

3M™ Dyneon™ Modified PTFE Compound TF R4212

Product Description

3M™ Dyneon™ Modified PTFE Compound TF R4212 is a free-flowing suspension PTFE compound containing 10 % electro-graphitized carbon for ram extrusion.

Special Features

- Increased thermal dimensional stability
- Increased surface hardness
- Improved deformation under load
- Reduced friction & wear
- Good chemical stability
- High limiting oxygen index (LOI)
- Low friction behaviour
- Very good mechanical properties
- Exceptional temperature resistance

Product Properties	Test method	Unit	Value
Bulk Density	ASTM D 4894-07	g/l	740
Shrinkage	ASTM D 4894-07	%	2.1
Specific Gravity	ASTM D 4745-06	g/cm ³	2.155

Mechanical Properties	Test method	Unit	Value
Tensile Strength	ASTM D 4745-06	MPa	27.0
Elongation at Break	ASTM D 4745-06	%	340
Hardness	DIN 53505	Shore 'D'	62

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Typical Properties

PTFE Compound Ram Extrusion powder with excellent free-flowing and easy-feeding characteristics, which are prerequisites for trouble-free ram extrusion processing.

Typical Applications

3M™ Dyneon™ Modified PTFE Compound TF R4212 can be used in sealing applications in the chemical processing (CPI) and automotive industries.

Processing Recommendations

If transport or storage temperatures are too high the material can agglomerate in its container. In such cases, it is advisable to store the material for 48 hours at below 23 °C and then to sieve it (mesh size 4 mm) before filling the mould. To achieve optimum properties, compression moulding should be carried out within a temperature range of 23 °C to 26 °C and a humidity range of 45 % to 55 % and a pressure of 55 MPa. The maximum sintering temperature should be 365 °C.

Storage and Handling

3M™ Dyneon™ Modified PTFE Compound TF R4212 can be stored for a relatively long period of time. It should preferably be stored in a clean, dry place at a temperature of less than 30 °C. Before processing it is advisable to store the material in the sealed boxes for 24 hours in the production area. This is particularly important when ambient temperature is low; in such cases the material should be conditioned for up to 72 hours in the production area in the recommended temperature range.

Safety Instructions

Follow the normal precautions observed with all fluoropolymer materials.

Please consult the Material Safety Data Sheet and Product Label for information regarding the safe handling of the material. By following all precautions and safety measures, processing these products poses no known health risks. General handling/processing precautions include: 1) Process only in well-ventilated areas. 2) Do not smoke in areas contaminated with powder/residue from these products. 3) Avoid eye contact. 4) If skin comes into contact with these products during handling, wash with soap and water afterwards. 5) Avoid contact with hot fluoropolymer.

Potential hazards, including release of toxic vapours, can arise if processing occurs under excessively high temperature conditions. Vapour extractor units should be installed above processing equipment. When cleaning processing equipment, do not burn off any of this product with a naked flame or in a furnace.

Delivery Form

3M™ Dyneon™ Modified PTFE Compound TF R4212 is supplied in moisture and dust tight plastic boxes.

Packaging sizes are:

- Capacity per box: 25 kg
- Order quantity per pallet: 300 kg

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Important Notice

All information set forth herein is based on our present state of knowledge and is intended to provide general notes regarding products and their uses. It should not therefore be construed as a guarantee of specific properties of the products described or their suitability for a particular application. Because conditions of product use are outside Dyneon's control and vary widely, user must evaluate and determine whether a Dyneon product will be suitable for user's intended application before using it.

The quality of our products is warranted under our General Terms and Conditions of Sale as now are or hereafter may be in force.

Technical information, test data, and advice provided by Dyneon personnel are based on information and tests we believe are reliable and are intended for persons with knowledge and technical skills sufficient to analyze test types and conditions, and to handle and use raw polymers and related compounding ingredients.

No license under any Dyneon or third party intellectual rights is granted or implied by virtue of this information.

General recommendations on health and safety in processing, on work hygiene and on measures to be taken in the event of accident are detailed in our material safety data sheets.

You will find further notes on the safe handling of fluoropolymers in the brochure "[Guide for the safe handling of Fluoropolymers Resins](#)" (download link) by PlasticsEurope, Box 3, B-1160 Brussels, Tel. +32 (2) 676 17 32.

You can also download it with your smartphone using the QR code below.



Customer Service

Europe
Phone: 00 800 396 366 27
Fax: 00 800 396 366 39
Italy
Phone: 800 7 910 18
Fax: 800 7 810 19
USA
Phone: +1 800 810 8499
Fax: +1 800 635 8061

Technical Service Fluoroplastics

Dyneon GmbH
3M Advanced Materials Division
Industrieparkstraße 1
84508 Burgkirchen
Germany
Phone: +49 8679 7 4709
Fax: +49 8679 7 5037

Technical Service Fluoroelastomers & Polymer Processing Additives

3M Belgium N.V.
3M Advanced Materials Division
Canadastraat 11
Haven 1005
2070 Zwijndrecht
Belgium
Phone: +32 3 250 7868
Fax: +32 3 250 7905

Technical Service PTFE Compounds

Dyneon B.V.
3M Advanced Materials Division
Tunnelweg 95
6468 EJ Kerkrade
The Netherlands
Phone: +31 45 567 9600
Fax: +31 45 567 9619

We will gladly supply further contact details for our full network of global sales offices. Alternatively, find them [here](#).



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