

# FORANE® 407A

Forane® 407A (R-407A) refrigerant is a non-ozone depleting blend of HFC refrigerants R-32, R-125, and R-134a. R-407A was developed as a retrofit refrigerant for some R-22 applications.

<b>Application</b>	R-407A is an R-22 retrofit for medium and low temperature refrigeration systems. It is not intended for air-conditioning applications, nor recommended for use in systems with flooded evaporators.
<b>Properties &amp; Performance</b>	<p>R-407A is designed to meet the needs of many new and existing refrigeration systems. R-407A is a zeotropic HFC refrigerant blend, which is rated A1 by ASHRAE (lowest levels of toxicity and flammability) having zero ozone depletion potential.</p> <p>R-407A is a close match to R-22's capacities and flow rates, making it well suited as a retrofit for R-22 in supermarket and food storage applications. Additionally, R-407A is one of the more energy efficient R-22 retrofit options available for refrigeration applications.</p> <p>Discharge temperatures of R-407A will be noticeably lower than those seen with R-22. System pressures for R-407A are higher than R-22, particularly in high ambient environments. Consult the system or component OEMs for recommendations on how best to accommodate the changes in operating pressures.</p>
<b>Lubrication</b>	As with many HFC blends, R-407A will require a change to polyester oil (POE) to ensure reliable oil return and circulation throughout the system. For systems currently using an oil separator, multiple oil flushes may not be required.
<b>Charging</b>	Due to the zeotropic nature of R-407A blend, it should be charged as a liquid to prevent fractionation (changes in the designed refrigerant composition*). For installations where vapor is normally fed into the low side of a running system, a flash valve should be installed in the charging line to prevent liquid from entering the compressor. When retrofitting from R-22 to R-407A, the new charge weight will typically be 95 – 100% of the original charge weight of R-22.
<b>Retrofit</b>	<p>In most cases, overall system capacities and efficiencies of a R-407A retrofit will be similar to those of R-22. Differences in actual performance will depend largely on system design, operating conditions, and ambient temperatures. Refrigerant flow rates for R-407A are slightly higher than R-22. Expansion valves that are operating properly with R-22 will typically not have to be replaced. Slight expansion valve adjustments may be required to optimize system performance.</p> <p>Operating pressures will be higher and may require changes to cut-out settings and pressure relief devices. Always consult the OEM for recommendations before performing any system retrofit.</p>

\* See Definitions – Fractionation

## RETROFITTING PROCEDURE

1. Establish baseline performance. Note the oil type in use and any system operating data (if system is operating properly). Check for existing leaks and identify any needed repairs.
2. Recover the existing refrigerant charge (DO NOT vent to atmosphere). Weigh the amount of refrigerant removed.
3. Perform any repairs identified in step 1 and fix any leaks.
4. Replace the filter-drier and, if necessary, elastomeric seals (O-rings, sight glasses, etc.). Verify the condition of the system oil; replace if necessary.
5. R-407A is immiscible with mineral oil and alkylbenzene and will require most of the original system oil to be replaced. Drain existing mineral oil or alkylbenzene from the compressor sump, suction line accumulators, etc. Record the amount of oil removed.
6. Add an equivalent amount of OEM recommended POE oil.
7. Evacuate the system (less than 500 microns) and ensure it maintains a vacuum. If vacuum is lost, it may indicate that leaks are present in the system.
8. Charge system with R-407A refrigerant. Remove refrigerant as liquid only from cylinder. The initial weight should be approximately 95% of the standard charge for R-22, charging up to 100% if necessary.
9. Adjust TXV set point and/or refrigerant charge to achieve the desired superheat. Low side pressure control settings may also need to be adjusted.
10. Monitor oil level in the compressor. If necessary, adjust oil amount to attain normal operating level (mid-sight glass).
11. Label system clearly, indicating the type and amounts of system refrigerant and oil.

PROPERTIES	R-407A
Average Molecular Weight (g/mol)	90.1
Normal Boiling Point (°F)	-49.0
Critical Temperature (°F)	180.1
ASHRAE Safety Group Classification	A1
Ozone Depletion Potential (ODP)	0
Global Warming Potential (GWP)	2,100

## DEFINITIONS

<b>Bubble Point (Saturated Liquid Temperature)</b>	The temperature (for a given pressure) at which the liquid of a refrigerant blend (any 400 or 500 series refrigerant) begins to evaporate or boil. This is similar to the saturated liquid temperature of a single component refrigerant.
<b>Dew Point (Saturated Vapor Temperature)</b>	The temperature (for a given pressure) at which the vapor of a given refrigerant blend (any 400 or 500 series refrigerant) begins to condense or liquefy. This is similar to the saturated vapor temperature of a single component refrigerant.
<b>Fractionation</b>	The change in composition of a refrigerant blend (any 400 or 500 series refrigerant) when it changes phase from liquid to vapor (evaporation) or from vapor to liquid (condensation). This behavior in blends explains the permanent changes to refrigerant composition from leaks, causing the blend to deviate outside the tolerances of the designed composition.
<b>Glide</b>	The difference in temperature between the evaporator outlet and inlet due to fractionation of the blend. Theoretically, this can be calculated by finding the difference between the dew and bubble temperatures at constant pressure. Actual measurements may differ slightly depending on the state of the liquid refrigerant at either end of the evaporator (or condenser). Pressure losses through the evaporator may also affect glide.
<b>Normal Boiling Point (NBP)</b>	The temperature at which a given refrigerant begins to boil while at atmospheric pressure (14.7 psia).
<b>Abbreviations</b>	AB – alkylbenzene GWP – global warming potential MO – mineral oil ODP – ozone depletion potential OEM – original equipment manufacturer POE – polyolester PAG – polyalkylene glycol

## OTHER TOPICS

### Refrigerant Lubricants

The phase-out of ozone depleting refrigerants has impacted air-conditioning and refrigeration equipment design in many ways. One of the most significant changes to these systems is the transition of the compressor lubricants. Use of an appropriate lubricant is important when servicing, installing, or retrofitting a system. The following information may be helpful as general background information on refrigerant lubricants; however, always follow OEM recommendations for proper lubricant selection.

**Mineral Oil:** Mineral oil has been the lubricant of choice for systems utilizing many of the CFC and HCFC refrigerants. Both the CFCs and HCFCs tend to have adequate miscibility with mineral oil, helping to ensure acceptable oil return under normal operating conditions. Sometimes a synthetic lubricant (i.e. AB or POE) is required under certain conditions, such as reduced miscibility with CFC retrofit blends or high discharge temperatures with products like R-22.

**Alkylbenzene:** Alkylbenzene is a synthetic refrigerant compressor lubricant used in new refrigeration systems and for retrofits from CFCs to HCFCs. Typically, Alkylbenzene has better miscibility with HCFCs than mineral oil, resulting in more reliable oil return. For retrofits of older CFC equipment, a partial oil change from mineral oil to alkylbenzene may be acceptable.

**Polyolester:** HFC refrigerants serve as the replacements for the ozone-depleting CFCs and HCFCs. However, both mineral oil and alkylbenzene have poor miscibility with HFCs, making oil return with these products unreliable in many systems. POEs are synthetic oils commonly used in new HFC systems and for retrofitting older CFC and HCFC equipment to HFC refrigerants. Special care must be taken when using POE oils due to their quick absorption of moisture when left exposed to the atmosphere (hygroscopic).

**Polyalkylene Glycol:** In addition to POE oils, polyalkylene glycol (PAG) lubricants are used with R-134a in automotive air-conditioning applications. Like POEs, PAGs are hygroscopic synthetic oils and must be treated with care to minimize exposure to moisture. While both POEs and PAGs are used with R-134a in automotive systems, the two oil types are not interchangeable and should not be mixed.

### Material Compatibility

Whenever retrofitting an air-conditioning or refrigeration system, compatibility of system materials is always a concern. Items such as elastomers, hoses, and filter-driers respond differently to different refrigerants and oils. For these reasons, before performing any refrigerant retrofit, Arkema recommends contacting the OEM for specific recommendations. Arkema's Technical Service hotline can also be reached at (800) 738-7695.

### Leak Detection

Leak checking should be a routine practice whenever performing maintenance on or servicing an air-conditioning or refrigeration system. As elastomers and other sealing components may react differently to new refrigerants and oils, leak checking should always be performed after any refrigerant retrofit.

Certain older style leak detectors have difficulty detecting newer refrigerants. It is important to verify whether or not your leak detector is rated for the type of refrigerant (CFC, HCFC, or HFC) you will be working with. Also, some refrigerant dyes are only compatible with specific refrigerant oils. Always check with the manufacturer before using a leak dye in an air-conditioning or refrigeration system.

Forane® Refrigerant Pressure Temperature Chart

PRESSURE (PSIG)																		
Sat. Temp (°F)	R-22	R-407C Liquid Pressure	R-407C Vapor Pressure	R-410A Liquid Pressure	R-427A Liquid Pressure	R-427A Vapor Pressure	R-407A Liquid Pressure	R-407A Vapor Pressure	R-123	R-12	R-134a	R-409A Liquid Pressure	R-409A Vapor Pressure	R-401A Liquid Pressure	R-401A Vapor Pressure	R-401B Liquid Pressure	R-401B Vapor Pressure	Sat. Temp (°C)
-50	<b>6.2</b>	<b>2.9</b>	<b>11.4</b>	5.3	<b>3.8</b>	<b>11.9</b>	<b>0.8</b>	<b>9.0</b>	<b>29.2</b>	<b>15.4</b>	<b>18.7</b>	<b>12.4</b>	<b>17.2</b>	<b>13.5</b>	<b>17.9</b>	<b>12.2</b>	<b>16.8</b>	-45.6
-45	<b>2.7</b>	0.4	<b>8.5</b>	8.0	<b>0.1</b>	<b>9.0</b>	1.7	<b>5.7</b>	<b>29.0</b>	<b>13.3</b>	<b>16.9</b>	<b>9.7</b>	<b>15.2</b>	<b>11.1</b>	<b>16.0</b>	<b>9.6</b>	<b>14.7</b>	-42.8
-40	0.5	2.5	<b>5.2</b>	11.0	1.9	<b>5.9</b>	3.9	<b>2.0</b>	<b>28.9</b>	<b>11.0</b>	<b>14.8</b>	<b>6.8</b>	<b>13.1</b>	<b>8.4</b>	<b>13.8</b>	<b>6.7</b>	<b>12.4</b>	-40.0
-35	2.6	4.8	<b>1.5</b>	14.2	4.1	<b>2.4</b>	6.4	1.0	<b>28.7</b>	<b>8.4</b>	<b>12.5</b>	<b>3.5</b>	<b>10.7</b>	<b>5.3</b>	<b>11.4</b>	<b>3.4</b>	<b>9.7</b>	-37.2
-30	4.9	7.3	1.3	17.8	6.6	0.8	9.2	3.3	<b>28.4</b>	<b>5.5</b>	<b>9.8</b>	0.0	<b>8.1</b>	<b>2.0</b>	<b>8.7</b>	0.1	<b>6.8</b>	-34.4
-25	7.4	10.1	3.6	21.8	9.3	2.9	12.2	5.8	<b>28.1</b>	<b>2.3</b>	<b>6.9</b>	2.0	<b>5.1</b>	0.8	<b>5.6</b>	2.0	<b>3.5</b>	-31.7
-20	10.1	13.1	6.1	26.1	12.2	5.3	15.6	8.5	<b>27.8</b>	0.6	<b>3.7</b>	4.1	<b>1.9</b>	2.9	<b>2.2</b>	4.1	0.1	-28.9
-15	13.2	16.5	8.8	30.8	15.4	7.9	19.2	11.5	<b>27.4</b>	2.4	<b>0.1</b>	6.5	0.8	5.1	0.7	6.5	2.0	-26.1
-10	16.5	20.1	11.9	35.9	18.9	10.8	23.2	14.9	<b>27.0</b>	4.5	1.9	9.0	2.8	7.5	2.8	9.1	4.2	-23.3
-5	20.0	24.0	15.2	41.5	22.8	14.0	27.5	18.5	<b>26.5</b>	6.7	4.1	11.8	4.9	10.1	5.0	11.9	6.6	-20.6
0	23.9	28.3	18.9	47.5	26.9	17.5	32.2	22.5	<b>25.9</b>	9.1	6.5	14.8	7.2	13.0	7.4	14.9	9.2	-17.8
5	28.2	33.0	22.9	54.1	31.4	21.2	37.3	26.9	<b>25.3</b>	11.8	9.1	18.1	9.7	16.1	10.1	18.2	12.1	-15.0
10	32.8	38.0	27.3	61.2	36.3	25.4	42.8	31.6	<b>24.6</b>	14.6	11.9	21.7	12.5	19.5	13.0	21.8	15.2	-12.2
15	37.7	43.5	32.0	68.8	41.5	29.9	48.7	36.7	<b>23.7</b>	17.7	15.0	25.5	15.4	23.1	16.2	25.7	18.6	-9.4
20	43.0	49.3	37.2	77.1	47.2	34.7	55.1	42.3	<b>22.8</b>	21.0	18.4	29.6	18.7	27.1	19.6	29.9	22.3	-6.7
25	48.7	55.7	42.7	86.0	53.3	40.0	62.0	48.3	<b>21.8</b>	24.6	22.1	34.0	22.2	31.4	23.4	34.4	26.3	-3.9
30	54.9	62.5	48.7	95.5	59.8	45.7	69.3	54.8	<b>20.7</b>	28.4	26.0	38.7	26.0	36.0	27.4	39.3	30.6	-1.1
35	61.5	69.8	55.2	105.7	66.8	51.9	77.2	61.8	<b>19.5</b>	32.5	30.3	43.8	30.1	40.9	31.8	44.5	35.2	1.7
40	68.5	77.6	62.1	116.6	74.3	58.7	85.6	69.4	<b>18.1</b>	36.9	35.0	49.2	34.5	46.2	36.5	50.1	40.2	4.4
45	76.0	86.0	69.5	128.3	82.3	65.6	94.6	77.4	<b>16.6</b>	41.6	40.0	54.9	39.2	51.8	41.6	56.0	45.6	7.2
50	84.0	94.9	77.5	140.8	90.8	73.3	104.2	86.1	<b>15.0</b>	46.7	45.4	61.0	44.3	57.9	47.0	62.4	51.4	10.0
55	92.5	104.5	86.0	154.1	99.9	81.5	114.4	95.3	<b>13.1</b>	52.0	51.1	67.6	49.8	64.3	52.8	69.2	57.5	12.8
60	101.6	114.6	95.1	168.2	109.6	90.3	125.2	105.2	<b>11.2</b>	57.7	57.3	74.5	55.6	71.2	59.0	76.5	64.1	15.6
65	111.2	125.4	104.8	183.2	119.9	99.6	136.7	115.7	<b>9.0</b>	63.7	63.9	81.8	61.9	78.5	65.7	84.2	71.2	18.3
70	121.4	136.9	115.2	199.2	130.8	109.6	148.8	127.0	<b>6.6</b>	70.2	71.0	89.5	68.6	86.3	72.8	92.3	78.7	21.1
75	143.6	149.1	126.2	216.1	142.4	120.3	161.7	138.9	<b>4.0</b>	76.9	78.6	97.7	75.8	94.5	80.3	101.0	86.7	23.9
80	143.6	162.1	137.8	234.0	154.6	131.6	175.3	151.6	<b>1.2</b>	84.1	86.6	106.4	83.4	103.2	88.4	110.2	95.2	26.7
85	155.7	175.8	150.2	253.0	167.6	143.7	189.7	165.1	0.9	91.7	95.1	115.5	91.5	112.4	96.9	119.8	104.2	29.4
90	168.4	190.2	163.4	273.0	181.2	156.4	204.8	179.3	2.5	99.7	104.2	125.2	100.2	122.2	106.0	130.1	113.8	32.2
95	181.8	205.5	177.4	294.1	195.6	170.0	220.8	194.4	4.2	108.2	113.8	135.3	109.4	132.5	115.6	140.9	123.9	35.0
100	195.9	221.6	192.1	316.4	210.8	184.4	237.6	210.4	6.1	117.1	124.1	146.0	119.2	143.3	125.7	152.3	134.7	37.8
105	210.7	238.5	207.8	339.9	226.8	199.6	255.3	227.4	8.1	126.5	134.9	157.2	129.6	154.8	136.5	164.3	146.0	40.6
110	226.3	256.4	224.4	364.6	243.6	215.7	273.9	245.2	10.3	136.4	146.3	169.0	140.6	166.8	147.8	176.9	158.0	43.3
115	242.7	275.1	241.9	390.5	261.2	232.7	293.5	264.1	12.6	146.7	158.4	181.4	152.3	179.4	159.8	190.1	170.6	46.1
120	259.9	294.7	260.5	417.7	279.7	250.6	314.0	284.0	15.1	157.6	171.1	194.4	164.7	192.7	172.4	204.0	183.9	48.9
125	277.9	315.2	280.1	446.3	299.1	269.5	335.4	305.0	17.7	169.0	184.5	208.0	177.8	206.6	185.7	218.6	197.9	51.7
130	296.8	336.7	300.9	476.3	319.4	289.5	357.9	327.1	20.6	180.9	198.7	222.3	191.6	221.2	199.7	233.9	212.6	54.4
135	316.5	359.2	322.9	507.6	340.7	310.5	381.5	350.5	23.6	193.5	213.6	237.2	206.3	236.5	214.5	250.0	228.1	57.2
140	337.2	382.6	346.2	540.5	362.9	332.6	406.2	375.1	26.8	206.5	229.3	252.9	221.8	252.5	229.9	266.7	244.3	60.0
145	358.8	407.0	370.8	574.8	386.1	355.9	431.9	401.0	30.2	220.2	245.7	269.3	238.2	269.3	246.2	284.3	261.4	62.8
150	381.5	432.4	396.9	610.6	410.3	380.4	458.9	428.3	33.8	234.5	263.0	286.4	255.5	286.8	263.2	302.6	279.3	65.6

Red Numerals (in bold and italics) - Inches Hg. Below 1 ATM

**PRESSURE (PSIG)**

Sat. Temp (°F)	R-502	R-408A Liquid Pressure	R-402A Liquid Pressure	R-402B Liquid Pressure	R-404A Liquid Pressure	R-507A	Sat. Temp (°C)
-50	<b><i>0.2</i></b>	<b><i>1.6</i></b>	2.5	1.1	0.6	1.1	-45.6
-45	1.9	1.1	4.9	3.2	2.7	3.3	-42.8
-40	4.1	3.3	7.4	5.6	5.0	5.7	-40.0
-35	6.5	5.6	10.3	8.2	7.6	8.3	-37.2
-30	9.2	8.2	13.4	11.1	10.4	11.2	-34.4
-25	12.1	11.0	16.7	14.2	13.4	14.3	-31.7
-20	15.3	14.1	20.4	17.6	16.8	17.8	-28.9
-15	18.8	17.5	24.5	21.4	20.5	21.6	-26.1
-10	22.6	21.2	28.8	25.4	24.5	25.7	-23.3
-5	26.7	25.2	33.6	29.8	28.8	30.1	-20.6
0	31.1	29.5	38.7	34.6	33.5	34.9	-17.8
5	35.9	34.2	44.2	39.8	38.6	40.2	-15.0
10	41.0	39.3	50.1	45.3	44.0	45.8	-12.2
15	46.5	44.8	56.5	51.3	49.9	51.8	-9.4
20	52.5	50.7	63.4	57.6	56.2	58.3	-6.7
25	58.8	57.0	70.7	64.5	63.0	65.3	-3.9
30	65.6	63.7	78.5	71.8	70.3	72.8	-1.1
35	72.8	71.0	86.9	79.6	78.1	80.8	1.7
40	80.5	78.7	95.8	88.0	86.4	89.3	4.4
45	88.7	87.0	105.3	96.9	95.2	98.4	7.2
50	97.4	95.8	115.4	106.3	104.7	108.1	10.0
55	106.6	105.1	126.1	116.3	114.7	118.5	12.8
60	116.4	115.1	137.4	127.0	125.3	129.4	15.6
65	126.7	125.6	149.4	138.2	136.6	141.1	18.3
70	137.6	136.8	162.1	150.1	148.6	153.4	21.1
75	149.1	148.7	175.5	162.7	161.2	166.4	23.9
80	161.2	161.2	189.7	176.0	174.6	180.2	26.7
85	174.0	174.4	204.6	189.9	188.8	194.8	29.4
90	187.4	188.4	220.2	204.7	203.7	210.1	32.2
95	201.4	203.1	236.8	220.2	219.4	226.3	35.0
100	216.2	218.7	254.2	236.5	235.9	243.4	37.8
105	231.7	235.4	272.4	253.6	253.4	261.3	40.6
110	247.9	252.1	291.6	271.6	271.7	280.2	43.3
115	264.9	270.2	311.7	290.5	290.9	300.0	46.1
120	282.7	289.1	332.8	310.3	311.1	320.8	48.9
125	301.4	308.9	354.9	331.0	332.3	342.6	51.7
130	320.8	329.7	378.1	352.7	354.5	365.5	54.4
135	341.2	351.5	402.4	375.4	377.8	389.4	57.2
140	362.6	374.3	427.8	399.2	402.2	414.5	60.0
145	385.0	398.1	454.4	424.0	427.7	440.7	62.8
150	408.4	423.0	482.3	450.0	454.4	468.1	65.6

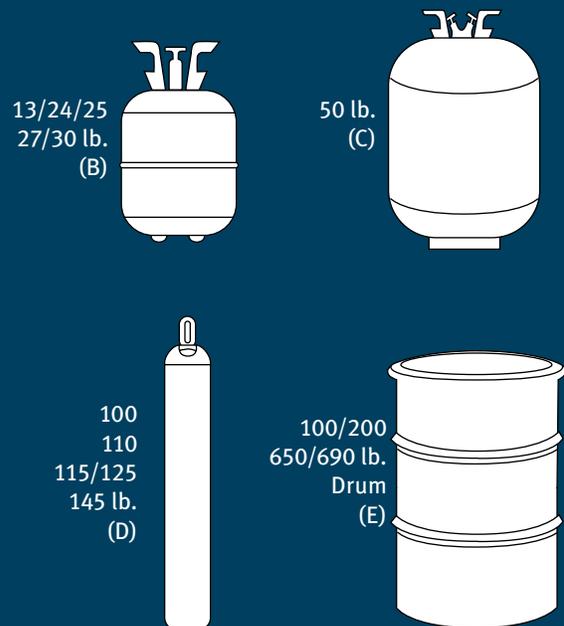
Red Numerals (in bold and italics) - Inches Hg. Below 1 ATM

Forane® Refrigerant Cylinder Identification

Type	Color Code	Sizes (Net lbs.)	
R-12	CFC	White	30 (B), 50 (C), 145 (D), 2000
R-502	CFC	Lavender	30 (B), 125 (D)
R-22	HCFC	Light Green	30 (B), 50 (C), 125 (D), 1000, 1750
R-123	HCFC	Light Blue Grey	100 (E), 200 (E)
R-401A	HCFC	Pinkish Red	30 (B), 125 (D)
R-401B	HCFC	Mustard	30 (B), 125 (D)
R-402A	HCFC	Sand	27 (B), 110 (D)
R-402B	HCFC	Olive	13 (B)
R-408A	HCFC	Medium Purple	24 (B), 100 (D), 1300
R-409A	HCFC	Tan	30 (B), 125 (D), 1800
R-134a	HFC	Light Blue	30 (B), 125 (D), 1000, 1750
R-404A	HFC	Orange	24 (B), 100 (D), 1300 tons
R-407A	HFC	Lime Green	25 (B), 115 (D)
R-407C	HFC	Brown	25 (B), 115 (D), 1000, 1600
R-427A	HFC	Green	25 (B) 110 (D)
R-410A	HFC	Rose	25 (B), 100 (D), 850, 1350
R-507A	HFC	Teal	25 (B), 100 (D), 800, 1400

Container Types

Size not to scale



## Forane® Refrigerant Basic Property Data Chart

Properties	R-410A	R-427A	R-407A	R-407C	R-134a	R-404A	R-507A	R-22	R-408A	R-409A	R-123
Average Molecular Weight (g/mol)	72.6	90.4	90.1	86.2	102.0	97.6	98.8	86.5	87.0	97.4	152.9
Normal Boiling Point (NBP) (°F)	-61.9	-44.8	-49.0	-46.1	-14.9	-51.5	-52.8	-41.3	-47.9	-30.1	82.1
Latent Heat of Vaporization at NBP (BTU/lb)	116.7	102.0	101.3	107.4	92.8	86.0	84.3	100.5	97.6	94.6	73.7
Critical Temp (°F)	162.0	185.6	180.1	187.2	214.1	161.6	159.8	204.8	182.6	224.2	362.7
Critical Pressure (psia)	717.9	637.1	654.9	670.1	590.3	539.5	539.5	722.3	629.5	667.2	532.9
Density of Saturated Vapor @ NBP (lb/ft³)	0.26	0.30	0.30	0.29	0.33	0.34	0.34	0.29	0.30	0.31	0.40
Density of Saturated Liquid at 77°F (lb/ft³)	66.3	71.9	71.5	71.1	75.3	65.2	65.0	74.5	66.3	75.9	91.3
Specific Heat of Saturated Vapor at NBP (BTU/lb °R)	0.17	0.18	0.18	0.17	0.19	0.18	0.18	0.14	0.16	0.15	0.16
Specific Heat of Saturated Liquid at 77°F (BTU/lb °R)	0.44	0.38	0.36	0.38	0.34	0.39	0.39	0.30	0.37	0.30	0.23
Ozone Depletion Potential (ODP) (CFC-11 = 1.0)	0	0	0	0	0	0	0	0.055	0.026	0.05	0.02
ASHRAE Safety Group Classification	A1	A1	A1	A1	B1						
Occupational Exposure Limits (8 hr time/wt. Avg.) (ppm)	1,000	1,000	1,000	1,000	1,000	1,000	1,000	1,000	1,000	1,000	50
Global Warming Potential (GWP)	2,100	2,130	2,100	1,800	1,430	3,900	4,000	1,810	2,650	1,290	77

The information contained in this document is based on trials carried out by Arkema Research Centers and data selected from literature, but shall in no event be held to constitute or imply any warranty, undertaking, express or implied commitment from our part. Our formal specifications define the limit of our commitment. No liability whatsoever can be accepted by Arkema with regard to the handling, processing or use of the product or products concerned which must in all cases be employed in accordance with all relevant laws and/or regulations in force in the country or countries concerned.

The statements, technical information and recommendations contained herein are believed to be accurate as of the date hereof. Since the conditions and methods of use of the product and of the information referred to herein are beyond our control, Arkema expressly disclaims any and all liability as to any results obtained or arising from any use of the product or reliance on such information; NO WARRANTY OF FITNESS FOR ANY PARTICULAR PURPOSE, WARRANTY OF MERCHANTABILITY OR ANY OTHER WARRANTY, EXPRESS OR IMPLIED, IS MADE CONCERNING THE GOODS DESCRIBED OR THE INFORMATION PROVIDED HEREIN. The information provided herein relates only to the specific product designated and may not be applicable when such product is used in combination with other materials or in any process. The user should thoroughly test any application before commercialization. Nothing contained herein constitutes a license to practice under any patent and it should not be construed as an inducement to infringe any patent and the user is advised to take appropriate steps to be sure that any proposed use of the product will not result in patent infringement.

See MSDS for Health & Safety Considerations  
 Forane® is a registered trademark belonging to Arkema  
 © 2009 Arkema Inc. All rights reserved.



Arkema Inc.  
 2000 Market Street  
 Philadelphia, PA 19103-3222  
 Tel.: 215-419-7000  
 www.arkema-inc.com