

# 3M™ Dyneon™ PTFE TF 1641

Polytetrafluoroethylene

3M Advanced Materials Division

## Message:

- Free-flowing PTFE for general moulding
- Features
  - Meets ASTM D 4894 Type IV, Grade 2 classification
  - Moulding powder with very good free-flowing properties
  - Good mould filling behaviour
  - Good mechanical properties
  - Very good surface quality of isostatically moulded articles
- Typical applications
  - Shaped parts
  - Isostatically moulded articles
  - Sealings, small parts

General Information			
Features	Good Flow		
	Good Surface Finish		
Uses	Seals		
Forms	Granules		
	Powder		
Processing Method	Compression Molding		
	Sintering		
Physical	Nominal Value	Unit	Test Method
Density	2.15	g/cm <sup>3</sup>	ISO 12086
Apparent Density	0.84	g/cm <sup>3</sup>	ISO 60
Molding Shrinkage	2.7	%	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 <sup>1</sup> (15 MPa)	17.0	%	ASTM D621
Films	Nominal Value	Unit	Test Method
Tensile Strength (200 µm)	36.0	MPa	ISO 527-3
Tensile Elongation (Break, 200 µm)	430	%	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)	60	kV/mm	ISO 12086
Flammability	Nominal Value	Unit	Test Method
Flame Rating	V-0		UL 94
NOTE			
1.	24 hr		

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