



Technical Information



Dyneon™

TF 6404

PTFE Compound

Features

- Dyneon™ PTFE Compound with 40 % non-oxidizing bronze
- Free flow compound

Typical properties

Property	Test Method	Unit	Value
Bulk density	ASTM D 4894-07	g/l	1050
Shrinkage	ASTM D 4894-07	%	1.8
Specific gravity	ASTM D 4745-06	g/cm ³	3.01

Mechanical properties, on sintered moldings

Tensile strength	ASTM D 4745-06	MPa	25.0
Elongation at break	ASTM D 4745-06	%	330
Hardness	DIN 53505	Shore 'D'	68

Recommended processing procedures

If transport or storage temperatures are too high the material can agglomerate in its container. In such cases, it is advisable to store the material for 48 hours at below 23 °C and then to sieve it (mesh size 4 mm) before filling the mold. To achieve optimum properties, compression molding should be carried out within a temperature range of 23 °C to 26 °C and a humidity range of 45 % to 55 % and a pressure of 55 MPa. The maximum sintering temperature should be 365 °C.

Supply form

Dyneon™ TF 6404 PTFE compound is supplied in moisture and dust tight plastic boxes.

Capacity per box: 25 kg
Order quantity per pallet: 300 kg



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Storage and Material Handling

Dyneon™ TF 6404 can be stored for a relatively long period of time. It should preferably be stored in a clean, dry place at a temperature of less than 30 °C. Before processing it is advisable to store the material in the sealed boxes for 24 hours in the production area. This is particularly important when ambient temperature is low; in such cases the material should be conditioned for up to 72 hours in the production area in the temperature range as recommended.

Safety/Toxicology

This is a PTFE material, so normal precautions observed with PTFE should be followed. Before processing this product, consult the Material Safety Data Sheet and follow all label directions and handling precautions. General handling/processing precautions include: (1) Process only in well-ventilated areas; (2) Do not smoke in areas contaminated with powder/residue from these products; (3) Avoid eye contact; (4) After handling these products wash any contacted skin with soap and water. (5) Avoid contact with hot fluoropolymer. Potential hazards, including evolution of toxic vapors, can exist if processing occurs under excessively high temperature conditions. Vapor extractor units should be installed above processing equipment. When cleaning processing equipment, do not burn off any of this product with an open flame or in a furnace.

Management systems

Indicative of our commitment, most Dyneon design, development, production and service facilities have achieved global quality management certification. Production facilities have also received certification for their environmental management system. Please see the Dyneon website (www.dyneon.com) for the most up-to-date certification details.

Important Notice

All information set forth herein is based on our present state of knowledge and is intended to provide general notes regarding products and their uses. It should not therefore be construed as a guarantee of specific properties of the products described or their suitability for a particular application. Because conditions of product use are outside Dyneon's control and vary widely, user must evaluate and determine whether a Dyneon product will be suitable for user's intended application before using it. The quality of our products is warranted under our General Terms and Conditions of Sale as now are or hereafter may be in force.

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General recommendations on health and safety in processing, on work hygiene and on measures to be taken in the event of accident are detailed in our material safety data sheets.

You will find further notes on the safe handling of fluoropolymers in the brochure "Guide for the safe handling of Fluoropolymers Resins" by PlasticsEurope, Box 3, B-11160 Brussels, Tel. +32 (2) 676 17 32.

The present edition replaces all previous versions. Please make sure and inquire if in doubt whether you have the latest edition.

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Web Site: www.dyneon.com
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Printed in Germany
Issue: May 2010
98-0504-1976-5