

# FKM 2604G2

### Introduction ▶

FKM 2604G2 fluoroelastomer is a medium-viscosity di-polymer that demonstrates improved processing when compared with existing fluoroelastomers.

### Features ▶

Compared with other di-polymers, FKM 2604G2 provides:

- Improved compression molding
- Better mold release
- Less mold fouling
- Excellent scorch safety
- Improved compression set resistance
- Improved tear strength resistance

Product Description	FKM 2604G2
Chemical Composition	Dipolymer of hexafluoropropylene and vinylidene fluoride
Physical form	sheet
Fluorine content	66%
Odor	None
Mooney Viscosity (ML 1+10 at 121°C)	125
Specific Gravity	1.82
Storage Stability	Excellent
Solubility	Low molecular weight esters and ketones

### Applications ▶

- Compression molding
  - O-rings
  - Gaskets
  - Seals
- Preferred material for fuel system
  - Fuel Injector O-ring

### Safety and Handling ▶

Keep off skin and wash well after handling.  
For the safe handling of other compounding ingredients, refer to the respective manufacturers' literature

### Packing Specification▶

25Kg

Table 1. Performance of FKM 2604G2 in typical compound

### Formulation of Full Compound ▶

Ingredients	FKM 2604G2
FKM 2604G2	97.5
Viton™ Curative No.50	2.5
N990 MT carbon black	30
Calcium hydroxide	6
Magnesium oxide (High activity)	3

### Rheology Properties ▶

Mooney Viscosity (ML 1+10 at 121°C)	151
MDR at 177°C, 0.5arc, 8min	
ML [dNm]	4.67
MH [dNm]	34.44
Ts1[min]	0.82
T90 [min]	2.29

### Physical Properties▶

Slab cure: 10min at 177°C	
Post cure: 24h at 230 °C	
Stress/strain at 23°C-original	
Tensile properties [MPa]	17.7
Elongation at break [%]	206
Modulus at 100 % [MPa]	7.7
Hardness, shore A, points	78
After heat aging 72h at 275°C	
Tensile properties [MPa]	11.8
Elongation at break [%]	210
Modulus at 100 % [MPa]	5.2
Hardness, shore A, points	78
Compression set, %, Type B, 25% Deflection	
70 hours at 200°C	16.7

