

# DuPont™ Tefzel® 210

## fluoropolymer resin

### Extrusion and Molding Resin

#### Description

DuPont™ *Tefzel*® fluoropolymer 210 is a special-purpose resin available in translucent, 2.5-mm (0.1-in) pellets. Compared to other grades of *Tefzel*®, it has a higher flow rate and a lower maximum service temperature.

*Tefzel*® 210 and the other *Tefzel*® fluoropolymers are melt processible, modified copolymers of ethylene and tetrafluoroethylene. They are high-performance resins that can be processed at relatively high rates compared to fluorocarbon resins. They are mechanically tough and offer an excellent balance of properties.

The relatively high flow rate of *Tefzel*® 210 makes it uniquely suitable for high speed processing, especially for extruded coatings and injection molding of slender, thin-walled or intricate shapes. Molded or extruded products made from *Tefzel*® 210 are preferred for uses that do not involve significant flexural or tensile stress at elevated temperatures.

Properly processed products made from virgin *Tefzel*® 210 are inert to most solvents and chemicals, hydrolytically stable and weather resistant. Recommended upper service temperature is 135°C (275°F); useful properties are retained at cryogenic ranges. The level and stability of dielectric properties are excellent and the flame rating is V-0 by the UL94 method. Mechanical properties include outstanding impact strength, cut-through and abrasion resistance.

Statements, or data, regarding behavior in a flame situation are not intended to reflect hazards presented by this or any other material when under actual fire conditions.

#### Typical End Products

*Tefzel*® 210 is ideal for many end products, including electrical components, such as sleeving, coil forms, sockets, connectors and switches; lab ware, such as tubing, valves, containers and fasteners; battery or instrument components that require chemical inertness; and mechanical parts.

#### Processing

*Tefzel*® 210 can be processed by conventional, melt-extrusion techniques and by injection, compression, transfer and blow molding processes. Compared to other grades of *Tefzel*®, it can be processed with greater ease and speed because of its high flow rate. Also, the melt viscosity of *Tefzel*® is reduced with increasing shear rate, thus permitting the use of pressure extrusions through narrow dies without requiring appreciable draw-down. Reciprocating screw injection molding machines are preferred. Corrosion-resistant metals should be used in contact with molten resin. Extruder barrels should be long, relative to diameter, to provide residence time for heating the resin to approximately 340°C (640°F).

#### Safety Precautions

##### WARNING!

##### VAPORS CAN BE LIBERATED THAT MAY BE HAZARDOUS IF INHALED.

Before using *Tefzel*® 210, read the Material Safety Data Sheet and the detailed information in the "Guide to the Safe Handling of Fluoropolymer Resins," latest edition, published by the Fluoropolymers Division of The Society of the Plastics Industry—available from DuPont.



Open and use containers only in well-ventilated areas using local exhaust ventilation (LEV). Vapors and fumes liberated during hot processing, or from smoking tobacco or cigarettes contaminated with *Tefzel*<sup>®</sup> 210, may cause flu-like symptoms (chills, fever, sore throat) that may not occur until several hours after exposure and typically pass within about 24 hours. Vapors and fumes liberated during hot processing should be exhausted completely from the work area; contamination of tobacco with polymers should be avoided.

Mixtures with some finely divided metals, such as magnesium or aluminum, can be flammable or explosive under some conditions.

### **Storage and Handling**

The properties of *Tefzel*<sup>®</sup> 210 resins are not affected by storage time. Ambient storage conditions should be designed to avoid airborne contamination and the formation of water condensation on the resin when it is removed from containers.

### **Packaging**

*Tefzel*<sup>®</sup> fluoropolymer resins are packaged in 20.3-kg (45-lb) multilayer, kraft bags with an integral polyethylene liner and in 149-kg (330-lb) drums with polyethylene liners.

### **Freight Classification**

*Tefzel*<sup>®</sup> when shipped by rail or express is classified "Plastics, Synthetic, O.T.L., NOIBN." Resin shipped by truck is classified "Plastics, Materials O.T.F.C.E. or S. Granules."

**Table 1**  
**Typical Property Data for DuPont™ Tefzel® Fluoropolymer Resin Grade 210**

Property	Test Method	Unit	Value
<b>Thermal Properties</b>			
Nominal Melting Point	ASTM D3159	°C (°F)	255–280 (491–536)
Flow Rate	ASTM D3159	g/10 min	20
Upper Service Temperature	UL746	°C (°F)	135 (275)
<b>Mechanical Properties</b>			
Tensile Strength, 23°C (73°F)	ASTM D3159	MPa (psi)	40 (5,800)
Specific Gravity	ASTM D792	—	1.7
Ultimate Elongation, 23°C (73°F)	ASTM D3159	%	300
Flexural Modulus, 23°C (73°F)	ASTM D790	MPa (psi)	1,200 (170,000)
Impact Strength, 23°C (73°F)	ASTM D256	J/m (ft-lb/in.)	No Break
Hardness Durometer	ASTM D2240	Shore D	63
Compressive Strength	ASTM D695	MPa (psi)	38 (5,500)
Linear Coefficient of Expansion, 0–100°C (32–212°F)	ASTM E831	mm/mm/°C (in./in./°F)	12.6 x 10 <sup>-5</sup> (7.0 x 10 <sup>-5</sup> )
<b>Electrical Properties</b>			
Dielectric Strength, 0.25 mm (0.010 in.)	ASTM D149	kV/mm (V/0.001 in.)	70 (1,800)
Dielectric Constant, 1 MHz, 23°C (73°F)	ASTM D1531	—	2.5–2.6
Dissipation Factor, 1 MHz, 23°C (73°F)	ASTM D1531	—	0.00540
Volume Resistivity	ASTM D257	ohm-m (ohm-cm)	1 x 10 <sup>3</sup> (1 x 10 <sup>17</sup> )
Arc Resistance	ASTM D495	seconds	122
<b>General Properties</b>			
Water Absorption, 24 h	ASTM D570	%	0.007
Weather and Chemical Resistance	—	—	Excellent
Limiting Oxygen Index	ASTM D2863	%	30–32

Typical properties are not suitable for specification purposes.

Tefzel® 210 is ASTM D3159 Type I, Grade 2.

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**For more information on Fluoroproducts:**

**(302) 479-7731**

DuPont Fluoroproducts  
P.O. Box 80713  
Wilmington, DE 19880-0713  
[www.teflon.com](http://www.teflon.com)

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***Europe***

DuPont de Nemours Int'l SA  
DuPont Fluoroproducts  
2, chemin du Pavillon  
P.O. Box 50  
CH-1218 Le Grand-Saconnex  
Geneva, Switzerland  
(022) 7175111

***Japan***

DuPont Mitsui  
Fluorochemicals Co., Ltd.  
Chiyoda Honsha Building  
5-18, Sarugaku-cho 1-chome  
Chiyoda-ku, Tokyo 101 Japan  
81-3-5281-5872

***Asia Pacific***

DuPont China, Limited  
26/F., Tower 6, The Gateway  
9 Canton Road, Tsimshatsui  
Kowloon, Hong Kong  
(852) 27341948  
Tim-S.T.Leung@hkg.dupont.com

***Canada***

DuPont Canada, Inc.  
DuPont Fluoroproducts  
P.O. Box 2200, Streetsville  
7070 Mississauga Road  
Mississauga, Ontario, Canada  
L5M 2H3  
(905) 821-5194

***South America***

DuPont do Brasil S/A  
Fluoropolymers  
Alameda Itapecuru, 506  
06454-080 - Alphaville  
P.O. Box 263  
Barueri, Sao Paulo, Brazil  
0800-171715  
Produtos.Brazil@bra.dupont.com

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**CAUTION:** Do not use in medical applications involving permanent implantation in the human body. For other medical applications, see "DuPont Medical Caution Statement," H-50102.

