

Tecnoflon® FOR 335

Cure Incorporated Copolymer

Tecnoflon® FOR 335 is a low viscosity cure incorporated fluoroelastomer copolymer. This grade is especially suited for injection molding of O-rings and sealing components which must meet demanding specifications. Tecnoflon® FOR 335 contains proprietary cure system providing superior processability for fast cycles and scorch safety. It has been particularly designed to offer improved characteristics such as flow, mold release, scorch safety and faster cycles at higher molding temperatures.

Some of the basic properties of Tecnoflon® FOR 335 are:

- Best for high duro and non-black compounds
- O-ring curative level
- Excellent mold flow
- Low viscosity
- Improved scorch safety
- Easiest mold release, non-mold fouling

Tecnoflon® FOR 335 can be used for injection and transfer moulding of O-rings, gaskets, and seals. Tecnoflon® FOR 335 can be mixed using typical fluoroelastomers compounding ingredients and mixing can be accomplished with two roll mills or internal mixers.

Tecnoflon® FOR 335 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 safety data sheet.

Basic characteristics of the raw polymer are as follows

Property	Typical Value	Unit	Test Method
ML (1+10') at 121 °C	20	MU	ASTM D1646
Fluorine content	66	%	Solvay Internal Method – NMR
Specific gravity	1.81	g/cm ³	ASTM D792
Color	Off white		
Packaging / Form	Slabs		
Solubility	Ketones and esters		

Typical properties

Test Compound	Typical Value	Unit	Test Method
Tecnoflon® FOR 335	100	phr	
MgO–DE	3	phr	
Ca(OH) ₂	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	44	MU	ASTM D1646
Mooney Scorch MS 135 °C			ASTM D1646
MV	19	MU	
t ₁₅	>60	min	
MDR 6 min at 177 °C arc 0.5 °			ASTM D6601
Minimum torque	0.8	lb · in	
Maximum torque	25.0	lb · in	
t _{s2}	2.1	min	
t' ₅₀	2.4	min	
t' ₉₀	3.5	min	
Press cure: 10 min at 170 °C			
100 % Modulus	5.3	MPa	
Tensile strength	10.2	MPa	
Elongation at break	240	%	
Hardness	71	ShoreA	ASTM D2240
Post cure: (8+16) h at 250 °C			
100 % Modulus	8.0	MPa	
Tensile strength	17.0	MPa	
Elongation at break	170	%	
Hardness	76	ShoreA	ASTM D2240
Compression set			ASTM D395 method B
25 % deformation, 70 h at 200 °C			
O-ring #214	16	%	
6 mm Buttons	13	%	
Heat resistance, 70 h at 275 °C			ASTM D573
Δ Tensile strength	-21	%	
Δ Elongation at break	16	%	
Δ Hardness	-2	ShoreA	

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