

TECHNICAL DATA

PFA PF-410

PF-410 is a copolymer resin. It has excellent heat resistance, chemical resistance, weather resistance, as well as excellent light transmittance, mechanical strength at high temperatures, and easy melt processing properties.

Applications such as connectors, nuts, filter covers, films, and wafer carriers (6 to 12 inches).

Property	Unit	Typical Value	Test Method
General			
Appearance	-	Translucent Granules	ASTMD 3307
MFR	g / 10min	10.0 - 20.0	
Density	g / cm ³	2.12-2.17	
Bulk density	g / mL	1.10-1.40	
Mechanical			
Tensile Strength	MPa	≥22.6	ASTM D638
Ultimate Elongation	%	≥290	ASTM D638
Flexural Modulus	MPa	No Break	ASTM D790
Impact Strength (Cantilever Type) Load Deformation	N/m	No Break	ASTM D256
Creep 25°C 13.7mpa	%	2.5-3.0	
Total Deformation 25°C 13.7mpa	%	8.0-9.0	-
Friction Coefficient (Static Friction Coefficient)	Coated Steel Surfaces	0.04-0.05	
Hardness	Shore Hardness	D60-D70	ASTM D895
Thermal Performance			
Melting Point	°C	295-311	DSC
Specific Heat	J/g/°C	1.05	-
Coefficient Of Heat Conduction	J · cm / s · cm ² · °C	2.6×10 ⁻³	ASTM C177
Coefficient Of Linear Expansion	1/°C	12×10 ⁻⁵ (+20-+100°C)	ASTM D696
Limit Oxygen Index Oli	vol%	>0.95	ASTM D2863
Continuous Use Temperature	°C	<260	
Electrical			
Dielectric Constant	-	2.1	ASTM D150
Dielectric Dissipation Factor	-	<1×10 ⁻⁵	D15010 ³ Hz
	-	3×10 ⁻⁴	D150106Hz
Fluorine	cm ³ ·cm/cm ² ·S atm	1.4×10 ⁻⁸	-
Oxygen	cm ³ ·cm/cm ² ·S atm	4.8×10 ⁻⁸	-
Density	g/m ² 24hrs	3.1(Thickness Of Film :45μm)	-
Other			
Contact Angle	Angle	115	-
Water Absorption	%	<0.01	-

Processing: Extrusion, injection molding, blow molding, transfer molding, and other methods.

Injection: Injection molding can be used for various semiconductor and industrial devices. Screw-type injection molding machines are typically used. To reduce molding deformation, slightly larger and shorter nozzles, runners, and gates should be selected when designing the mold. The mold should be made of corrosion-resistant mold steel and heated to 120-200°C.

Index	Small Basket	Sheet (Thickness 2mm)
Zone 5 (°C)	330	330
Zone 4 (°C)	365	360
Zone 3 (°C)	385	370
Zone 2 (°C)	380	375
Zone 1 (°C)	390	400
Mold temperature (°C)	190	180
screw speed	180	180
Injection Pressure (Mpa)	80	39.4 - 68.6
Maintain pressure (MPa)	60	44.1
Hold time (s)	18	20
Cooling time (s)	60	60
Forming cycle time (s/cycle)	100	120

Packaging and transportation: PVC bag weighs 25kg net. Transported as non-hazardous goods.

Storage And Handling

1. Process only in well-ventilated areas;
2. Do not smoke in areas contaminated with powder/residues from these products;
3. Avoid contact with eyes;
4. After handling these products, wash exposed skin with soap and water.
5. Avoid contact with hot fluoropolymers.
6. Steam extraction equipment should be installed above the processing equipment.
7. Do not use open flames or burn any of this product in a furnace when cleaning processing equipment.
8. Since this product is intended for general industrial use, its suitability and safety for use as a raw material for medical purposes cannot be guaranteed.

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