



Designation: D4745 – 08

Standard Specification for Filled Compounds of Polytetrafluoroethylene (PTFE) Molding and Extrusion Materials¹

This standard is issued under the fixed designation D4745; 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 polytetrafluoroethylene (PTFE) filled molding compounds made with virgin PTFE resins defined in Specification D4894, as Types II and III.

NOTE 1—This specification can be used as a model for other PTFE compounds having particulate fillers that can survive the sintering temperatures of PTFE as can those listed in this specification. This specification is restricted to virgin PTFE base resin for technical reasons. Recycled or reprocessed material cannot be processed successfully.

NOTE 2—The properties measured on commercially fabricated parts may differ from the listed values for samples prepared by the procedures given in this specification, depending on part geometry and processing parameters.

NOTE 3—There is no ISO equivalent to this specification.

1.2 The values stated in SI units are to be regarded as standard.

1.3 The following statement applies to the test method portion, Section 12, 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 limitations prior to use.* See Note 5 for a specific warning statement.

2. Referenced Documents

2.1 ASTM Standards:²

- D618 Practice for Conditioning Plastics for Testing
- D638 Test Method for Tensile Properties of Plastics
- D792 Test Methods for Density and Specific Gravity (Relative Density) of Plastics by Displacement
- D883 Terminology Relating to 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.

D1600 Terminology for Abbreviated Terms Relating to Plastics

D3892 Practice for Packaging/Packing of Plastics

D4894 Specification for Polytetrafluoroethylene (PTFE) Granular Molding and Ram Extrusion Materials

IEEE/ASTM SI-10 Standard for Use of the International System of Units (SI): The Modern Metric System³

3. Terminology

3.1 *Definitions*—The terminology given in Terminology D883 is applicable to this specification unless otherwise specified.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *bulk density, n*—the mass in kilograms per cubic metre of resin compound measured under the conditions of the test.

3.2.2 *filled compound, n*—blend of PTFE resin as the matrix and particulate fillers, generally glass, other inorganic, metallic, or polymeric materials that withstand the sintering temperature of PTFE (327 to 380°C).

3.2.3 *free-flow resins (pelletized), n*—generally made by treatment of finely divided resins to produce free-flowing agglomerates.

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

3.2.5 *pigmented compound, n*—a compound in which a pigment is added for colorant purposes only.

3.2.6 *standard flow resins (nonpelletized), n*—finely divided resin with an average particle size less than 100 μm .

3.3 *Abbreviations*—Abbreviations are in accordance with Terminology D1600. PTFE is the acronym for polytetrafluoroethylene.

4. Classification

4.1 This specification covers the following two types of PTFE compounds:

4.1.1 *Type I*—Standard flow resins (nonpelletized) material, for general-purpose compression molding.

³ Available from ASTM International Headquarters, 100 Barr Harbor Drive, West Conshohocken, PA 19428

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

TABLE 1 TFE Compounds, Type I, Standard Flow (Nonpelletized)

Grade	Raw Resin Bulk Density, min, g/L	Molded Parts (Molded and Sintered)					
		Specific Gravity, min	Specific Gravity, max	Tensile Strength		Elongation, min, %	
				min, MPa	min, psi		
1	15 % glass fiber	400	2.150	2.250	19.6	2840	220
2	25 % glass fiber	425	2.150	2.250	15.7	2270	180
3	35 % glass fiber	350	2.200	2.300	10.3	1500	150
4	5 % glass fiber and 5 % MoS ₂	300	2.150	2.300	13.8	2000	200
5	15 % glass fiber and 5 % MoS ₂	375	2.150	2.300	13.8	2000	150
6	10 % graphite	350	2.100	2.220	17.9	2600	120
7	15 % graphite	300	2.100	2.200	13.8	2000	100
8	25 % carbon and graphite	350	1.950	2.150	9.6	1400	20
9	32 % carbon and graphite	250	1.900	2.100	6.9	1000	20
10	40 % bronze	500	2.950	3.350	16.5	2400	100
11	60 % bronze	650	3.850	4.154	12.4	1800	50
12	55 % bronze and 5 % MoS ₂	700	3.500	4.000	10.3	1500	80
13	50 % stainless steel	500	3.200	3.600	15.2	2200	120
0	As specified by customer and supplier			As specified by customer and supplier.			

4.1.2 *Type II*—Free-flow resins (pelletized) material, for compression molding, automatic molding, or ram extrusion.

4.2 Grades of each type distinguished by the nature of the filler(s) are listed in **Tables 1 and 2**.

4.3 A one-line system is used to specify materials covered by this specification. The system uses predefined cells to refer to specific aspects of this specification, as the following illustrates:

Standard Number Block	Specification			
	Type	Grade	Class	Special Notes
Example: Specification D4745 – 08	II	2		

4.3.1 For this example, the line callout would be Specification D4745 – 08, Type II, Grade 2, and would specify a free-flowing (pelletized) composition of polytetrafluoroethylene that has all of the properties listed for that type, and grade in the appropriate specified properties, 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, grade, and class.⁴ A provision for special notes is included so that other information can be provided when required. Precede special notes, when used, by a comma.

5. Ordering Information

5.1 The filled compounds of PTFE are ordered using the type, (see 4.1) and the grade (see reference **Table 1**), or they are ordered using the designation of the suppliers.

6. Requirements

6.1 The PTFE compounds covered by this specification shall be uniform (filler and resin particles evenly distributed) and shall contain no foreign material.

6.2 The PTFE compounds shall conform to the requirements prescribed in **Tables 1 and 2** when tested by the

procedures specified herein. **Table 1** lists requirements for Type I. **Table 2** references requirements for Type II.

7. Sampling

7.1 Sampling shall be statistically adequate to satisfy the requirements of 13.4.

8. Number of Tests

8.1 Routine lot inspection tests shall consist of those carried out to determine the requirements specified in **Table 1** depending on type.

8.2 The requirements listed in **Tables 1 and 2**, as they apply, are sufficient to establish conformity of a material to this specification. When the number of test specimens is not stated in the test method, single determinations may be made. If more than single determinations are made on specimens from separate portions of the same sample, the results shall be averaged. The single or average result shall conform to the requirements prescribed in this specification.

9. Test Specimens

9.1 Test specimens shall cut from a billet molded in accordance with the following procedures. An acceptable alternate procedure for molding a test plaque is described in Specification **D4894**, subsection 9.1.1.

9.2 Test Billets:

9.2.1 Prior to molding, screen the material through a 2.0-mm hand sieve, if necessary.

9.2.2 Preform solid test billets in a mold (see **Fig. 1**) having a cross-sectional area not greater than $25.8 \text{ cm}^2 \leq (4 \text{ in.}^2)$ and of sufficient height to contain the sample. End plug clearance shall be sufficient to ensure escape of entrapped air during pressing. It is acceptable to vary the powder charge weight in accordance with the density of the material. A mold length of 250 mm (9.8 in.) produces a billet approximately 75 mm (2 to 3 in.) long. Powder-charge weight may be varied in accordance with the density of the material. The billet length shall not exceed 75 mm (3 in.).

9.2.3 Assemble the mold. Add the resin to the mold. Insert the top plug and apply hand pressure, making certain that the

⁴ See the *ASTM Form and Style Manual*, available from ASTM Headquarters.

TABLE 2 TFE Compounds, Type II, Free-Flow (Pelletized)

Grade	Raw Resin Bulk Density, min, g/L	Molded Parts (Molded and Sintered)					
		Specific Gravity, min	Specific Gravity, max	Tensile Strength		Elongation, min, %	
				min, MPa	min, psi		
1	15 % glass fiber	625	2.150	2.25	13.8	2000	200
2	25 % glass fiber	625	2.150	2.250	12.4	1800	150
3	35 % glass fiber	650	2.150	2.250	8.3	1200	100
4	5 % glass fiber and 5 % MoS ₂	575	2.150	2.300	17.2	2500	170
5	15 % glass fiber and 5 % MoS ₂	600	2.150	2.300	13.8	1800	120
6	10 % graphite	600	2.070	2.190	13.8	2000	150
7	15 % graphite	550	2.100	2.200	10.3	1500	60
8	25 % carbon and graphite	500	1.950	2.100	8.3	1200	20
9	32 % carbon and graphite	400	1.900	2.200	6.9	1000	20
10	40 % bronze	750	2.950	3.250	13.8	2000	85
11	60 % bronze	900	3.800	4.000	10.3	1500	20
12	55 % bronze and 5 % MoS ₂	900	3.500	4.000	6.9	1000	20
13	50 % stainless steel	850	3.200	3.600	13.8	2000	100
0	As specified by customer and supplier				As specified by customer and supplier.		

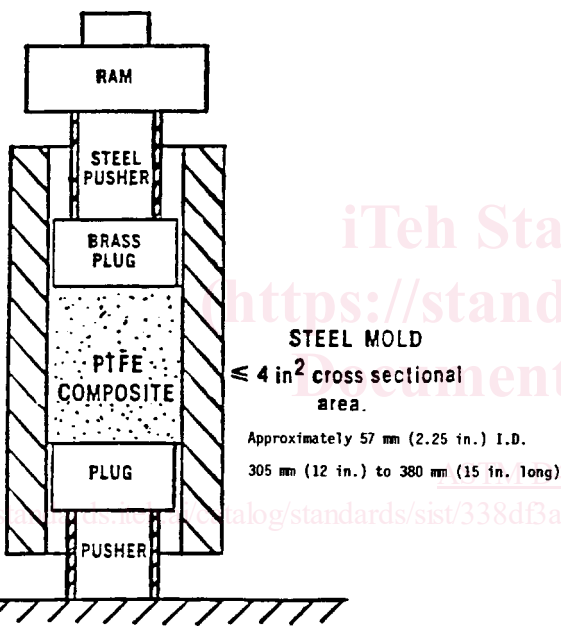


FIG. 1 Preforming of PTFE Composite Test Billet

pusher is centered in the mold. Place the mold in a hydraulic press and remove the support ring or spacers. Increase the loading smoothly to the final preforming pressure in 3 to 5 min. Use 20.7 MPa (3000 psi) for compounds containing up to 4 % by weight filler. Use 34.5 MPa (5000 psi) for compounds containing 5 to 25 % by weight and 68.9 MPa (10 000 psi) for compounds containing more than 26 % filler. Hold under maximum pressure for 2 to 5 min. Open the press, remove the top pusher from the mold, and force the preform vertically out of the mold, using a continuous, smooth movement.

9.2.4 Place the preform in a sintering oven and sinter in accordance with the procedure in Table 3.

9.2.5 *Safety Warning*—At normal processing temperatures, PTFE liberates harmful vapors. Provide adequate ventilation in areas where PTFE compounds are exposed to elevated temperatures. Avoid contaminating smoking materials with PTFE compounds.

TABLE 3 Sintering Procedures for Test Billets

Initial temperature, °C (±) ^A	Ambient
Rate of heating, °C/h (°F/h)	60 ± 5 (108 ± 9)
Hold temperature, °C (°F)	370 ± 6 (698 ± 10)
Hold time, min	240 ± 5
Rate of cooling, °C/h (°F/h)	60 ± 5 (108 ± 9)
Final temperature, °C (°F) ^A	95 ± 6 (203 ± 10)

^A Oven can be opened safely at these temperatures.

9.3 Sectioning Test Billet:

9.3.1 Divide the test billet into sections by making transverse cuts by machining, or by a suitable alternate procedure, in accordance with Fig. 2.

9.3.2 Prepare five test specimens, 1 ± 0.25 mm (0.040 ± 0.010 in.) in thickness for the determination of tensile strength and elongation and cut a piece of suitable thickness for specific gravity measurements. This piece will be approximately cubical in shape, weighing at least 10 g. All surfaces must be smooth. Take care to avoid wedge-shape cuts. Alternate molding for specific gravity specimens as described in D4894, subsection 9.2.1 and Appendix X1.

10. Conditioning Test Specimens

10.1 For density and tensile properties the test specimens shall be conditioned in accordance with Procedure A of Practice D618 for a period of at least 4 h prior to test.

11. Test Conditions

11.1 Tests shall be conducted at 23 ± 2°C (73.4 ± 4°F). Since the resin does not absorb water, the maintenance of constant humidity during testing is not required.

12. Test Methods

12.1 Filler Content:

12.1.1 *Scope*—This burn-out procedure for filler content may be used for determining the amount of a filler in a compound. The entire procedure shall be carried out in an inert atmosphere, especially when fillers that react with PTFE and oxygen are present. Reaction with oxygen produces volatile products that will cause incorrect results. This procedure is not