3M™ Dyneon™
Fluoroelastomer FPO 3630
Medium Fluorine Peroxide Curable

Product Description
Dyneon Fluoroelastomer FPO 3630 is a medium fluorine content peroxide curable grade, which has been designed for injection moulding processes. The product provides excellent physical properties and very broad chemical resistance.

Special Features
- Composition: terpolymer of vinylidene fluoride, hexafluoropropylene and tetrafluoroethylene plus cure site monomer
- Process target: molding and extrusion
- Excellent flow
- Excellent physical properties
- Good low temperature properties
- High resistance against chemical fluids

Typical Applications
Dyneon Fluoroelastomer FPO 3630 can be used for plate heat exchange gaskets and many different applications where broad chemical resistance is needed.

Typical Polymer Properties

<table>
<thead>
<tr>
<th>Property</th>
<th>Test method</th>
<th>Unit</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Colour</td>
<td></td>
<td></td>
<td>Off-white</td>
</tr>
<tr>
<td>Fluorine Content</td>
<td>QCM 50.18.3C</td>
<td>%</td>
<td>67.3</td>
</tr>
<tr>
<td>Mooney Viscosity (raw gum) ML 1 + 10 @ 121°C</td>
<td>QCM 2.14.4C</td>
<td>Mooney unit</td>
<td>37</td>
</tr>
<tr>
<td>Solubility</td>
<td></td>
<td></td>
<td>Ketones and Esters</td>
</tr>
<tr>
<td>Specific Gravity</td>
<td>QCM 14.10</td>
<td></td>
<td>1.81</td>
</tr>
<tr>
<td>Tg</td>
<td></td>
<td>°C</td>
<td>-19</td>
</tr>
</tbody>
</table>

Storage and Handling
Store and use all Dyneon Fluoroelastomers only in well-ventilated areas under cool and dry conditions.
The shelf life of Dyneon Fluoroelastomer FPO 3630 is 3 years from date of manufacturing.

Delivery Form
3M™ Dyneon™ Fluoroelastomer FPO 3630 is delivered in slab form.
Packaging sizes are:
- 25 kg cardboard box
- 600 kg returnable bulk shipping container systems comprised of 48 PE bags, containing 12.5 kg of product each

Processing Recommendations
Dyneon Fluoroelastomer FPO 3630 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 Fluoroelastomer FPO 3630 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.
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**Typical Properties**

<table>
<thead>
<tr>
<th>Compound</th>
<th>Amount (in Parts/100)</th>
</tr>
</thead>
<tbody>
<tr>
<td>FPO 3630</td>
<td>100</td>
</tr>
<tr>
<td>Carbon Black MT N-990</td>
<td>30</td>
</tr>
<tr>
<td>TAIC (70%)</td>
<td>3.5</td>
</tr>
<tr>
<td>ZnO</td>
<td>3</td>
</tr>
<tr>
<td>Trigonox 101-50D</td>
<td>3</td>
</tr>
</tbody>
</table>

**Typical Rheological Properties**

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

**Test Condition, 6' @ 177°C**

<table>
<thead>
<tr>
<th>Property</th>
<th>Unit</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>ML, Minimum Torque</td>
<td>dNm</td>
<td>1.0</td>
</tr>
<tr>
<td>MH, Maximum Torque</td>
<td>dNm</td>
<td>19.4</td>
</tr>
<tr>
<td>ts2</td>
<td>Minutes</td>
<td>0.5</td>
</tr>
<tr>
<td>t50, Time to 50 % cure</td>
<td>Minutes</td>
<td>0.7</td>
</tr>
<tr>
<td>t90, Time to 90 % cure</td>
<td>Minutes</td>
<td>1.9</td>
</tr>
</tbody>
</table>

**Typical Physical Properties**

Press Cured 15’ @ 177 °C
Post Cured 16 hours @ 230 °C

<table>
<thead>
<tr>
<th>Property</th>
<th>Unit</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Physical Properties DIN 53504 (S2 DIE)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>100% Modulus</td>
<td>MPa</td>
<td>7.0</td>
</tr>
<tr>
<td>Tensile</td>
<td>MPa</td>
<td>24.0</td>
</tr>
<tr>
<td>Elongation at break</td>
<td>%</td>
<td>197</td>
</tr>
<tr>
<td>Hardness (ASTM D2240)</td>
<td>Shore A</td>
<td>72</td>
</tr>
</tbody>
</table>

Compression Set on buttons ASTM D395 method B

70 hours @ 200°C % 24

Compression Set on 2 mm disks; 50% deformation VDA 675218

22 hours @ 150°C % 52

**Lower Temperature Property**

TR10 (ASTM D1329) °C -17
Safety Instructions

Follow the normal precautions observed with all fluoro polymer 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 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.

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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.

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