

BODA Fluoroelastomer BDF275P

Technical Data Sheet

BDF275P is a low viscosity curative incorporated fluoroelastomer copolymer.

This grade is well suited for application where good flowability and excellent mold release property are required. BDF275P can be compounded to meet the major fluoroelastomer specifications.

BDF275P can be used for injection molding of O-rings and gaskets, or extrusion of complicated geometries. It can be mixed using typical fluoroelastomer compounding ingredients. Mixing can be accomplished with two-roll mills or internal mixers. Finished goods can be produced by a variety of rubber processing methods. Basic characteristics of the polymer are as follows:

Properties	Typical Values
Fluorine Content, %	66
Specific Gravity	1.81
Color	White
Solubility	LMW Ketones and esters
Mooney Viscosity ML 1+10@121°C	20

Typical Properties of BDF275P

Test Compound			
Polymer			100
MT Black (N990)	phr		30
MgO	Phr		3
Ca(OH) ₂	phr		6
Curing Condition	Press		10min at 170°C
	Oven		24h at 230°C

Typical Rheological Properties

Monsanto Moving Die Rheometer (MDR2000®)
100cpm, 0.5°Arc, 6 minutes, 177 °C

ML, Minimum Torque	N m	0.15
ts2, Time to 2 inch-lb rise from minimum		1'02"
t'90, Time to 90% cure		2'21"
MH, Maximum Torque	N m	1.40

Typical Physical Properties

Press Cure 10 minutes @ 170 °C

Post Cure 24 hours @ 230 °C

Tensile (ASTM D412)	Mpa	11.0
Elongation at break (ASTM D412)	%	240
Hardness (ASTM D2240)	Shore A	76

Compression Set, [ASTM D395 Method B (Disc)]

Aged 70 hours @ 200°C	%	22
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