Hyflon® MFA® F1540

Perfluoropolymer

Solvay Specialty Polymers

Message:

Hyflon® MFA® is a unique family of perfluoro polymers which combine excellent mechanical characteristics to unique properties such as chemical inertness, high flexural endurance, inherent flame resistance, low surface energy and exceptional dielectric properties.

Hyflon® MFA® F1540 is a medium-high melt flow rate multi purpose resin with an exceptional stress crack resistance, continuous service temperature up to 225°C and a 13-15 x 10³ cycles flex-life (on a 0.3 mm film, ASTM D2176).

UL VellowCard E109081-100037832 Features High ESCR (Stress Cracking Resistance) High liquidity Fame retardancy Uses Wire and cable applications General General ROHS Compliance RoHS compliance Forms Particle Processing Method Extrusion coating Physical Nominal Value Unit Particle 10-2.15 g/cm³ Physical Nominal Value Unit Meth Mass-Flow Rate (MFR) (372°C/s Log) 8.0 - 18 g/10 min Methodus ¹ (23°C) 8.0 - 18 g/10 min ASTM D792 Methodus ¹ (23°C) 9.5 - 60 Kest Method 10-240 Durometer Hardness Nominal Value Unit Test Method Durometer Hardness (Shore D) 55 - 60 XESTM D2320 ASTM D2307 Tensile Modulus ¹ (23°C) 400 - 500 MPa ASTM D3307 Tensile Strength ² (Break, 23°C) > 25.0 Ma ASTM D3307 Tensile Elongation ³ (Break, 23°C) > 300 % ASTM D3307 Heat of rystalization 160 - 24.0 /	General Information			
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	Peak Crystallization Temperature (DSC)	255 - 265	°C	DSC

CLTE - Flow	1.2E-4 - 2.0E-4	cm/cm/°C	ASTM D696
Specific Heat (23°C)	900 - 1100	J/kg/°C	DSC
Thermal Conductivity (40°C)	0.20	W/m/K	ASTM C177
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+17	ohms	ASTM D257
Volume Resistivity	> 1.0E+17	ohms•cm	ASTM D257
Dielectric Strength ⁵ (1.00 mm)	35 - 40	kV/mm	ASTM D149
Dielectric Constant			ASTM D150
23°C, 50 Hz	2.00		ASTM D150
23°C, 100 kHz	2.00		ASTM D150
Dissipation Factor			ASTM D150
23°C, 50 Hz	< 5.0E-4		ASTM D150
23°C, 100 kHz	< 5.0E-4		ASTM D150
Flammability	Nominal Value	Unit	Test Method
Flame Rating	V-0		UL 94
Oxygen Index	95	%	ASTM D2863

COLOR MASTER BATCHES

We recommend that only Color Master Batches based in MFA® be used. Master Batches based on other fluoropolymers can negatively influence the superior processing and electrical performance of the resin. A list of suppliers can be obtained from your Solvay sales representative. HEALTH SAFETY AND ENVIRONMENT

Hyflon ® MFA® F1540 is a very inert polymer and it is not harmful if used and handled according to standard processing procedures. If handled inappropriately, it may release harmful toxic chemicals.

Hyflon® MFA® F1540 does not contain any RoHS or WEEE substances, it is not produced using APFO and contains no APFO. Please refer to the Material Safety Data Sheets for more information on handling and safety.

PACKAGING AND STORAGE

The Hyflon® MFA® F1540 resin is available in 25 kg (55 lbs) and 500 kg (1102 lbs) packaging. Though it has an indefinite shelf life, it is recommended to store it in a clean area, protected by direct sun light and possible contamination.

Extrusion	Nominal Value	Unit	
Cylinder Zone 1 Temp.	240 - 290	°C	
Cylinder Zone 2 Temp.	270 - 320	°C	
Cylinder Zone 3 Temp.	300 - 360	°C	
Cylinder Zone 4 Temp.	330 - 380	°C	
Cylinder Zone 5 Temp.	340 - 390	°C	
Adapter Temperature	370 - 400	°C	
Melt Temperature	390 - 420	°C	
Die Temperature	390 - 420	°C	
Extrusion instructions			

WIRE AND CABLE PROCESSING GUIDELINES

As with other fluoropolymers, MFA is corrosive in the melt. Therefore all parts coming into prolonged contact with the melt should be made with corrosion resistant materials such as Hastelloy[®], Inconel[®], Monel[®] or Xaloy[®]. Chrome or nickel plating is not recommended since they are typically only sufficient for brief processing tests.

Hyflon MFA F1540 is applied onto wire using tubing extrusion techniques similar to other thermoplastic materials. An overview of the temperature, tooling and equipment requirements are in the following tables.

Many different screw designs can be used. Single-flight screws are recommended while barrier-flights should be avoided. A typical screw design consist of a long feed section, followed by a 2 to 6 flight transition and a 5 to 7 flight metering section. The addition of a block mixing section can improve the processing performance.

EQUIPMENT/TOOLING REQUIREMENTS Line Speed: 200 to 350 m/min (700 to 1200 ft/min) Draw Down Ratio: 80 to 120 Draw Balance: 0.96 to 1.04 Extruder L/D: 20/1 to 30/1 Screen Pack: Breaker plate only is required.

NOTE	
1.	1.0 mm/min
2.	50 mm/min
3.	50 mm/min
4.	0.3mm film
5.	50Hz

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