



Designation: D7472 – 19 (Reapproved 2024)

Standard Specification for EFEP-Fluoropolymer Molding and Extrusion Materials¹

This standard is issued under the fixed designation D7472; 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 (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This specification covers melt processible molding and extrusion materials of EFEP-fluoropolymer. The EFEP resin is a copolymer of ethylene, tetrafluoroethylene, and hexafluoropropylene.

1.2 This specification does not cover blended materials and does not cover recycled materials.

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

1.4 The following safety hazards caveat pertains only to the test method portion, Section 11, of this specification. *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, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

NOTE 1—Although this specification and ISO 20568-1 and ISO 20568-2 differ in approach or detail, data obtained using either are technically equivalent.

1.5 *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:²

- D150 Test Methods for AC Loss Characteristics and Permittivity (Dielectric Constant) of Solid Electrical Insulation**
- D618 Practice for Conditioning Plastics for Testing**
- D638 Test Method for Tensile Properties of Plastics**

¹ This specification is under the jurisdiction of ASTM Committee D20 on Plastics and is the direct responsibility of Subcommittee D20.15 on Thermoplastic Materials.

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² 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.

- 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**
- D1600 Terminology for Abbreviated Terms Relating to Plastics (Withdrawn 2024)³**
- D3418 Test Method for Transition Temperatures and Enthalpies of Fusion and Crystallization of Polymers by Differential Scanning Calorimetry**
- D3892 Practice for Packaging/Packing of Plastics**
- E177 Practice for Use of the Terms Precision and Bias in ASTM Test Methods**
- IEEE/ASTM SI-10 Use of the International System of Units (SI): The Modern Metric System**
- 2.2 ISO Standards:⁴**
 - ISO 20568-1 Plastics—Fluoropolymer Dispersions and Moulding and Extrusion Materials—Part 1**
 - ISO 20568-2 Plastics—Fluoropolymer Dispersions and Moulding and Extrusion Materials—Part 2**

3. Terminology

3.1 *General*—The terminology given in Terminology **D883** is applicable to this specification.

3.2 Definitions:

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

3.3 *General*—The abbreviated terms given in Terminology **D1600** are applicable to this specification.

4. Classification

4.1 This specification covers two types of fluoropolymer supplied in pellet form classified according to their melting points. The resins of each type are divided into one to two grades in accordance with their melt flow rate.

³ The last approved version of this historical standard is referenced on www.astm.org.

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

4.2 An one-line system shall be used to specify materials covered by this specification. The system uses predefined cells to refer to specific aspects of this specification, as illustrated as follows:

Specification
Standard Number : Type : Grade : Special
Block : : : Notes
: : : :

Example: Specification D7472 - 09, I2

For this example, the line callout shall be, Specification D7472 – 09, I2 and shall specify a fluoropolymer that has all of the properties listed for that type and grade in the appropriate specified properties, or tables, or both, in the specification identified. A comma is used as the separator between the standard number and the type. Separators are not needed between the type and grade.⁵

5. General Requirements

5.1 The material shall be of uniform composition and so prepared as to conform to the requirements of this specification.

5.2 The material described in this specification shall be free of foreign matter to such a contamination level as shall be agreed upon between the purchaser and the seller.

6. Performance Requirements

6.1 The average test result of the lot shall conform to the requirements prescribed in Tables 1 and 2 when tested by the procedures specified herein. Table 2 lists those tests requiring a specimen molded as described in Section 8.

7. Sampling

7.1 The materials shall be sampled in accordance with an adequate statistical sampling program.

8. Specimen Preparation

8.1 Prepare a molded sheet 1.5 ± 0.3 mm (0.06 ± 0.01 in.) thick. Use a picture-frame-type chase having a suitable blanked-out section and thickness to produce the desired sheet. Use clean aluminum foil, 0.13 to 0.18 mm (0.005 to 0.007 in.) thick, in contact with the resin. Spraying a high-temperature mold release agent on the aluminum foil will help prevent the

⁵ See the ASTM Form and Style Manual, available from ASTM Headquarters.

TABLE 1 Specific Gravity, Melting Point, and Flow Rate Requirements

Type Grade	I	II
	1	2
Specific gravity,		
min:	1.71	1.71
max:	1.77	1.77
Melting point, °C,		
min:	155	190
max:	170	200
Flow rate, g/10 min,		
min:	25.0	30.0
max:	50.0	8.0

TABLE 2 Detail Requirements for Molded Test Specimens for All Resins in This Specification

Type Grade	I	II
	1	2
Tensile strength, min, psi:	5800	4300
Elongation, min, %:	370	370
Dielectric constant,		
10 ³ Hz, max:	2.6	2.6
10 ⁶ Hz, max:	2.6	2.6
Dissipation factor,		
10 ³ Hz, max:	0.001	0.001
10 ⁶ Hz, max:	0.01	0.01

foil from sticking to the sheet. Use steel molding plates at least 1.0 mm (0.040 in.) thick and have an area adequate to cover the chase.

8.2 Lay down and smoothly cover one plate with a sheet of aluminum foil. Place the mold chase on top of this assembly. Place within the mold chase sufficient molding material to produce the required sheet in such manner that the polymer charge is a mound in the middle of the chase. Place a second sheet of aluminum foil on top of the granules and add the top mold plate. Place the assembly in a compression molding press having platens that have been heated to 265 ± 5°C (509 ± 9°F).

8.3 Bring the press platens to incipient contact with the mold assembly. Hold for 2 to 4 min without pressure. Apply approximately 1 MPa (145 psi) and hold for 1 to 1.5 min. Then apply 2 to 4 MPa (290 to 580 psi) and hold for 1 to 1.5 min. Maintain the press at 265 ± 5°C (509 ± 9°F) during these steps. Remove the assembly from the press and place between two 20 ± 7-mm (0.75 ± 0.25-in.) steel plates whose temperature is less than 40°C (104°F).

8.4 When the sheet is cool enough to touch about 50 to 60°C (122 to 140°F), remove aluminum foil from the sheet. (If the sheet is allowed to cool to room temperature, the aluminum foil cannot be pulled free.)

9. Conditioning

9.1 For tests of specific gravity and tensile properties, condition the molded test specimens in accordance with Procedure A of Practice D618 for a period of at least 4 h prior to test. The other tests require no conditioning.

9.2 Conduct tests at the standard laboratory temperature of 23 ± 2°C (73.4 ± 3.6°F) for determination of specific gravity and tensile properties only. Since this resin does not absorb water, the maintenance of constant humidity during testing is not necessary. Conduct tests for melt flow rate and melting point under ordinary laboratory conditions.

10. Packaging and Package Marking

10.1 *Packaging*—The material shall be packaged in standard commercial containers so constructed as to ensure acceptance by common or other carriers for safe transportation to the point of delivery unless otherwise specified in the contract or order.