

Rheometer Curing Properties Comparison of ARLON® 27 and 57 Compounds

Properties		Product		Curing Temperature °F					
				212°	239°	250°	280°	302°	302°
Minimum torque (lb-in)	27	1.7	1.9	1.9	2.4	2.8	3.5		
	57	1.0	1.0	1.0	1.1	1.3	1.7		
Maximum torque (lb-in)	27	18.5	23.6	23.8	25.1	25.5	25.9		
	57	7.5	11.6	12.2	12.8	13.0	13.7		
Time for curing, TC10 (minute)	27	0.6	0.3	0.2	0.1	0.1	0.1		
	57	1.4	0.5	0.4	0.3	0.2	0.1		
Time for 90% curing, TC90 (minute)	27	3.2	1.0	0.7	0.4	0.3	0.2		
	57	11.8	8.7	5.8	1.4	0.6	0.3		
Time for 100% curing (minute)	27	12.1	3.3	2.0	0.8	0.5	0.4		
	57	15.0	15.0	15.0	14.2	1.9	0.5		

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Test instrument: MDR 3000 (Montech)

Test method: Constant curing temperature and curing time=15 minutes

Disclaimer: The curing time provided herein is a general guideline only. During this rheometer test, rubber reaches the test temperature immediately. In real life applications it will take longer for the rubber to reach target temperature. Actual curing time needs to be evaluated on a case-by- case basis.

