curable

Cure Incorporated Copolymers

KB 2250Z	66.0	-18 (-0.4)	23	74	14.0 (2031)
KB 2252	66.0	-18 (-0.4)	23	73	13.0 (1885)
KB 2253	66.0	-18 (-0.4)	23	76	14.0 (2031)
KB 2255	66.0	-18 (-0.4)	23	76	13.0 (1885)
KB 2400Z	66.0	-18 (-0.4)	40	75	13.0 (1885)
KB 2402	66.0	-18 (-0.4)	40	74	14.0 (2031)
KB 2403	66.0	-18 (-0.4)	40	77	14.0 (2031)
KB 2450Z	66.0	-18 (-0.4)	45	73	13.0 (1885)
KB 2452	66.0	-18 (-0.4)	45	74	14.0 (2031)
KB 2453	66.0	-18 (-0.4)	45	77	15.0 (2176)

Bisphenol/Diamine Curable Terpolymer Raw Gums

KR 325	68.0	-14 (7)	25	75	13.0 (1885)
KR 370	68.0	-14 (7)	70	74	14.0 (2031)
KR 435	68.5	-13 (9)	30	73	13.0 (1885)
KR 470	68.5	-13 (9)	65	73	14.0 (2031)

Cure Incorporated Terpolymers

KR 3300Z	68.0	-14 (7)	30	73	11.0 (1595)
KB 4303	68.5	-13 (9)	30	75	12.0 (1740)
KB 4602	68.5	-13 (9)	60	75	13.0 (1885)
KB 4603	68.5	-13 (9)	60	75	14.0 (2031)

Low Temperature Terpolymers

KR 630	65.8	-19 (-2)	30	75	13.0 (1885)
KB 6253	65.8	-19 (-2)	25	72	13.0 (1885)

Peroxide Curable

Terpolymers

KR 320P	67.0	-15 (5)	20	70	19.0 (2756)
KR 340P	67.0	-15 (5)	45	70	19.0 (2756)
KR 520P	70.4	-5 (23)	20	76	20.0 (2901)
KR 545P	70.4	-5 (23)	45	72	21.0 (3046)
KR 565P	70.4	-5 (23)	65	72	21.0 (3046)

* 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)

** Compliant to FDA § 177.2600

*** 45 Mooney version available

	Elongation at Break* (%)	Compression Set* (%)	Product suggested uses/applications
	ASTM D 412C	ASTM D 395 Method B	
	240	20	Injection molding of complex shapes - Metal bonding
	260	18	Injection molding of complex or extruded shapes. FDA**
	200	17	Injection molding, O-rings, gaskets. FDA**
	180	16	Injection molding, O-rings, gaskets. Improved Cset than KB 2253. FDA**
	250	23	Injection/ compression molding of metal-bonded parts
	250	18	Injection/ compression molding of complex shapes. FDA**
	190	17	Compression, transfer or injection molding of O-rings. FDA**
	230	23	Injection/ compression molding of metal-bonded parts
	250	17	Injection/ compression molding of complex shapes. FDA**
	190	15	Compression, transfer or injection molding of O-rings. FDA**
	230	25	Low viscosity general purpose grade. Better chemical resistance vs. copolymers
	230	25	High viscosity general purpose grade. Better chemical resistance vs. copolymers. FDA**
	230	23	Medium-low viscosity general purpose grade. Better chemical resistance vs. copolymers. FDA**
	230	23	High viscosity general purpose grade. Better chemical resistance vs. copolymers. FDA**
	280	27	Injection molding of oil seals, metal bonding
	190	23	Injection molding of O-rings, gaskets. Better chemical resistance vs. copolymers
	250	25	Compression molding of complex shapes
	200	23	Compression molding of O-rings, gaskets
	170	18	Injection molding, general purpose
	190	16	Compression, transfer or injection molding of O-rings
	250	22	Injection molding - General purpose
	280	22	Compression molding - General purpose
	210	17	Injection molding - General purpose. Best chemical resistance among FKMs
	210	17	Injection or compression molding - General purpose. Best chemical resistance among FKMs
	180	20	

Test Compounds :

Using Bisphenol Curable Raw Gum

Raw Polymer	100	Remarks
Bisphenol AF	2 phr	>99.5
BenzylTriphenylPhosphonium Chloride	0.5 phr	>99.5
N-990 carbon black	30 phr	Thermax N-990
Magnesium oxide	3 phr	Kyowamag 1 50
Calcium hydroxide	6 phr	OMM-2

Using Bisphenol Cure incorporated Copolymers/Terpolymers

Precompound	100	Remarks
N-990 carbon black	30 phr	Thermax N-990
Magnesium oxide	3 phr	Kyowamag 1 50
Calcium hydroxide	6 phr	OMM-2

Using peroxide curable Terpolymer raw gum

Peroxide curable raw gum	100	Remarks
N-990 carbon black	30 phr	Thermax N-990
Luperox 101XL45	3 phr	Arkema
TAIC (100%)	3 phr	>99.0%
Zinc Oxide (ZnO)	5 phr	>99.0%



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