

3M™ Dyneon™ PTFE TF 1620

Polytetrafluoroethylene

3M Advanced Materials Division

Message:

Semi free-flowing PTFE for moulding with reduced pressure

Features

Meets ASTM D 4894 Type IV, Grade 2 classification

Moulding powder with semi-free-flowing properties

Reduced moulding pressure of 20 MPa

Good surface quality of isostatically moulded articles

Typical applications

Large compression moulded sheets

Isostatically moulded articles

Shaped parts

Skived films of >200 µm

Thinner wall articles like bellows etc.

General Information			
Features	Good Surface Finish		
Uses	Film		
	Sheet		
Forms	Granules		
	Powder		
Processing Method	Compression Molding		
	Sintering		
Physical	Nominal Value	Unit	Test Method
Density	2.15	g/cm ³	ISO 12086
Apparent Density	0.87	g/cm ³	ISO 60
Molding Shrinkage	2.9	%	Internal Method
Average Particle Size	220	µm	ISO 13320
Hardness	Nominal Value	Unit	Test Method
Shore Hardness (Shore D)	56		ISO 868
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	600	MPa	DIN 53457
Deformation Under Load			ASTM D621
15 MPa ¹	10.0	%	
15 MPa ²	17.0	%	
15 MPa ³	16.0	%	
Films	Nominal Value	Unit	Test Method
Tensile Strength (200 µm)	38.0	MPa	ISO 527-3
Tensile Elongation (Break, 200 µm)	400	%	ISO 527-3

Thermal	Nominal Value	Unit	Test Method
CLTE - Flow			DIN 53752
30 to 100°C	1.2E-4	cm/cm/°C	
30 to 200°C	1.7E-4	cm/cm/°C	
30 to 260°C	1.4E-4	cm/cm/°C	
Thermal Conductivity	0.22	W/m/K	DIN 52612
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+17	ohms	IEC 60093
Volume Resistivity	1.0E+18	ohms·cm	IEC 60093
Electric Strength (0.200 mm)	74	kV/mm	ISO 12086
Flammability	Nominal Value	Unit	Test Method
Flame Rating	V-0		UL 94
NOTE			
1.	permanent		
2.	100 hr		
3.	24 hr		

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