**DAI-EL® G-671**

**Characteristics**

**DAI-EL® G-671** is a bisphenol cure incorporated terpolymer designed for transfer and compression molding applications. G-671 combines good chemical and solvent resistance with good low temperature properties.

<table>
<thead>
<tr>
<th>Properties*</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Fluorine content</td>
<td>66%</td>
</tr>
<tr>
<td>Specific gravity</td>
<td>1.80</td>
</tr>
<tr>
<td>Mooney viscosity (ML1+10@121°C)</td>
<td>35</td>
</tr>
<tr>
<td>Color</td>
<td>Milky white to light pink sheet</td>
</tr>
<tr>
<td>Solubility</td>
<td>Soluble in lower ketones and esters</td>
</tr>
</tbody>
</table>

*Typical properties are not suitable for specification purposes.

**Typical Applications**

O-rings, gaskets, seals

**Form & Packaging**

**DAI-EL® G-671** is packaged as slabs with polyethylene film separators sealed in a polyethylene bag. The standard shipping container is a 20 kg (44 lb) net weight carton.

**Safety**

1. Store and use all fluoroelastomers in a well-ventilated area.
2. Do not smoke in areas contaminated with dust from fluoroelastomers.
3. Avoid eye contact.
4. After handling, wash any skin that came in contact with the product with soap & water.

Potential hazards, including evolution of toxic vapors, exist during compounding or processing under high temperatures. Before processing Daikin fluoroelastomers, consult the SDS (Safety Data Sheet) and follow all label directions and handling precautions. Read and follow all directions from other compound ingredient suppliers. Mixing agents that contain metallic particulate such as powdered aluminum can rapidly decompose at high temperatures, and therefore should not be used with this product.
**Typical Compound Properties**

<table>
<thead>
<tr>
<th>Test Formula</th>
<th>phr</th>
</tr>
</thead>
<tbody>
<tr>
<td>DAI-EL® G-671</td>
<td>100</td>
</tr>
<tr>
<td>N-990 Carbon Black</td>
<td>30</td>
</tr>
<tr>
<td>Magnesium Oxide</td>
<td>3</td>
</tr>
<tr>
<td>Calcium Hydroxide</td>
<td>6</td>
</tr>
</tbody>
</table>

**Rheological Properties**

<table>
<thead>
<tr>
<th>Temperature: 190°C</th>
<th>Strain: 0.5°</th>
</tr>
</thead>
<tbody>
<tr>
<td>Frequency: 100 cpm</td>
<td>Test time: 6 min</td>
</tr>
</tbody>
</table>

- ML (minimum torque), lb-in (dNm): 1.7 (1.9)
- MH (maximum torque), lb-in (dNm): 20.8 (23.5)
- t2 (scorch time), minutes: 0.6
- t'50 (time to 50% cure), minutes: 0.8
- t'90 (time to 90% cure), minutes: 1.0

**Physical Properties**

<table>
<thead>
<tr>
<th>Press Cure</th>
<th>10 min @ 190 °C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Post Cure</td>
<td>24 hrs @ 232 °C</td>
</tr>
</tbody>
</table>

- Hardness, Shore A: 76
- Tensile strength, MPa (psi): 12.0 (1750)
- Elongation at break, %: 130
- 100% Tensile Stress, MPa (psi): 9.1 (1320)
- Compression Set, ASTM D395 Method B (#214 O-ring)

- 70 hours @ 175°C (347°F), %: 11
- 70 hours @ 200°C (392°F), %: 22

**Low Temperature Properties**

- Embrittlement Temperature, °C: -23
- Gehman Torsion ASTM 1053-92A
  - T2, °C: -9.0
  - T10, °C: -14.7

**Temperature Retraction**

- TR10, °C: -20
- TR70, °C: -10

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**DAIKIN AMERICA, INC.**
20 Olympic Drive
Orangeburg, NY 10962
Customer Service: 800-365-9570
Fax: 845-365-9598
http://www.daikin-america.com

**DAIKIN INDUSTRIES, LTD.**
Umeda Center Building
2-4-12 Nakasaki-Nishi, Kita-Ku
Osaka 530-8323 Japan
Phone: +81-6-6734-9355
Fax: +81-6-6734-4281
http://www.daikin.com

**DAIKIN CHEMICAL EUROPE GmbH**
Immermannstr, 65D
40210 Düsseldorf, Germany
Phone: +49-211-1792250
Fax: +49-211-1640732