

# 3M™ Dyneon™

## Fluoroelastomer LTFE 6350Z

### Low Temperature Peroxide Curable

#### Product Description

3M™ Dyneon™ Fluoroelastomer LTFE 6350Z is a terpolymer made from vinylidene fluoride, tetrafluoroethylene and perfluoromethylvinylether. The product contains an incorporated cure site monomer.

#### Special Features

- Composition: terpolymer of vinylidene fluoride, tetrafluoroethylene and perfluoromethylvinylether plus cure site monomer
- Process target: injection and transfer moulding, extrusion and calendaring
- Peroxide curable
- Improved low temperature performance compared to standard peroxide grades
- Excellent physical properties

#### Typical Applications

Dyneon LTFE 6350Z can be used for manufacturing parts such as O-rings for fuel injectors and other parts using the manufacturing processes listed above.

#### Typical Polymer Properties

Property	Test method	Unit	Value
Colour			Opaque, off-white
Fluorine Content		%	64.2
Mooney Viscosity (raw gum) ML 1 + 10 @ 121 °C	QMC 2.14.4C	Mooney Unit	50
Solubility			Ketones and Esters
Specific Gravity	QCM 14.10		1.80
Tg		°C	-32

#### Storage and Handling

Store and use all Dyneon Fluoroelastomers only in well ventilated areas under cool and dry conditions.

The shelf life of Dyneon LTFE 6350Z is 3 years from date of manufacturing.

#### Delivery Form

3M™ Dyneon™ Fluoroelastomer LTFE 6350Z is delivered in crumb form.

Packaging sizes:

- 25 kg cardboard box, containing two PE-bags with 12.5 kg material content each

#### Processing Recommendations

Dyneon LTFE 6350Z can be compounded using standard water cooled internal mixers or two-roll mills with standard fillers and ingredients utilized in typical fluoroelastomer formulations. The “dry” ingredients should be blended before adding to the masticated gum. For best results, Dyneon LTFE 6350Z should be banded on the mill several minutes prior to adding the blended dry ingredients. Once mixed, the compounded stocks have good scorch resistance and storage stability.

**3M™ Dyneon™****Fluoroelastomer LTFE 6350Z****Low Temperature Peroxide Curable****Typical Properties**

Compound	Amount (in Parts/100)
Dyneon LTFE 6350Z	100
Carbon Black MT N-990	30
TAIC (70 %)	4.3
ZnO	3
2,5-Dimethyl-2,5-di(tert-butylperoxy)hexane	1.5

**Typical Rheological Properties**

Alpha Technologies Moving Die Rheometer (MDR 2000), 100 cpm, 0.5° Arc, (QCM 2.19.1)

Test Condition, 6' minutes @ 177 °C

Property	Unit	Value
ML, Minimum Torque	dNm (in.lb)	1.7 (1.5)
MH, Maximum Torque	dNm (in.lb)	21.5 (19.0)
ts2	Minutes	0.4
t'50, Time to 50 % cure	Minutes	0.5
t'90, Time to 90 % cure	Minutes	0.8

**Typical Physical Properties**

Press Cured 7' minutes @ 177 °C

Post Cured 2 hours @ 230 °C

Property	Unit	Value
----------	------	-------

**Physical Properties DIN 53504 (S2 DIE)**

100 % Modulus	MPa (psi)	4.4 (638)
Tensile	MPa (psi)	21.8 (3163)
Elongation at Break	%	250
Hardness (ASTM D2240)	Type A	69

**Compression Set on buttons ASTM D395 method B**

70 hours @ 200 °C	%	22
-------------------	---	----

**Compression Set on O-rings ASTM D395 method B**

70 hours @ 200 °C	%	25
-------------------	---	----

**Lower Temperature Property**

TR10 (ASTM D1329)	°C	-30
-------------------	----	-----

### 3M™ Dyneon™ Fluoroelastomer LTFE 6350Z Low Temperature Peroxide Curable

#### Safety Instructions

Follow the normal precautions observed with all fluoropolymer materials.

Please consult the Material Safety Data Sheet and Product Label for information regarding the safe handling of the material. By following all precautions and safety measures, processing these products poses no known health risks. General handling/processing precautions include: 1) Process only in well-ventilated areas. 2) Do not smoke in areas contaminated with powder/residue from these products. 3) Avoid eye contact. 4) If skin comes into contact with these products during handling, wash with soap and water afterwards. 5) Avoid contact with hot fluoropolymer.

Potential hazards, including release of toxic vapours, can arise if processing occurs under excessively high temperature conditions. Vapour extractor units should be installed above processing equipment. When cleaning processing equipment, do not burn off any of this product with a naked flame or in a furnace.

#### Important Notice

All information set forth herein is based on our present state of knowledge and is intended to provide general notes regarding products and their uses. It should not therefore be construed as a guarantee of specific properties of the products described or their suitability for a particular application. Because conditions of product use are outside Dyneon's control and vary widely, user must evaluate and determine whether a Dyneon product will be suitable for user's intended application before using it.

The quality of our products is warranted under our General Terms and Conditions of Sale as now are or hereafter may be in force.

Technical information, test data, and advice provided by Dyneon personnel are based on information and tests we believe are reliable and are intended for persons with knowledge and technical skills sufficient to analyze test types and conditions, and to handle and use raw polymers and related compounding ingredients. Testing in accordance with DIN, ISO and ASTM.

No license under any Dyneon or third party intellectual rights is granted or implied by virtue of this information.

General recommendations on health and safety in processing, on work hygiene and on measures to be taken in the event of accident are detailed in our material safety data sheets.

You will find further notes on the safe handling of fluoropolymers in the brochure "[Guide for the safe handling of Fluoropolymers Resins](#)" (download link by PlasticsEurope, Box 3, B-1160 Brussels, Tel. +32 (2) 676 17 32).

You can also download it with your smartphone using the QR code below.



#### Customer Service

Europe  
Phone: 00 800 396 366 27  
Fax: 00 800 396 366 39  
Italy  
Phone: 800 7 910 18  
Fax: 800 7 810 19  
USA  
Phone: +1 800 810 8499  
Fax: +1 800 635 8061

#### Technical Service Fluoroplastics

Dyneon GmbH  
3M Advanced Materials Division  
Industrieparkstraße 1  
84508 Burgkirchen  
Germany  
Phone: +49 8679 7 4709  
Fax: +49 8679 7 5037

#### Technical Service Fluoroelastomers & Polymer Processing Additives

3M Belgium BVBA / SPRL  
3M Advanced Materials Division  
Canadastraat 11,  
Haven 1005  
2070 Zwijndrecht  
Belgium  
Phone: +32 3 250 7868  
Fax: +32 3 250 7905

#### Technical Service PTFE Compounds

Dyneon B.V.  
3M Advanced Materials Division  
Tunnelweg 95  
6468 EJ Kerkrade  
The Netherlands  
Phone: +31 45 567 9600  
Fax: +31 45 567 9619

We will gladly supply further contact details for our full network of global sales offices. Alternatively, find them [here](#).



Web Site: [www.dyneon.eu](http://www.dyneon.eu)

Printed in Germany  
© Dyneon 2016  
Status: Mar. 2016

3M, Dyneon and Dynamar are Trademarks of 3M Company.  
All Rights reserved. The present edition replaces all previous versions. Its content is being continuously adjusted to reflect the current level of knowledge. Please make sure and inquire if in doubt whether you have the latest edition.