

# Tecnoflon® FOR 5351/U

## Cure Incorporated Copolymer

Tecnoflon® FOR 5351/U is a low viscosity cure incorporated fluoroelastomer copolymer. This grade has excellent flow and good compression set. Tecnoflon® FOR 5351/U can be used for molded items with complicated shapes which require a very good hot tear resistance for part removal.

Some of the basic properties of Tecnoflon® FOR 5351/U are:

- Very fast cure rate
- Very good scorch safety
- Superior mold flow
- Excellent mold release
- Lack of mold fouling
- Low compression set
- High elongation
- Excellent hot tear strength

Tecnoflon® FOR 5351/U can be used for injection and transfer moulding of gaskets and seals. Tecnoflon® FOR 5351/U can be mixed using typical fluoroelastomers compounding ingredients and mixing can be accomplished with two roll mills or internal mixers.

Tecnoflon® FOR 5351/U can be extruded into hoses or profiles and can be calendered to make sheet stocks or belting. Finished goods can be produced by a variety of rubber processing methods.

### Handling and safety

Normal care and precautions should be taken to avoid skin contact, eye contact and breathing of fumes. Smoking is prohibited in working areas. Wash hands before eating or smoking. For complete health and safety information, please refer to the material safety data sheet.

### Basic characteristics of the raw polymer are as follows

Property	Typical Value	Unit	Test Method
ML (1+10') at 121 °C	24	MU	ASTM D1646
Fluorine content	66	%	Solvay Internal Method – NMR
Specific gravity	1.81	g/cm <sup>3</sup>	ASTM D792
Colour	Off white		
Packaging/Form	Slabs		
Solubility	Ketones and esters		

### Typical properties

Test Compound	Typical Value	Unit	Test Method
Tecnoflon® FOR 5351/U	100	phr	
MgO–DE	3	phr	
Ca(OH) <sub>2</sub>	6	phr	
N-990 MT Carbon Black	30	phr	

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Property	Typical Value	Unit	Test Method
Mooney viscosity ML (1+10') at 121 °C	50	MU	ASTM D1646
<b>Mooney Scorch MS 135 °C</b>			ASTM D1646
MV	23	MU	
t <sub>15</sub>	22	min	
<b>ODR 12 min at 177 °C arc 3°</b>			ASTM D2084
Minimum torque	10	lb·in	
Maximum torque	83	lb·in	
t <sub>s2</sub>	1.9	min	
t' <sub>90</sub>	3.6	min	
<b>MDR 6 min at 177 °C arc 0.5°</b>			ASTM D6601
Minimum torque	1.0	lb·in	
Maximum torque	15.2	lb·in	
t <sub>s2</sub>	1.2	min	
t' <sub>50</sub>	1.4	min	
t' <sub>90</sub>	2.2	min	
<b>Press cure: 10 min at 170 °C, post cure: (8+16) h at 250 °C</b>			
100% Modulus	4.7	MPa	ASTM D412C
Tensile strength	16.2	MPa	
Elongation at break	249	%	
Hardness	72	ShoreA	ASTM D2240
<b>Compression set</b>			ASTM D395
25% deformation, 70 h at 200 °C			method B
O-ring #214	18	%	
6 mm buttons	14	%	

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