

3M™ Dyneon™ PTFE TF 1645

Polytetrafluoroethylene

3M Advanced Materials Division

Message:

- Free-flowing PTFE for general moulding and ram extrusion
- Features
 - Meets ASTM D 4894 Type IV, Grade 2 classification
 - Moulding powder with very good free-flowing properties
 - Good mould filling behaviour
- Universal standard PTFE grade for general compression moulding and esp. for automatic moulding
- Good mechanical properties
- Low shrinkage
- Typical applications
 - Shaped parts
 - Automatically and isostatically moulded articles
 - Moulded cylinders
 - Semi-finished articles

General Information			
Features	Good Flow		
	Low Shrinkage		
Forms	Granules		
	Powder		
Processing Method	Compression Molding		
	Ram Extrusion		
	Sintering		
Physical	Nominal Value	Unit	Test Method
Density	2.15	g/cm ³	ISO 12086
Apparent Density	0.84	g/cm ³	ISO 60
Molding Shrinkage	2.5	%	Internal Method
Average Particle Size	450	µm	ISO 13320
Hardness	Nominal Value	Unit	Test Method
Shore Hardness (Shore D)	56		ISO 868
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	600	MPa	ISO 527-2
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)	37.0	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	1.4E-4	cm/cm/°C	
30 to 260°C	1.7E-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)	55	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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