

OTHER APPLICATION

Molding, black

70 Shore A, FKM, bisphenol cure

Guide formulations of Ausimont (now Solvay Solexis)	Comparative fillers				
	39	40	41	42	43
Tecnoflon T 636	100.0	100.0	100.0	100.0	100.0
Tecnoflon FOR M1	3.3	3.3	3.3	3.3	3.3
Tecnoflon FOR M2	1.3	1.3	1.3	1.3	1.3
Elastomag 170	3.0	3.0	3.0	3.0	3.0
Calcium hydroxide	6.0	6.0	6.0	6.0	6.0
AKTISIL VM 56	30.0	---	---	---	---
AKTISIL MAM	---	30.0	---	---	---
MT N-990	---	---	30.0	---	---
Wollastonite, surface treated with epoxy silane	---	---	---	30.0	---
Barium sulfate, precipitated	---	---	---	---	30.0
Mold Wiz INT-44/3PV	1.0	1.0	1.0	1.0	1.0
Total phr	144.6	144.6	144.6	144.6	144.6

Mooney Viscosity

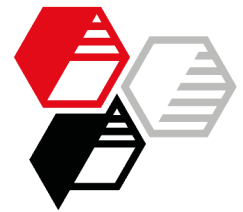
ML (1+10) 121°C	MU	83	120	88	182	125
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ODR 2000, 10 min @ 177°C

ML	dNm	16	19	16	19	17
MH	dNm	84	110	115	117	107
ts ₂	min	1.5	1.1	1.1	0.9	1.0
tC ₉₀	min	5.8	2.8	2.3	1.9	2.3

MDR, 6 min @ 177°C

ML	dNm	1.8	1.9	1.7	1.9	1.5
MH	dNm	14.2	18.2	19.8	18.8	15.8
ts ₂	min	1.1	0.4	0.4	0.3	0.4
tC ₉₀	min	4.0	1.3	1.2	0.6	1.0



		RRS	39	40	Comparative fillers		
			41	42	43		
Physical properties							
Press cure 10 min @ 177°C							
Hardness		Shore A	70	69	71	68	61
Modulus 100 %		MPa	3.5	3.7	3.4	4.5	2.0
Tensile strength		MPa	10.3	10.3	9.6	10.5	7.0
Elongation at break		%	420	350	345	290	330
Physical properties							
Pressure and post cure (8+16) h @ 250°C							
Hardness		Shore A	71	70	72	67	61
Modulus 100 %		MPa	4.9	5.9	5.7	6.7	2.6
Tensile strength		MPa	14.1	13.3	15.1	12.7	9.4
Elongation at break		%	275	225	220	210	295
Tear resistance	ASTM DIE C	N/mm	30.6	26.3	26.4	25.9	21.9
Compression set							
70 h @ 200°C	ASTM D 395 B	%	19	16	15	15	14
Air aging, 70 h @ 250°C, ASTM D 573							
Δ Hardness		Shore A	+1	0	+2	+2	+1
Δ Modulus 100 %		%	+1	-11	-5	-4	+2
Δ Tensile strength		%	-9	-12	-5	-4	-3
Δ Elongation at break		%, rel.	-6	+14	+4	-1	0

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