



Designation: **D3222–05 (Reapproved 2015) D3222 – 18**

## Standard Specification for Unmodified Poly(Vinylidene Fluoride) (PVDF) Molding Extrusion and Coating Materials<sup>1</sup>

This standard is issued under the fixed designation D3222; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

*This standard has been approved for use by agencies of the U.S. Department of Defense.*

### 1. Scope-~~Scope~~\*

1.1 This specification covers melt processable molding and extrusion materials, as well as coating materials of poly(vinylidene fluoride) fluoroplastic, commonly abbreviated PVDF (or PVF<sub>2</sub> in scientific literature). This specification covers thermoplastic resin materials supplied in pellet or powder form.

1.2 This specification applies only to the virgin homopolymer prepared from vinylidene fluoride, not copolymers, reinforced, filled grades or special grades with additives or treatments for modification of attributes.

1.3 The tests involved are intended to provide information for specification of unmodified PVDF homopolymer resins. It is not the purpose of this specification to provide engineering data for design purposes.

1.4 PVDF fluoroplastics melt between 156 and 180°C (312 and 356°F) and are thermally stable up to about 370°C (698°F). (**Warning**—Evolution of corrosive and toxic hydrogen fluoride can occur under certain conditions.)

1.5 The values stated in SI units, as detailed in **IEEE/ASTM S-10**, are to be regarded as the standard. The values given in parentheses are for information only.

NOTE 1—PVDF exhibits polymorphism.<sup>2</sup> The type and extent of crystalline structure varies with the thermomechanical history of the sample. Specimens prepared by techniques different than prescribed in this specification can have properties that vary from the values specified.

1.6 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate ~~safety~~-safety, health, and ~~health~~environmental practices and determine the applicability of regulatory limitations prior to use.* Specific precautionary statements are given in Section 10.

NOTE 2—There is no equivalent ISO standard for this specification. Information in this specification is technically equivalent to related information in ISO 12086-1 and ISO 12086-2.

1.7 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

### 2. Referenced Documents

#### 2.1 ASTM Standards:<sup>3</sup>

**D149** Test Method for Dielectric Breakdown Voltage and Dielectric Strength of Solid Electrical Insulating Materials at Commercial Power Frequencies

**D150** Test Methods for AC Loss Characteristics and Permittivity (Dielectric Constant) of Solid Electrical Insulation

**D256** Test Methods for Determining the Izod Pendulum Impact Resistance of Plastics

**D257** Test Methods for DC Resistance or Conductance of Insulating Materials

**D542** Test Method for Index of Refraction of Transparent Organic Plastics

**D618** Practice for Conditioning Plastics for Testing

**D638** Test Method for Tensile Properties of Plastics

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee D20 on Plastics and is the direct responsibility of Subcommittee D20.15 on Thermoplastic Materials. Current edition approved May 1, 2015May 1, 2018. Published June 2015May 2018. Originally approved in 1973. Last previous edition approved in 20142015 as D3222 - 05(2010)-(2015). DOI: 10.1520/D3222-05R15-10.1520/D3222-18.

<sup>2</sup> Lovinger, A. J., "Poly(Vinylidene Fluoride)" *Developments in Crystalline Polymers*, Vol 1, Chapter 5, D. C. Bassett, Ed., Applied Science, London, 1982.

<sup>3</sup> For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

\*A Summary of Changes section appears at the end of this standard

**TABLE 1 Classification of PVDF Resins**

Property		Typical Values or Ranges		
		Type I		Type II
		Grade 1	Grade 2	
Specific Gravity	Gms/cc	1.75-1.79	1.75-1.79	1.76-1.79
Peak Melting Endotherm	°G	156-162	162-170	164-180
Peak Melting Endotherm	°C	156-162	162-172	164-180
Melt Flow Rate	g/10 min (wt in Kg)			
	Ultra High Viscosity	...	...	0.5-10 <sup>A</sup>
	High Viscosity	0.5-8 <sup>A</sup>	5-8 <sup>B</sup>	0.5-10 <sup>C</sup>
	Medium Viscosity	4-18 <sup>A</sup>	5-36 <sup>B</sup>	0.5-30 <sup>D</sup>
	Low Viscosity	...	3.5-45 <sup>E</sup>	0.5-60 <sup>F</sup>
Apparent Melt Viscosity	Pa's: <sup>G</sup>			
	High Viscosity	2800-3800	2800-3700	2500-4000
	Medium Viscosity	2300-2800	1300-2800	1300-2500
	Low Viscosity	...	350-1300	250-1300

Note: For measuring MFR values of PVDF, the load must be selected based on the viscosity as follows:

<sup>A</sup>= 21.6 Kg

<sup>B</sup>= 12.5 Kg

<sup>C</sup>= 10.0 Kg

<sup>D</sup>= 5 Kg

<sup>E</sup>= 3.8 Kg

<sup>F</sup>= 2.16 Kg

<sup>G</sup> Reported for a shear rate of 100 s<sup>-1</sup> determined by capillary rheometry at 232°C (450°F) using 0.027 radian (60°) entrance angle die with L/D of 15 and in accordance with procedures of Test Method [D3835](#). Multiply the pascal second values by ten to obtain poise values.

[D790 Test Methods for Flexural Properties of Unreinforced and Reinforced Plastics and Electrical Insulating Materials](#)

[D792 Test Methods for Density and Specific Gravity \(Relative Density\) of Plastics by Displacement](#)

[D883 Terminology Relating to Plastics](#)

[D1238 Test Method for Melt Flow Rates of Thermoplastics by Extrusion Plastometer](#)

[D2863 Test Method for Measuring the Minimum Oxygen Concentration to Support Candle-Like Combustion of Plastics \(Oxygen Index\)](#)

[D3418 Test Method for Transition Temperatures and Enthalpies of Fusion and Crystallization of Polymers by Differential Scanning Calorimetry](#)

[D3835 Test Method for Determination of Properties of Polymeric Materials by Means of a Capillary Rheometer](#)

[D3892 Practice for Packaging/Packing of Plastics](#)

[IEEE/ASTM S-10 Use of the International System of Units \(SI\): The Modern Metric System](#)

2.2 *IEC and ISO Standards:*

[ISO 12086-1 Plastics—Fluoropolymer Dispersion and Moulding and Extrusion Materials—Part 1: Designation and Basis for Specification](#)<sup>4</sup>

[ISO 12086-2 Plastics—Fluoropolymer Dispersion and Molding and Extrusion Materials—Part 2: Preparation of Test Specimens and Determination of Properties](#)<sup>4</sup>

### 3. Terminology

#### 3.1 Definitions:

3.1.1 For definitions of plastics terms used in this specification, see Terminology [D883](#).

3.1.2 *lot, n*—one production run or a uniform blend of two or more production runs.

### 4. Classification

4.1 This specification covers two types<sup>5</sup> of natural, unmodified PVDF fluoroplastics supplied in pellet form for molding and extrusion, and in powder form for solutions, dispersions, or coatings.

4.1.1 *Type I*—PVDF fluoroplastics are polymerized in emulsion. Depending upon the polymerization conditions, the peak melting point of the resin can be varied between 156 and 170°C. The diameter of the primary particle isolated from the emulsion is typically less than 1 µm; the dried powder has an average agglomerate diameter range of 3 to 15 µm.

4.1.1.1 Two distinctly different Type I emulsion PVDF resins are available commercially. These are differentiated by peak melting endotherm values, as shown in [Table 1](#), and this difference is the basis for subdividing Type I resins into Grades 1 and 2. [Table 1](#) shows the melt viscosity ranges encompassing resin grades available from several sources and are provided for information purposes only.

<sup>4</sup> Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

<sup>5</sup> Dohany, J. E., and Robb, L. E., "Poly(Vinylidene Fluoride)" *Kirk-Othmer Encyclopedia of Chemical Technology*, Vol 11, 3rd Edition, 1980, pp. 64–74.

4.1.2 *Type II*—PVDF fluoroplastics are polymerized in suspension. Peak melting temperatures of these resins range from 164 to 180°C. The particles isolated from suspension are spherical and range typically from 20 to 150 µm in diameter.

4.1.2.1 Type II resins are available commercially, and the data of [Table 1](#) reflect ranges encompassing values typical for the properties of available grades.

4.2 The system uses predefined cells to refer to specific aspects of this specification, as illustrated below.

Standard Number Block	Specification			
	Type	Grade	Class	Special Notes
Example: Specification				
D3222-05	I	2	...	...
D3222	I	2	...	...

For this example (D3222-05D3222, I2), the line callout describes a PVDF resin polymerized in emulsion, having a specific gravity between 1.75 and 1.79, and a peak melting endotherm between 162 to 170°C. A comma is used as the separator between the Standard Number and the Type. Separators are not needed between the Type, Grade, and Class.<sup>6</sup> Provision for Special Notes is included so that other information, such as a preferred viscosity range, can be provided when required. When special notes are used, they shall be preceded by a comma.

## 5. General Requirements

5.1 The material shall be of uniform composition and free of foreign matter.

## 6. Detail Requirements

### 6.1 General Attributes:

6.1.1 *Peak Melting Endotherm*—The material covered by this specification shall have a minimum peak melting endotherm for the type and class as shown in [Table 1](#) when tested in accordance with Test Method [D3418](#). For Type I resins, this shall involve heating a solid specimen of  $5 \pm 1$  mg from room temperature to 200°C at 10°C/min, maintaining the temperature at 200°C for 5 min, followed by cooling at a controlled rate of 10°C/min to about 30°C, then reheating at 10°C/min to 200°C. Record the peak melting endotherm during the second melting cycle.

6.1.1.1 *Temperature*—Test Type II resins likewise except that the maximum is 250°C.

6.1.2 *Specific Gravity*—A solid specimen of the material covered by this specification shall have the ~~minimum~~ specific gravity indicated in [Table 1](#) (1.75 for Type I, Class 1 and 1.76 for all others) when tested in accordance with Test Method [D792](#).

NOTE 3—Test attached to the specimen upon immersion. Dipping the specimens in a very dilute solution (less than 0.1 weight percent) of an ammonium perfluorooctanoate surfactant minimizes this problem.

6.1.3 *Refractive Index*—The material covered in this specification shall have a refractive index of 1.42 when measured at the sodium D line at 25°C (77°F) in accordance with the refractometer procedure in Test Methods [D542](#), using specimens that have not been subjected to any processes which induce orientation of the polymer chains or crystal-lites. Compression-molded specimens at least 2-mm (0.079-in.) thick that have been quenched rapidly in water are preferred.

6.1.4 *Limiting Oxygen Index*—The material covered in this specification shall have a minimum limiting oxygen index of 42 when tested in accordance with Test Method [D2863](#).

NOTE 4—If a column with a restricted opening is used, position the top of the specimen 40 mm below the opening.

### 6.2 Processing Related Attributes:

6.2.1 *Flow Rate*—Materials conforming to this specification shall be tested for melt flow rate in accordance with Test Method [D1238](#) using loads shown in parentheses in [Table 1](#).

6.2.2 *Rheological Properties*—The apparent melt viscosity of these materials shall be tested in accordance with Test Method [D3835](#) at  $231 \pm 1^\circ\text{C}$  (450°F) using a die with an entrance angle of 60° (cone angle of 120°) and a minimum capillary L/D of 15. See [Table 1](#).

### 6.3 Mechanical Properties:

6.3.1 *Tensile Properties*—The material covered in this specification shall have a tensile yield strength exceeding 36 MPa (5200 psi) at 23°C (74°F) and a minimum elongation at break of 10 % when tested in accordance with Test Method [D638](#) at 51 mm (2 in.)/min, using Type I specimens 3.2-mm (0.125-in.) thick as specified in Test Method [D638](#). Preferably, compression-molded samples are used (see [Section 8](#)), but injection molded specimens also are used, providing that the samples yield and rupture in the gage region and not near the heel. Specimens shall be molded under conditions specified by the resin suppliers. Generally, injection molded specimens show low and variable elongation values compared to compression-molded specimens. Typically, the melt temperature is 30 to 60°C higher than the upper peak melting endotherm value depending on the grade. Mold temperature is  $120 \pm 10^\circ\text{F}$ .

<sup>6</sup> See the ASTM *Form and Style for ASTM Standards*, available from ASTM Headquarters.