



# Teflon™ PFA 345

## Molding and Extrusion

## Product Information

For inventory control purposes, product name may be followed by an X.

Products labeled PFA 345 and PFA 345 X are equivalent, and all information in this document is applicable to both.

### Typical Applications

Applications for Teflon™ PFA 345 include extruded tubing, wire and cable insulation, injection molded parts, and chemically resistant linings for bellows, valves, fittings, pipes, pumps, and other fluid-handling components.

### Description

Teflon™ PFA 345 is a medium melt flow rate fluoropolymer resin available in pellet form. Compared with Teflon™ PFA 340, it offers increased flex life and greater resistance to environmental stress-cracking (Teflon™ PFA 345 offers a typical MIT folding endurance of 50,000\* compared to 15,000 in Teflon™ PFA 340). Table 1 shows the typical property data for Teflon™ PFA 345.

Teflon™ PFA 345 is used when traditional extrusion and molding processes are required for producing products with the superior properties of a fluoropolymer resin. Compared to other thermoplastics, the high melt strength and thermal stability of Teflon™ PFA 345 can be used to improve processing rates. Compared with other fluoropolymers, creep resistance at high service temperatures provides a superior balance and level of end-use properties. Teflon™ PFA 345 combines the processing ease of conventional thermoplastics with many properties similar to those of polytetrafluoroethylene.

Properly processed products made from neat Teflon™ PFA 345 resin provide the superior properties characteristic of fluoropolymer resins: chemical inertness, exceptional dielectric properties, heat resistance, toughness and flexibility, low coefficient of friction, non-stick characteristics, negligible moisture absorption, low flammability, performance at temperature extremes, and excellent weather resistance.

In a flame situation, products of Teflon™ PFA 345 resist ignition and do not promote flame spread. When ignited by flame from other sources, their contribution of heat is very small and added at a slow rate with very little smoke.

### Processing

Teflon™ PFA 345 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 fluoropolymer resin. Extruder barrel should be long, relative to diameter, to provide residence time for heating the resin to approximately 390 °C (730 °F). For more detailed processing information, including recommended draw-down ratios, consult your Chemours sales representative.

### Safety Precautions

WARNING! VAPORS CAN BE LIBERATED THAT MAY BE HAZARDOUS IF INHALED.

Before using Teflon™ PFA 345 resin, refer to the Safety Data Sheet and the latest edition of "The Guide to the Safe Handling of Fluoropolymer Resins," published by the Plastics Industry Association ([www.fluoropolymers.org](http://www.fluoropolymers.org)) or by PlasticsEurope ([www.plasticseurope.org](http://www.plasticseurope.org)). Open and use containers only in well-ventilated areas using local exhaust ventilation (LEV). Vapors and fumes liberated during hot processing of Teflon™ PFA 345 should be exhausted completely from the work area. Contamination of tobacco with these polymers must be avoided. Vapors and fumes liberated during hot processing that are not properly exhausted, or from smoking tobacco or cigarettes contaminated with Teflon™ PFA 345, may cause flu-like symptoms, such as chills, fever, and sore throat. This may not occur until several hours after exposure and will typically pass within about 24 hours. Mixtures with some finely divided metals, such as magnesium or aluminum, can be flammable or explosive under some conditions.

### Storage and Handling

The properties of Teflon™ PFA 345 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.

### Freight Classifications

Teflon™ PFA 345 resin is classified as "Plastics, Materials, Pellets."

### Packaging

Teflon™ PFA 345 is supplied as pellets and is available in 25-lb multilayer bags with an integral polyethylene liner.



Chemours™



**Table 1: Typical Property Data for Teflon™ PFA 345 Molding and Extrusion Resin**

Property	Test Method		Unit	Typical Value
<b>GENERAL</b>				
Melt Flow Rate	ISO 12086	ASTM D3307	g/10 min	5
Melting Point	—	ASTM D4591	°C (°F)	305 (581)
Specific Gravity	—	ASTM D792	—	2.15
Critical Shear Rate, 372 °C (702 °F)	—	—	1/s	21
<b>MECHANICAL</b>				
Tensile Strength	ISO 12086	ASTM D3307	MPa (psi)	
23 °C (73 °F)				27 (3,900)
Ultimate Elongation	ISO 12086	ASTM D3307	%	
23 °C (73 °F)				300
Flexural Modulus	ISO 178	ASTM D790	MPa (psi)	
23 °C (73 °F)				551 (80,000)
MIT Folding Endurance (0.20 mm, 8 mil film)	—	ASTM D2176 <sup>†</sup>	Cycles	50,000*
Hardness Durometer	ISO 868	ASTM D2240	—	D55
<b>ELECTRICAL</b>				
Dielectric Strength, Short Time, 0.25 mm (0.010 in)	IEC 243	ASTM D149	kV/mm (V/mil)	80 (2,000)
Dielectric Constant, 1 MHz (10 <sup>6</sup> Hz)	IEC 250	ASTM D150	—	2.03
Dissipation Factor, 1 MHz (10 <sup>6</sup> Hz)	IEC 250	ASTM D150	—	<0.0002
Volume Resistivity	ISO 1325	ASTM D257	ohm-cm	10 <sup>18</sup>
<b>OTHER</b>				
Water Absorption, 24 hr	—	ASTM D570	%	<0.03
Weather and Chemical Resistance	—	—	—	Outstanding
Limiting Oxygen Index	ISO 4589	ASTM D2863	%	>95
Continuous Service Temperature <sup>‡</sup>	—	—	°C (°F)	260 (500)
Flammability Classification <sup>†</sup>	—	UL 94	—	V-0

\* Depending on fabrication conditions

† Historical standard

‡ Definition of continuous service temperature: The continuous service temperature is based on accelerated heat-aging tests, and represents the temperature at which tensile strength and ultimate elongation retain 50% of the original values after 20,000 hr thermal aging. Continuous service temperature above 260 °C (500 °F) may be feasible, depending on such factors as chemical exposure, support from the substrate, etc. When considering uses of Teflon™ PFA 345 above 260 °C (500 °F), preliminary testing should be done to verify suitability.

† These results are based on laboratory tests under controlled conditions and do not reflect performance under actual fire conditions; current rating is a typical theoretical value.

Note: Teflon™ PFA 345 meets the requirements of ASTM D3307, Type III

Typical properties are not suitable for specification purposes.

Statements or data regarding behavior in a flame situation are not intended to reflect hazards presented by this or any other material when under actual fire conditions.

