

# PTFE FLUOROPLAST-4 grade RX015



**Manufacturer:**  
"HaloPolymer Kirovo-Chepetsk", LLC  
QMS for production is certified:  
ISO 9001:2015, AS/EN/JISQ 9100, IATF 16949

**Chemical name:** Poly(tetrafluoroethylene) (IUPAC)  
**Structural formula:**  $(C_2F_4)_n$   
**CAS No.** 9002-84-0  
**HS code** 39 0461 0000

Fluoroplast-4 grade RX015 is the perfluorinated resin with an average particle size of up to 24  $\mu\text{m}$ . It has excellent chemical stability, electrical and mechanical properties. Material is a granular powder virgin fine cut product designed for usage in small to medium-sized billet compression molding, well suited for thin skived film applications requiring excellent physical and electrical properties. Fluoroplast-4 grade RX015 can be classified as type II, ASTM D 4894 standart. Typical properties are not suitable for specification purposes. For the detailed specification please contact the commercial department.



PROPERTIES	UNITS	TYPICAL VALUE	TEST METHOD
Appearance		White, easily lumping powder, without visible inclusions	Visual (internal method <sup>1</sup> )
Particle size: average diameter (d <sub>50</sub> ) maximum particle size (d <sub>99</sub> ), max	$\mu\text{m}$	14-24 140	Laser-diffraction analysis <sup>1</sup> (dry dispersion method)
Quantity of particles of not more than 100 $\mu\text{m}$ in size (Q <sub>100</sub> ), min	%	95	Laser-diffraction analysis <sup>1</sup> (dry dispersion method)
Water content, max	% wt	0,02	Gravimetry <sup>1</sup>
Bulk density	g/l	240-400	Gravimetry <sup>1</sup>
Density (SSG)	g/sm <sup>3</sup>	2,14-2,18	ASTM D4894
Tensile strength at break, min	MPa	32	ASTM D4894
Elongation at break, min	%	330	ASTM D4894
Dielectric strength (0.100+0.005 mm thickness) at constant voltage, min	kV/mm	100	ASTM D149
Melting point (initial / second), $\pm 5$	$^{\circ}\text{C}$	344 / 327	ASTM D4894

Note:

<sup>1</sup> The parameters are indicated according to the Technical Specifications (TU), because the manufactured products are analyzed in accordance with the TU (internal company standard). The procedure of sample preparation differs from that in ASTM, ISO, DIN.



## Main applications:

- well suitable for thin skived films.
- production of articles (rods, pipes, bushings) by molding.
- compression (direct) molding and isostatic pressing.
- suitable for compound material with additives.



## Package:

20 kg (net) card boxes with 2x10 kg PE bags on wooden pallet boards.  
PE vats with 10 or 15 kg (net) PE bags on wooden pallet boards.



## Guarantee storage life:

24 months from the date of manufacture.

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## Processing:

PTFE is usually processed in two steps: preforming and sintering. The powder is first compacted into a preformed shape approximating that of the desired molding.

**SINTERING** The preformed PTFE powder is sintered under a temperature program generally containing 7 temperature steps including:

1. heating,
2. dwell before melting,
3. complete melting of a billet,
4. dwell above melting point,
5. cooling to crystallization point,
6. crystallization of the melt of PTFE,
7. final cooling.

Annealing steps are also required for bigger billets sintering in order to reduce article distortion



## Storage and handling:

Storage and handling preforming is the easiest when the resin is uniformly between 21–27°C (70–80°F). As the temperature declines below this range, the resin will be increasingly difficult to mold without cracks and problems with condensed moisture. Higher temperatures inhibit flow and promote lumping. Storage conditions should be set accordingly.

F-4 RX015 tends to form agglomerates easily; therefore, do not store large quantities of powder in deep containers; avoid strong vibrations. Storage at the temperatures above 19°C tends to promote agglomerate formation. Should agglomerates form, keep the powder at less than 19°C (ideally 15°C or below) for two days then sift through a coarse screen and allow to come to room temperature before molding.



## Quality data:

Fluoroplast-4 RX015 can be classified as type II, ASTM D 4894 standard. Typical properties are not suitable for specification purposes. For the detailed specification please contact the commercial department.

**HaloPolymer does not use PFOA/APFO or its salts/LCPFAC in the process of polymerization of TFE.**

HaloPolymer PTFE is compliant with RoHS Directive 2011/65/EU

FDA 21 CFR 177.1380 & FDA 21 CFR 177.1550

Class VI acc. USP 35 <88>

3-A Sanitary Standard for Multiple-Use Plastic Materials 20-27



## Safety Precautions:

**WARNING! VAPORS CAN BE LIBERATED THAT MAYBE HAZARDOUS IF INHALED.**

Before using Halopolymer Fluoroplast-4 (PTFE) read the Material Safety Data Sheet.

Open and use containers only in well-ventilated areas using local exhaust ventilation. Vapors and fumes liberated during hot processing or from smoking tobacco or cigarettes contaminated with Halopolymer Fluoroplast may cause flu-like symptoms (chills, fever, sore throat) that may not occur until several hours after exposure and that typically pass within 24 hours. Vapors and fumes liberated during hot processing should be exhausted completely from the work area; contamination of tobacco with polymers should be avoided. Mixtures with some finely divided metals, such as magnesium or aluminum, can be flammable or explosive under some conditions.