

Haiflon® FKM Compound HFK-7862T

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
- High temperature and oil resistance

Basic Characteristics

Item	Typical value
Polymer type	Terpolymer (VDF/HFP/TFE)
Cure system	Bisphenol-cured
Color	Black

Typical Properties of Vulcanizate

Property	Typical value	Test method
Hardness, Shore A	78	ASTM D2240
Tensile strength, MPa	14.6	ASTM D412
Elongation at break, %	190	ASTM D412
Density, g/cm ³	1.92	ASTM D297
Compression set (200 °C × 70 h), %	25	ASTM D395, Method B
TR10, °C	-13	ASTM D1329
Brittleness temperature, °C	-27	ASTM D2137

Heat Aging Resistance

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

Property change	Hardness, pts	Tensile, %	Elongation, %
Value	0	-4.6	2.9

Fluid Resistance

Fluid (test condition)	ΔHardness, pts	ΔTensile, %	ΔElongation, %	ΔVolume, %
Engine oil 5W-30 (150 °C × 70 h)	1	-7.4	-22	1.0
Fuel C (23 °C × 70 h)	-2	-14.3	1.5	2.6
85 % 5W-30 + 15 % fuel (60 °C × 70 h)	-4	-16.7	10.5	2.8

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.