



Designation: D 6713 – 01

Standard Specification for Extruded and Compression Molded Shapes Made from Poly(Vinylidene Fluoride) (PVDF)¹

This standard is issued under the fixed designation D 6713; 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 the requirements and test methods for the material, dimensions, and workmanship, and the properties of extruded sheet, rod and tubular bar manufactured from PVDF.

1.2 The properties included in this specification are those required for the compositions covered. Requirements necessary to identify particular characteristics important to specialized applications may be described by using the classification system given in Section 4.

1.3 This specification allows for the use of recycled plastics (as defined in Guide D 5033).

1.4 The values stated in English units are to be regarded as the standard in all property and dimensional tables. For reference purposes, SI units are also included in Tables X and S-PVDF only.

1.5 The following precautionary caveat pertains only to the test method portions 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 and health practices and determine the applicability of regulatory requirements prior to use.*

NOTE 1—There is no similar or equivalent ISO standard. ISO 12086-1 and ISO 12086-2 have pertinent information.

2. Referenced Documents

2.1 ASTM Standards:

D 256 Test Methods for Determining the Izod Pendulum Impact Resistance of Plastics²

D 638 Test Method for Tensile Properties of Plastics²

D 790 Test Method for Flexural Properties of Unreinforced and Reinforced Plastics and Electrical Insulating Materials²

D 883 Terminology Relating to Plastics²

D 1600 Terminology for Abbreviated Terms Relating to Plastics²

D 3222 Specification for Unmodified Poly(Vinylidene Fluoride) (PVDF) Molding and Extrusion and Coating Materials³

D 3892 Practice for Packaging/Packing of Plastics³

D 4000 Classification System for Specifying Plastics Materials³

D 5033 Guide for Development of ASTM Standards Relating to Recycling and Use of Recycled Plastics⁴
2.2 ANSI Standard.⁵

Z1.4-1993 Sampling Procedures and Tables for Inspection by Attributes

3. Terminology

3.1 Definitions:

3.1.1 *regrind (plastic), n*—a product or scrap such as sprues and runners that have been reclaimed by shredding and granulating for use in-house. **D 5033**

3.1.2 For definitions of other technical terms pertaining to plastics used in this specification, see Terminology D 883 or Guide D 5033.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *recycled-plastic shape, n*—a product made from up to 100 % post-consumer material.

3.2.2 *rod, n*—an extruded solid cylindrical shape with a minimum diameter of 1/16 in.

3.2.3 *sheet, n*—flat stock greater than and including 0.010 in. thickness.

3.2.4 *tubular bar, n*—extruded annular shapes with minimum inside diameter of 1/16 in., and a minimum wall of 1/4 in.

3.2.5 *unmodified virgin plastic shape, n*—a product produced from virgin plastic, as furnished by a manufacturer, with no additives or processing aids.

¹ This specification is under the jurisdiction of ASTM Committee D20 on Plastics and is the direct responsibility of Subcommittee D20.20 on Plastic Products (Section D20.20.02).

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² Annual Book of ASTM Standards, Vol 08.01.

³ Annual Book of ASTM Standards, Vol 08.02.

⁴ Annual Book of ASTM Standards, Vol 08.03.

⁵ Available from American National Standards Institute, 11 W. 42nd St., 13th Floor, New York, NY 10036.

4. Classification and Material

4.1 Product shape and size as defined in the applicable purchase order.

4.2 This specification covers product extruded and compression molded as listed in Table S-PVDF. Products included in the designations reference Specification **D 3222** callouts where applicable.

4.2.1 The type of PVDF shape product may be categorized by type, grade and class depending on resin and filler compositions as defined in Table S-PVDF.

4.2.2 Each type of shape may be categorized into one of several grades as follows:

4.2.2.1 *Grade 1—Unmodified Virgin*—Extruded or compression molded product made using only 100 % virgin PVDF material.

4.2.2.2 *Grade 2—General Purpose*—Extruded or compression molded product made using up to 20 % PVDF regrind developed during internal processing steps may be used.

4.2.2.3 *Grade 3—Recycled*—Extruded or compression molded product made using up to 100 % recycled PVDF resin.

4.3 The type, class and grade is further differentiated based on dimensional stability (elevated temperature excursion test), Table S-PVDF, and dimensional requirements, Tables A and B.

4.4 Property Tables:

4.4.1 Table S-PVDF may be used to describe both extruded or compression molded products.

4.4.2 Table X may also be used to describe both extruded or compression molded products not included in Table S-PVDF via a cell callout that includes the applicable Table S-PVDF type and specific properties (Designations 1-7).

4.4.3 To facilitate the incorporation of future or special materials not covered by Table S-PVDF, the “as specified” category (00) for type, class and grade is shown in the table with the basic properties to be obtained from Table X, as they apply.

4.4.4 *Reinforcements and Additive Materials*—A symbol (single-letter) will be used for the major reinforcement or combination, or both, along with two numbers that indicate the percentage of addition by mass with the tolerance as tabulated below. This must be included in all Table X callouts.

Symbol	Material	Tolerance (Based on the Total Mass)
C	Carbon and graphite fiber reinforced	±2 %
G	Glass-reinforced	
	<15 % glass content	±2 %
	>15 % glass content	±3 %
L	Lubricants (for example, PTFE, graphite, and silicone)	by agreement between the supplier and the user
M	Mineral	±2 %
R	Combinations of reinforcements or fillers, or both	±3 % for the total reinforcement

4.5 *Callout Designation*—A one-line system shall be used to specify PVDF materials covered by this specification. The system uses predefined cells to refer to specific aspects of this specification as illustrated below:

4.5.1 Examples:

4.5.1.1 *Example 1*—Product made from unfilled virgin PVDF:

CELL CALLOUT: S-PVDF0111

where:

S-PVDF01 = product made from PVDF in accordance with Table S-PVDF,

1 = unfilled virgin class, and

1 = general purpose grade product.

4.5.1.2 *Example 2*—Product made from 10 % carbon fiber blended with unmodified virgin PVDF resin:

CELL CALLOUT: S-PVDF0100C10X3454430

where:

S-PVDF0100 = product made from PVDF in accordance with Table S-PVDF,

C10 = 10 % carbon fiber,

X = Table X properties,

3 = tensile strength (10,000 psi),

4 = elongation at break (10 %),

5 = tensile modulus (500,000 psi),

4 = dimensional stability (0.4 %),

4 = flexural modulus (550,000 psi),

3 = Izod impact (1.0 ft-lb/in of notch), and

0 = unspecified.

4.5.2 These two examples illustrate how an on-line, alphanumeric sequence can identify the product composition, commercial parameters and physical characteristics of extruded or compression molded product. A space must be used as a separator between the specification number and the type designation. No separators are needed between type, class and grade. When special notes are to be included, such information should be preceded by a comma. Special tolerances must be noted at the time of order and are inserted after the grade in parenthesis and preceded by a comma.

5. Property Requirements

5.1 The physical property values listed within this specification’s tables are to be considered minimum specification values. Any requirement for specific test data for a given production lot should be specified at the time of order. Physical properties for products not yet included in Table S-PVDF may be specified using Table X for extruded or compression molded products.

6. Dimensional Requirements

6.1 The type, class and grade is differentiated based on dimensional stability (elevated temperature excursion test), Table S-PVDF and dimensional requirements, Tables A and B. Products shall be produced within commercial tolerances and with the lowest stress levels for machined parts as delineated in Tables A and B for extruded and compression molded products.

6.2 Tubular bar dimensions shall be supplied in the unfinished condition, unless otherwise specified at time of order sufficient to finish to the nominal dimension ordered.

6.3 The maximum allowable camber or bow, or both, shall be within the limits referenced in Tables A and B.

7. Workmanship, Finish and Appearance

7.1 *Appearance*—The color of products shall be as published by the shapes manufacturer. They shall be uniform in color throughout the thickness. Specific colors and color-matching only agreed to by order. Physical properties may be affected by colors.