



道弘提供选择的牌型号		Dowhon FKM For fuel line hose	
牌号 Grade	氟含量%/F%	门尼粘度 Mooney viscosity ML1+10@ 121℃	产品特点及应用 Product feature and application
DTR-5915	69	13	挤出性优异，中等硫化速度，适用于大口径管子（如加油管） Excellent extrusion performance, middle curing speed, suitable for big diameter hose(like filler neck hose)
DTR-5915K	69	13	挤出性优异，较快的硫化速度，适用于大口径管子 Excellent extrusion performance, fast curing speed, suitable for big diameter hose
DTR-5915KD	69	13	挤出性优异，快速硫化速度，适用于大口径管子 Excellent extrusion performance, fast curing speed, suitable for big diameter hose
DTR-5915KE	69	18	挤出性好，较快硫化速度，耐热性优异，中等口径管子 Excellent extrusion performance, fast curing speed, excellent heat resistance, suitable for middle size hose
DTR-5925G	69	25	挤出性好，中等硫化速度，高强度 Excellent extrusion performance, normal curing speed, high tensile strength
DTR-5915GE	69	13	挤出优异，较快硫化速度，高强度，适用于大口径产品 Excellent extrusion performance, fast curing speed, high tensile strength, suitable for big diameter hose
DTR-5919GE	69	26	挤出性优异，较快硫化速度，高强度，适用于中等口径产品 Excellent extrusion performance, fast curing speed, high tensile strength, suitable for middle size hose
DTR-5930GE	69	30	挤出性好，较快硫化速度，高强度，适用于中等口径产品 Excellent extrusion performance, fast curing speed, high tensile strength, suitable for middle size hose
DTR-5915TV	69	13	挤出性优异，较快硫化速度，与THV500粘接优异 Excellent extrusion performance, fast curing speed, excellent bonding performance with THV500
DTR-5915TVC	69	13	挤出性优异，较快硫化速度，与THV800粘接优异 Excellent extrusion performance, fast curing speed, excellent bonding performance with THV800

◆ 可供参考的挤出工艺 Recommended Extrusion Parameters

挤出产品规格 Hose specification

内径 Inner Diameterø7.7mm 总壁厚 Total Thickness:2.0 mm 其中内层FKM厚度 Thickness Of Fkm Layer：0.7mm 外层 Outer Layer：ECO

挤出机温度：zone Temperature

内胶 Inner Layer(FKM)	螺杆 Screw：70℃	喂料口 Feeding：60℃	塑化段 Plasticizing：85℃
外胶 Outer Layer(ECO)	螺杆 Screw：40℃	喂料口 Feeding：45℃	塑化段 Plasticizing：60℃
复合机头温度(Die Head)：85℃			

螺杆转速 Screw Speed	内胶 Inner Layer(FKM)：12.18rpm	外胶 Outer Layer(ECO)14.2rpm
机头压力 Die Pressure	内胶 Inner Layer(FKM)：30.7mpa	外胶 Outer Layer(ECO)15.3mpc
挤出速度 Extrusion Speed：7m/min		

道弘氟橡胶与增粘剂
在汽车燃油胶管系统

—— 解决方案

Dowhon Fluoroelastomer And Bonding Solution
In Automotive Fuel Line Hose System

四川道弘新材料有限公司
Sichuan Dowhon New Materials Co., Ltd.

www.dowhon.com

产品属性 Product Feature

- ◆ 独特的分子链末端封端技术
Special Molecular Chain Capping Technology
- ◆ 双峰分布
Bimodal Distribution
- ◆ 优异的挤出性能
Excellent Extrusion Performance
- ◆ 优异的抗燃油渗透性能
Excellent Permeation Resistance To Fuel
- ◆ 优异的直接硫化粘接性能
Excellent Bonding Performance Through Curing

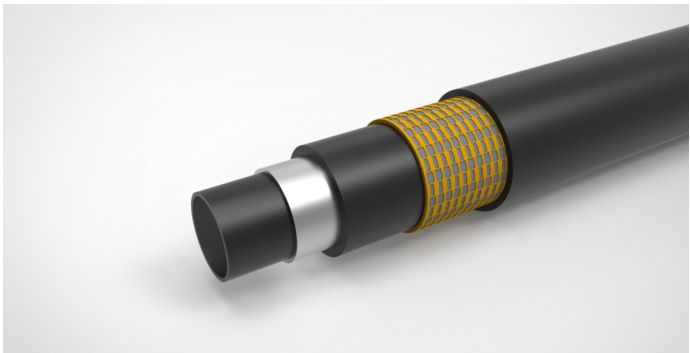


产品运用 Application

- ◆ 加油管 Fuel Filler Neck Hose



- ◆ 电喷管 Fuel Line Hose



粘接剂解决方案与氟橡胶的选择 Bonding Solution And FKM Selection

相互粘接的两种材料 Two Materials Need To Be Bonded		增粘剂 Bonding Agent	备注 Remark
FKM	ECO	FD-570/FD-560	
FKM	ECO	FD-4156/XL-21/水滑石 (hydrotalcite)	
THV	NBR	FD-4152/FD-4153	
THV	ECO	FD-570/FD-560	
THV	FKM	FD-4199/FD-4195	
FKM	NBR	FD-4152/FD-4153	