



Crosslinking peroxides for elastomers and thermoplastics



Perkadox[®] and Trigonox[®]

Nouryon

A complete range of crosslinking peroxides

Nouryon's range of organic peroxides for the crosslinking of elastomers and thermoplastics is very extensive. Companies all over the world depend on our Trigonox® and Perkadox® organic peroxide brands. Why? Because they are an important ingredient in the production of everything from hi-tech automotive parts such as hoses and belts to shoe soles and power distribution cables.

Examples include:

- **Trigonox 311**
PEX pipes, rotomolding
- **Trigonox 145**
PEX pipes, rotomolding
- **Trigonox 101**
PEX pipes, polymer modification, technical rubber goods
- **Trigonox T**
wire & cable (direct peroxide injection)
- **Perkadox 14**
wire & cable, technical rubber goods, footwear
- **Perkadox BC**
wire & cable, footwear, technical rubber goods
- **Trigonox 117 and Trigonox 131**
for EVA and POE encapsulant films
- **Trigonox 29**
for fast on-set of cure
- **Perkadox PM-50S-ps**
extruded silicone rubber articles such as silicone rubber cable, seals & tubes (halogen free)

Much of our success is due to our philosophy of creating close partnerships with our customers. What do you want to achieve? From optimizing applications, improving efficiencies, resolving difficulties or even developing new crosslinking peroxides, we're happy to meet with you to discuss your requirements.

This product guide provides an overview of our main, commercially available crosslinking peroxides. We invite you to visit us at nouryon.com for complete product listings.

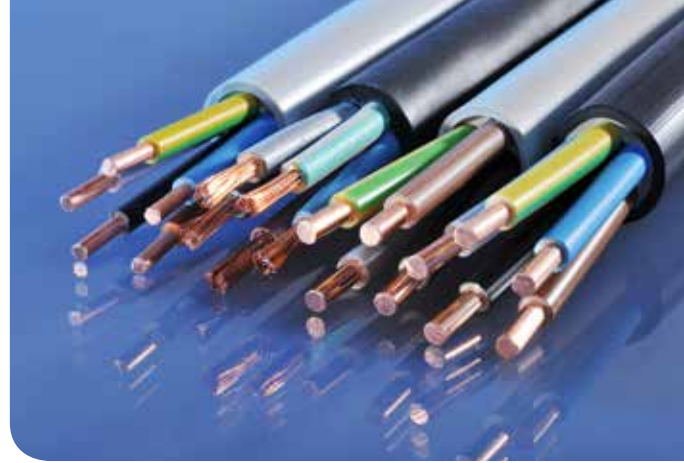
Formulations with phlegmatizers and carriers or concentrations other than those indicated, as well as unique custom made peroxide compositions can be made available with due observance of safety characteristics and the appropriate environmental and transportation regulations. Whatever your particular requirements, we can develop the product to match.



¹ Trigonox B has a boiling point of 110°C and a flash point of 6°C. Therefore, it is not recommended for standard rubber mixing procedures carried out in closed mixers (kneading mixer type) or on an open two-roll mill.

² Other concentrations are available on request

Product name	Chemical name [CAS no.]	Mol. weight	Assay (%)	Main carrier / solvent	Processing data	
					Safe processing temperature °C (°F)	Typical crosslink temperature °C (°F)
Trigonox 311	3,3,5,7,7-Pentamethyl-1,2,4-trioxepane [215877-64-8]	174.3	95		180 (356)	220 (428)
						
Trigonox 145-E85	2,5-Dimethyl-2,5-di(tert-butylperoxy)hexyne-3 [1068-27-5]	286.4	85	mineral oil	145 (293)	185 (365)
Trigonox 145-45B-PD			45	calcium carbonate		
						
Trigonox B ¹	Di-tert-butyl peroxide [110-05-4]	146.2	99		145 (293)	180 (356)
						
Trigonox 101	2,5-Dimethyl-2,5-di(tert-butylperoxy)hexane [78-63-7]	290.4	92		135 (275)	175 (347)
Trigonox 101-7.5PP-PD ²			7.5	PP		
Trigonox 101-20PP-PD ²			20	PP		
Trigonox 101-45B-PD			45	calcium carbonate/silica		
						
Trigonox T	tert-Butyl cumyl peroxide [3457-61-2]	208.3	95		135 (275)	175 (347)
						
Perkadox 14S-(FL)	Di(tert-butylperoxyisopropyl)benzene [25155-25-3; 2212-81-9]	338.5	98		135 (275)	175 (347)
Perkadox 14-40B-PD			40	calcium carbonate		
Perkadox 14-40K-PD-S			40	clay		
Perkadox 14-40MB-GR-S			40	EPR, calcium carbonate		
Perkadox 14-EP40			40	granules		
						
Perkadox BC-FF	Dicumyl peroxide [80-43-3]	270.4	99		130 (266)	170 (338)
Perkadox BC-40B-PD			40	calcium carbonate		
Perkadox BC-40K-PD			40	clay		
Perkadox BC-EP40			40	granules		
						



PD = powder
GR = granules
PS = paste
MB = EPR bound

Product name	Chemical name [CAS no.]	Mol. weight	Assay (%)	Main carrier / solvent	Processing data	
					Safe processing temperature °C (°F)	Typical crosslink temperature °C (°F)
Trigonox 17-40B-PD	Butyl 4,4-di(tert-butylperoxy)valerate [995-33-5]	334.5	40	calcium carbonate	125 (257)	160 (320)
Trigonox 117	tert-Butylperoxy 2-ethylhexyl carbonate [34443-12-4]	246.3	>98		120 (248)	150 (302)
Trigonox 29-40B-PD	1,1-Di(tert-butylperoxy)-3,3,5-trimethylcyclohexane [6731-36-8]	302.5	40	calcium carbonate	115 (239)	145 (293)
Trigonox C	tert-Butyl peroxybenzoate [614-45-9]	194.2	98		100 (212)	140 (284)
Trigonox C-40B-PD			40	calcium carbonate		
Perkadox PM-50S-PS	Di(4-methylbenzoyl) peroxide [895-85-2]	270.3	50	silicone oil	85 (185)	110 (230)
Perkadox L-50S-PS	Dibenzoyl peroxide [94-36-0]	242.2	50	silicone oil	85 (185)	105 (221)
Perkadox PD-50S-PS	Di(2,4-dichlorobenzoyl) peroxide [133-14-2]	380.0	50	silicone oil	75 (167)	90 (194)



Recommended dosage levels

Peroxide	Trigonox 29-40	Trigonox 17-40	Perkadox BC-40	Perkadox 14-40	Trigonox 101-45
Safe processing temperature (°C)	115	125	130	135	135
Typical crosslink temperature (°C)	145	160	170	175	175
Polymer	parts of peroxide per 100 parts of polymer				
NR; IR	2.3 - 4.5	2.5 - 5.0	2.0 - 4.1	1.3 - 2.5	1.3 - 2.4
BR	1.0 - 2.1	1.1 - 2.3	0.9 - 1.9	0.5 - 1.2	0.5 - 1.2
CR	1.1 - 3.0	1.3 - 3.3	1.0 - 2.7	0.6 - 1.7	0.6 - 1.6
SBR	1.9 - 4.1	2.1 - 4.6	1.7 - 3.7	1.1 - 2.3	1.1 - 2.2
NBR	2.6 - 4.5	2.9 - 5.0	2.4 - 4.1	1.5 - 2.5	1.4 - 2.4
HNBR	6.8 - 11.3	7.5 - 12.5	6.1 - 10.1	3.8 - 6.3	3.7 - 6.1
POE ¹	6.8 - 11.3	7.5 - 12.5	6.1 - 10.1	3.8 - 6.3	3.7 - 6.1
EPM ¹ ; EPDM	6.8 - 11.3	7.5 - 12.5	6.1 - 10.1	3.8 - 6.3	3.7 - 6.1
PE	1.5 - 7.6	1.7 - 8.4	1.4 - 6.8	0.8 - 4.2	0.8 - 4.0
CM ¹	6.8 - 10.6	7.5 - 11.7	6.1 - 9.5	3.8 - 5.9	3.7 - 5.7
EVA	2.6 - 5.3	2.9 - 5.8	2.4 - 4.7	1.5 - 3.0	1.4 - 2.9
Q ²			1.0 - 2.0	0.4 - 0.8	0.4 - 0.8

¹ Addition of a coagent is recommended.

² Silicone rubber can also be crosslinked with Perkadox PD-50S, Perkadox L-50S and Perkadox PM-50S.

Required amounts of peroxide: 1.1 - 2.3 phr, 0.7 - 1.4 phr and 0.8 - 1.6 phr respectively.

Typical crosslink temperatures 90°C, 105°C and 110°C.

Peroxide versus sulfur crosslinking

Advantages of peroxide crosslinking in comparison to sulfur cure:

- Simple formulation.
- Relatively easy to trace decomposition products
- Storage of the peroxide-containing compound without bin scorch.
- High processing temperature.
- Rapid vulcanization without reversion.
- Good compression set, particularly at elevated temperatures.
- High temperature resistance.
- Limited extractable constituents from final product.
- No staining of the finished parts.
- No discoloration of crosslinked product by contact with metals and PVC.
- Most peroxides do not cause blooming.

- Co-vulcanization of saturated and unsaturated elastomers.
- Co-vulcanization of elastomers and thermoplastics.
- Copolymerization with polymerizable plasticizers or coagents to give controlled hardness and stiffness, coupled with easy processing.
- Zinc oxide-free formulations possible

Points of attention for peroxide crosslinking:

- Sensitivity to oxygen under curing conditions.
- Certain components of the rubber compound such as
 - fillers
 - extender oils
 - antioxidants
 - resins

must be selected with care because they may, under certain conditions, interfere with free radicals.

- Usually, tensile and tear strength properties are reduced by about 15%, when compared to a conventional sulfur based crosslinking system.
- Scorch and cure time are less flexible, since they are determined mainly by the temperature.
- During cure, some peroxides may lead to distinct odors.
- Post cure may be necessary.



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Contact us

For product inquiry and ordering information, please contact your Nouryon account manager or regional Nouryon sales office.

Americas

US and other countries

100 Matsonford Road
Building 5, Suite 550
Radnor, PA 19087
USA
T +1 800 828 7929 (US only)
E polymer.amer@nouryon.com

Mexico

Av. Morelos No. 49
Col. Tecamachalco
Los Reyes La Paz Estado de Mexico
C.P. 56500 Mexico
T +52 55 5858 0700
E polymer.mx@nouryon.com

Brazil

Rodavia Nouryon no. 707
Portão A – Planta C
Bairro São Roque da Chave
13295-000 Itupeva - São Paulo
Brazil
T +55 11 4591 8800
E polymer.sa@nouryon.com

Europe, India, Middle East and Africa

France, Italy, Spain and Portugal

Autovia de Castelldefels, km 4.65
08820 El Prat de Llobregat
Barcelona
Spain
T +34 933 741991
E polymer.es@nouryon.com

India

North Block 801, Empire Tower,
Reliable Cloud City Campus,
Off Thane – Belapur Road
Airoli, Navi Mumbai - 400708
India
T +91(0) 22 68426700
E polymer.emeia@nouryon.com

Middle East

Nouryon Saudi Arabia
King Saud Road, Kanoo Tower
P.O. Box 37
31411 Dammam
Saudi Arabia
T + 96 61383 46526
E communications.me@nouryon.com

Russia and CIS

Smolnaya Str., 24D,
Commercial Tower Meridian
125445 Moscow
Russia
T + 7 495 766 1606
E info.moscow@nouryon.com

Other countries

Zutphenseweg 10
7418 AJ Deventer
The Netherlands
E polymer.emeia@nouryon.com

Asia Pacific

Room 2501 & 26F, Building A
Caohejing Center
No. 1520 Gumei Road, Xuhui District
Shanghai 200233
P.R. China
T +86 21 2289 1000
E polymer.apac@nouryon.com

Additional information

Product Data Sheets (PDS) and Safety Data Sheets (SDS) for our polymer crosslinking products are available at [nouryon.com](https://www.nouryon.com)

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