

PTFE

FLUOROPLAST-4

grade FCM-20, FCM-25



Manufacturer:
"HaloPolymer Kirovo-Chepetsk", LLC

QMS for production is certified:
ISO 9001:2015, EN 9100:2016, IATF 16949:2016

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

Fluoroplast-4 grade FCM-20 and FCM-25 are fully fluorinated resins which have excellent chemical stability, electrical and mechanical properties. Material is a granular powder product designed for use from small to medium billet compression molding, well suited to thin skived film applications requiring excellent physical and electrical properties.



PROPERTIES	UNITS	TYPICAL VALUE		TEST METHOD
		FCM-20	FCM-25	
Appearance		White, easily lumping powder, without visible inclusions		Visual (internal method ¹)
Particle size, average diameter (d ₅₀)	µm	10-25	20-30	Laser-diffraction analyses (internal method ¹)
Water content, max	% wt	0,02	0,02	internal method ¹
Bulk density	g/l	440-520	410-490	internal method ¹
Density (SSG)	g/sm ³	2,15-2,19	2,15-2,19	internal method ¹
Tensile strength at break, min	MPa	30	30	internal method ¹
Elongation at break, min	%	440	440	internal method ¹
Extrusion pressure at RR 400 : 1	MPa	100	100	internal method ¹
Melting point	°C	327±5	327±5	ASTM D4894

Note:

¹) 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 application:

- production of articles (rods, pipes, bushings) by molding, including large billets;
- production of small articles by automatic pressing (molding);
- compression (direct) molding and isostatic pressing.



Package:

Plastic drums with 1×25 kg polyethylene inserts 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.

Cleanliness is a critical requirement for successful usage of PTFE. The white resin and high sintering temperatures cause even very small foreign particles to become visible in finished moldings. Keep resin boxes closed and clean. Good housekeeping and careful handling are essential.



Quality data:

Fluoroplast-4 grade FCM-20 and FCM-25 can be classified as type III, 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.