

# FLUONOX<sup>®</sup>

Fluoroelastomers

*Engineered for demanding applications.*



## Product Selection Guide



GUJARAT  
FLUORO-CHEMICALS  
LIMITED

Grade	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 Description	Product suggested uses/applications
	Internal NMR	ASTM D 1329	ASTM D 1646	ASTM D 2240	ASTM D 412C		ASTM D 395 Method B		

### Bisphenol Curable Copolymers Raw Gums

KR 220	66.0	-18 (-0.4)	22	74	13.0 (1845)	180	17	Medium-low viscosity Copolymer raw gum	Coating, viscosity/ crosslinking adjustments
KR 235	66.0	-18 (-0.4)	28	75	14.4 (2089)	180	17	Medium viscosity Copolymer raw gum	Coating, viscosity/ crosslinking adjustments. FDA**
KR 250	66.0	-18 (-0.4)	46	77	14.0 (2031)	190	17	Medium-high viscosity Copolymer raw gum	Coating, viscosity/ crosslinking adjustments. FDA**

### Cure Incorporated Copolymers

KB 2250Z	66.0	-18 (-0.4)	25	74	14.2 (2060)	240	25	Excellent mold flow, tear resistance, bonding to metal	Injection molding of complex shapes - Metal bonding
KB 2252	66.0	-18 (-0.4)	25	73	13.4 (1944)	260	18	Excellent mold flow, high elongation/ tear resistance	Injection molding of complex or extruded shapes. FDA**
KB 2253	66.0	-18 (-0.4)	25	76	14.0 (2031)	200	17	Fast cure rate, excellent mold release	Injection molding, O-rings, gaskets. FDA**
KB 2255	66.0	-18 (-0.4)	25	75	13.5 (1958)	180	16	Outstanding compression set	Injection molding, O-rings, gaskets. Improved compression set than KB 2253. FDA**
KB 2400Z	66.0	-18 (-0.4)	40	75	13.2 (1914)	250	25	Excellent mold flow, tear resistance, bonding to metal	Injection/ compression molding of metal-bonded parts
KB 2402	66.0	-18 (-0.4)	40	74	14.4 (2089)	250	18	Excellent mold flow, high elongation/ tear resistance	Injection/ compression molding of complex shapes. FDA**
KB 2403	66.0	-18 (-0.4)	40	77	14.0 (2031)	190	17	Excellent resistance to compression set	Compression, transfer or injection molding of O-rings. FDA**

### Bisphenol/Diamine Curable Terpolymers Raw Gums

KR 325	68.0	-14 (7)	25	74	12.6 (1827)	195	22	Improved chemical resistance vs Copolymers. Excellent processability	General purpose
KR 370	68.0	-14 (7)	70	76	14.3 (2074)	240	20	High viscosity version of KR 325	Compression molding of oil seals, general purpose. FDA**
KR 435	68.5	-13 (9)	35	77	12.5 (1813)	200	28	Excellent chemical resistance	Injection molding, coating by solution
KR 470	68.5	-13 (9)	70	76	14.0 (2031)	205	28	High viscosity version of KR 435	Compression molding of oil seals, general purpose. FDA**

### Cure Incorporated Terpolymers

KR 3300Z	68.0	-14 (7)	30	71	12.5 (1813)	230	27	Excellent tear resistance, bonding to metal	Injection molding of oil seals, metal bonding
KB 4303	68.5	-13 (9)	30	75	12.5 (1813)	190	23	High cross-linking density, excellent compression set resistance	Injection molding of O-rings, gaskets
KB 4602	68.5	-13 (9)	60	75	13.2 (1914)	250	25	Medium cross-linking density, excellent tear resistance	Compression molding of complex shapes
KB 4603	68.5	-13 (9)	60	75	13.5 (1958)	195	23	High viscosity version of KB 4303	Compression molding of O-rings, gaskets

### Low Temperature Bisphenol Curable

KR 630	66.0	-19 (-2)	30	75	13.5 (1958)	175	19	Low temperature Terpolymer with TR10 at -19°C (-2°F) - Raw gum	Injection molding, general purpose
KB 6253	66.0	-19 (-2)	25	76	14.0 (2031)	175	18	Low temperature Terpolymer with TR10 at -19°C (-2°F) - Cure incorporated	Compression, transfer or injection molding of O-rings

### Peroxide Curable Terpolymers

KR 320P	67.0	-15 (5)	20	70	19.4 (2814)	250	23	Outstanding relaxation behavior	Injection molding - General purpose
KR 340P	67.0	-15 (5)	45	70	19.3 (2799)	280	25	Medium viscosity version of KR 320P	Compression molding - General purpose
KR 520P	70.0	-5 (23)	20	76	20.5 (2973)	210	21	High %F Peroxide cure Terpolymer - Best in class for chemical resistance	Injection molding - General purpose
KR 545P	70.0	-5 (23)	45	72	21.2 (3075)	210	24	Medium viscosity version of KR 520P	Compression molding - General purpose

\* Press cure condition: 10 min at 170°C (338 F)

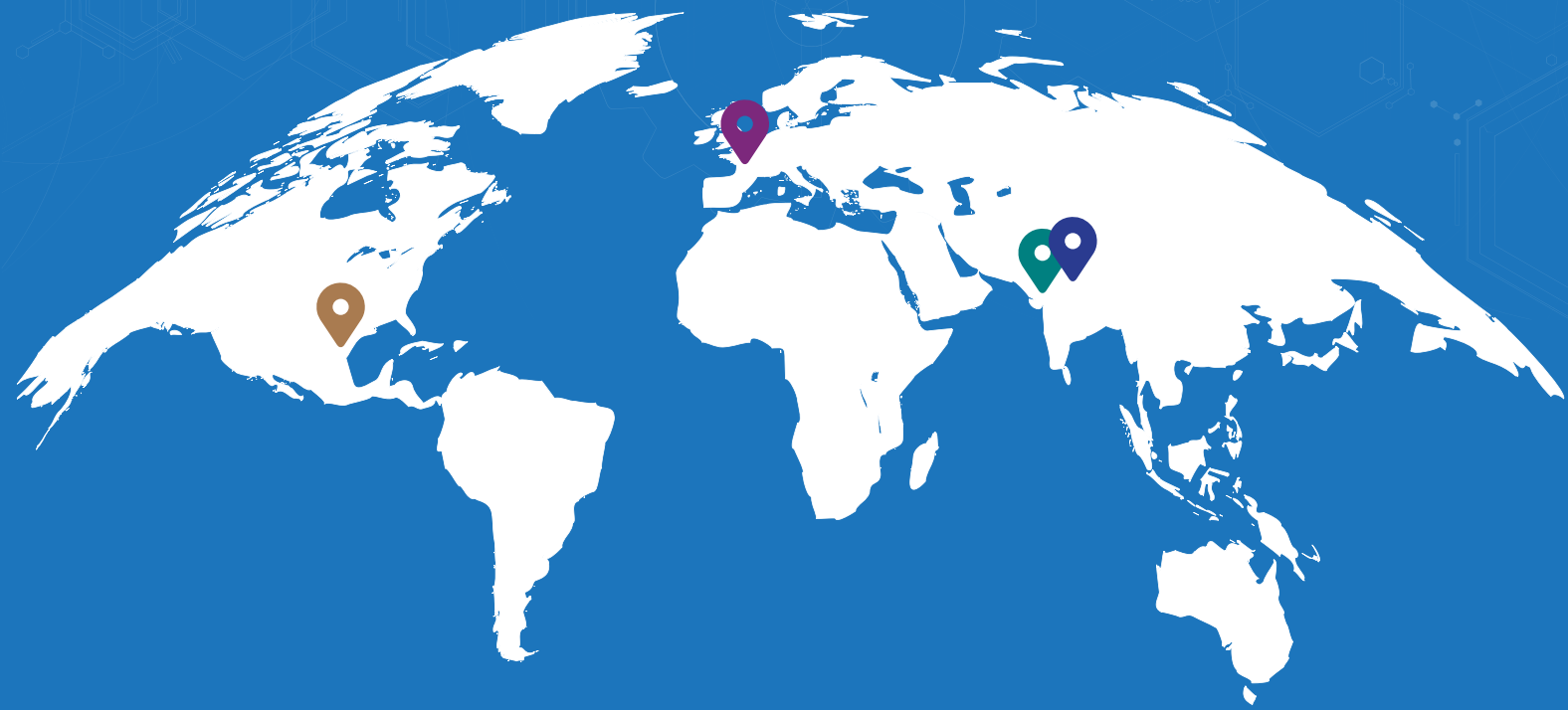
Post cure conditions: Bisphenol curable grades: (8+16) hours at 230°C (446 F) // Peroxide curable grades: 4 hours at 230°C (446 F)

\*\* Compliant to FDA § 177,2600

Copolymer cure incorporated grades are available in 45 Mooney version

### Test compounds:

Using Bisphenol Curable Raw Gum	Remarks	Using Bisphenol Cure Incorporated Copolymers/Terpolymers	Remarks	Using Peroxide Curable Terpolymer Raw Gum	Remarks
Raw Polymer	100	Precompound	100	Peroxide curable raw gum	100
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 101XL45	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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