Haiflon® FKM Compound HFK-7802C

Ready-to-mold fluorine rubber (FKM) compound · bisphenol-cured · 20 kg net per carton

Haiflon FKM compounds for valve stem oil seals (78 Shore A, black/brown/gray/green) combine good mold flow and reliable metal bonding for compression and injection molding of rubber-to-metal seal assemblies.

Product Features

- **Good mold flow**
- **Metal bonding**
- **For compression and injection molding**

Basic Characteristics

Item	Typical value
Polymer type	Copolymer (VDF/HFP)
Cure system	Bisphenol-cured
Color	Brown

Typical Properties of Vulcanizate

Property	Typical value	Test method
Hardness, Shore A	78	ASTM D2240
Tensile strength, MPa	15.5	ASTM D412
Elongation at break, %	230	ASTM D412
Density, g/cm³	1.95	ASTM D297
Compression set (200 °C × 70 h), %	18	ASTM D395, Method B
TR10, °C	-16	ASTM D1329
Brittleness temperature, °C	-21	ASTM D2137

Heat Aging Resistance

Air aging 230 °C × 70 h — change of properties:

Property change	Hardness, pts	Tensile, %	Elongation, %	
Value	0	8.5	-6.2	

Fluid Resistance

Fluid (test condition)	ΔHardness, pts	ΔTensile, %	ΔElongation, %	ΔVolume, %
Engine oil 5W-30 (150 °C × 70 h)	1	-26.3	-35	1.5
Fuel C (23 °C × 70 h)	-3	-21.6	4.6	3.2
85 % 5W-30 + 15 % fuel (60 °C × 70 h)	-5	-21.3	8.7	2.9

Applications

- **Valve stem oil seals; rubber-to-metal bonded sealing parts for compression and injection molding**

Processing Guidelines

Haiflon FKM compounds are fully pre-mixed and ready for molding — no additional compounding is required. Mold by compression, transfer or injection molding; typical press cure is about 10 min at 170 – 180 °C, followed by a post cure (oven) of 4 – 24 h at 200 – 230 °C, depending on part thickness and performance requirements.

Safety Precautions

- **Store and handle in a well ventilated place; smoking is strictly forbidden in working areas.**
- **Avoid eye contact; wash thoroughly any contacted skin and clothing after handling.**
- **Further safety and handling information can be found in the product's Safety Data Sheet (SDS).**

Storage & Handling

- **Store in clean, cool, dry conditions, away from direct sunlight and heat sources; keep the package sealed.**
- **Use on a first-in-first-out basis.**

Packing

Packed in PE film, in cardboard carton; net weight 20 kg per carton. · Custom packing is available on request.

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