



# Crosslinking peroxides for elastomers and thermoplastics



Perkadox<sup>®</sup> and Trigonox<sup>®</sup>

**Nouryon**

# A complete range of crosslinking peroxides

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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 and Perkadox® PD-50S-PS**  
extruded silicone rubber articles such as silicone rubber cable, seals & tubes

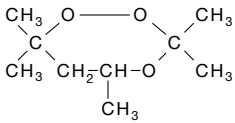
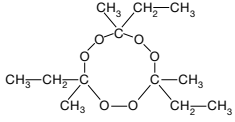
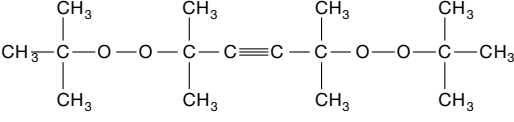
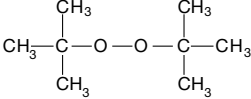
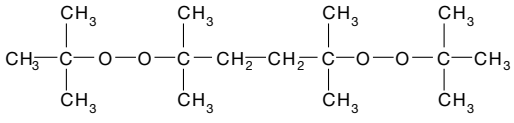
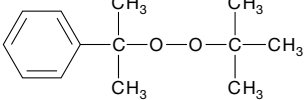
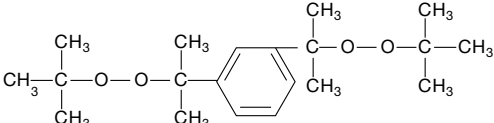
Much of our success is due to our philosophy of creating close partnerships with our customers. What do you want to achieve? From optimizing applications, improving efficiencies, resolving difficulties or even developing new crosslinking peroxides, we're happy to meet with you to discuss your requirements.

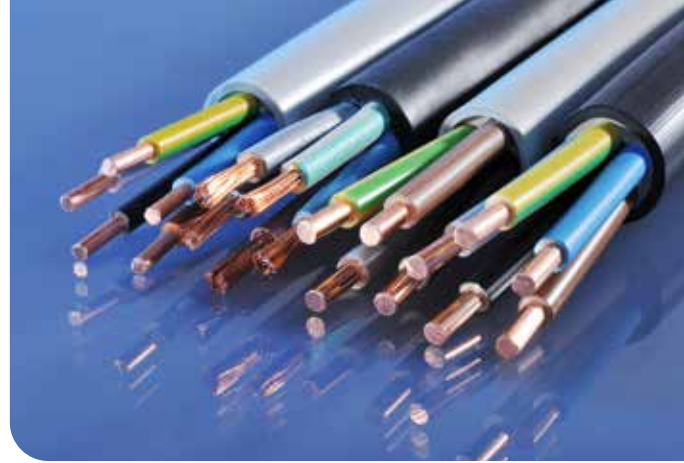
This product guide provides an overview of our main, commercially available crosslinking peroxides. We invite you to visit us at [www.nouryon.com](http://www.nouryon.com) for complete product listings.

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.

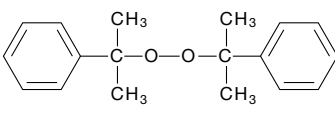
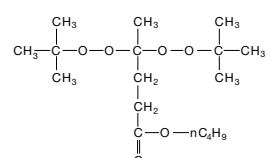
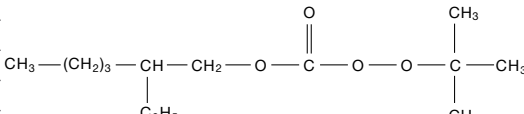
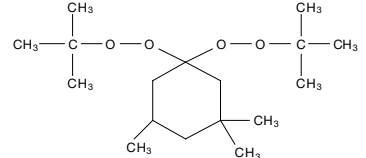
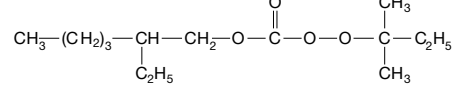
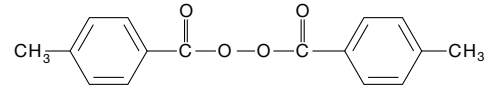
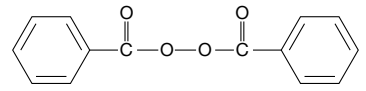
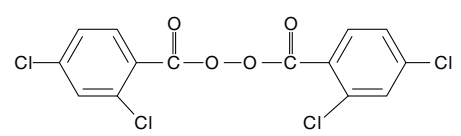


<sup>1</sup> Trigonox® B has a boiling point of 110°C and a flash point of 6°C. Therefore, this product is not recommended for standard rubber.

Product name	Chemical name [CAS no.]	Mol. weight	Assay (%)	Main carrier / solvent	Processing data	
					Safe processing temperature (°C)	Typical crosslink temperature (°C)
Trigonox 311	3,3,5,7,7-Pentamethyl-1,2,4-trioxepane [215877-64-8]	174.3	95		180	220
						
Trigonox 301	3,6,9-Triethyl-3,6,9-trimethyl-1,4,7-triperoxonane [24748-23-0]	264.3	41	iso-paraffins	145	185
						
Trigonox 145-E85	2,5-Dimethyl-2,5-di(tert-butylperoxy)hexyne-3 [1068-27-5]	286.4	85	mineral oil	145	185
						
Trigonox B <sup>1</sup>	Di-tert-butyl peroxide [110-05-4]	146.2	99		145	180
						
Trigonox 101	2,5-Dimethyl-2,5-di(tert-butylperoxy)hexane [78-63-7]	290.4	>92		135	175
Trigonox 101-50D-PD			50	silica		
Trigonox 101-45B-GR			45	calcium carbonate		
Trigonox 101-45D-PD			45	silica		
Trigonox 101-45S-PS			45	silicone oil		
						
Trigonox T	tert-Butyl cumyl peroxide [3457-61-2]	208.3	95		135	175
						
Perkadox 14S-(FL)	Di(tert-butylperoxyisopropyl)benzene [25155-25-3; 2212-81-9]	338.5	98		135	175
Perkadox 14-40B-PD/GR-S			40	calcium carbonate		
Perkadox 14-40K-PD-S			40	clay		
Perkadox 14-40MB-GR-S			40	EPR, calcium carbonate		
Perkadox 14-EP40			40	POE, calcium carbonate		
						



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

Product name	Chemical name [CAS no.]	Mol. weight	Assay (%)	Main carrier / solvent	Processing data	
					Safe processing temperature (°C)	Typical crosslink temperature (°C)
Perkadox BC-FF Perkadox BC-40B-PD/GR Perkadox BC-40K-PD Perkadox BC-40MB-GR Perkadox BC-40S-PS Perkadox BC-EP40	Dicumyl peroxide [80-43-3] 	270.4	99		130	170
Trigonox 17-40B-PD/GR Trigonox 17-40MB-GR	Butyl 4,4-di(tert-butylperoxy)valerate [995-33-5] 	334.5	40	calcium carbonate	125	160
Trigonox 117	tert-Butylperoxy 2-ethylhexyl carbonate [34443-12-4] 	246.3	>98		120	150
Trigonox 29-40B-PD/GR-E Trigonox 29-40MB-GR-E	1,1-Di(tert-butylperoxy)-3,3,5-trimethylcyclohexane [6731-36-8] 	302.5	40	calcium carbonate	115	145
Trigonox 131	tert-Amylperoxy 2-ethylhexyl carbonate [70833-40-8] 	260.4	>94		110	140
Perkadox PM-50S-PS	Di(4-methylbenzoyl) peroxide [895-85-2] 	270.3	50	silicone oil	85	110
Perkadox L-50S-PS	Dibenzoyl peroxide [94-36-0] 	242.2	50	silicone oil	85	105
Perkadox PD-50S-PS	Di(2,4-dichlorobenzoyl) peroxide [133-14-2] 	380.0	50	silicone oil	75	90



## 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 <sup>1</sup>	6.8 - 11.3	7.5 - 12.5	6.1 - 10.1	3.8 - 6.3	3.7 - 6.1
EPM <sup>1</sup> ; 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 <sup>1</sup>	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 <sup>2</sup>			1.0 - 2.0	0.4 - 0.8	0.4 - 0.8

<sup>1</sup> Addition of a coagent is recommended.

<sup>2</sup> 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 sales office.

## Americas

### US and other countries

Citadel Center  
131 S Dearborn St, Suite 1000  
Chicago, IL 60603-5566  
USA  
T +1 800 828 7929 (US only)  
E [polymer.amer@nouryon.com](mailto: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](mailto: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](mailto: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](mailto: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](mailto: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](mailto:communications.me@nouryon.com)

### Other countries

Zutphenseweg 10  
7418 AJ Deventer  
The Netherlands  
E [polymer.emeia@nouryon.com](mailto:polymer.emeia@nouryon.com)

### Asia Pacific

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