

TECHNICAL DATA**PF-415**

Product: PFA Resin PF-415 is a general-purpose fluoroplastic resin available in pellet form. It is used when traditional extrusion and molding processes are required for producing products with the superior properties of a fluoroplastic resin.

Applications: Extruded tubing and other profiles for hose, wire and cable insulation, and sleeving; industrial film;

Packing: It is packaged in 25-kg multilayer bags with an integral polyethylene liner.

TYPICAL PROPERTIES OF Fusible PF-415 (Data not for specification purposes)

Properties	Test Method	Unit	PF-415
Appearance		No impurities	Translucent particles or white powder
MFR, g/10min	ASTM D3307		6.1-15
Tensile Strength	ASTM D3307	MPa $\geq$	28
Elongation at Break	ASTM D3307	% $\geq$	300
Water Content	ASTM D570	% $\leq$	0.3
Melting Peak Temperature	ASTM D4591	°C	300-310
Standard Specific Gravity	ASTM D792		2.120~2.170

CERTIFICATION

- ROHS Certification
- REACH Certification
- SVHC Certification
- PFOA Free, PFAS Free

PROCESSING

PF-415 can be processed by conventional melt extrusion, and by injection, compression, and transfer molding processes. High melt strength and heat stability permit the use of relatively large die openings and high temperature draw-down techniques that increase production rates. Reciprocating screw injection molding machines are preferred. Corrosion-resistant metals should be used in contact with molten fluoroplastic resin. Extruder barrel should be long, relative to diameter, to provide residence time for heating the resin to approximately 390 °C (730 °F)

STORAGE AND HANDLING

PF-415 resin are not affected by storage time. Ambient storage conditions should be designed to avoid airborne contamination and water condensation on the resin when it is removed from containers.

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