

# DuPont™ Tefzel® HT-2190

## fluoropolymer resin

### Description

DuPont™ Tefzel® HT-2190 fluoropolymer resin is a premium grade resin designed for use in rotational molding. In order to be effective as a rotational molding resin, HT-2190 is a free-flowing powder, with controlled particle size, shape, and size distribution.

The properties of Tefzel® HT-2190 in molded form are similar to other grades of Tefzel® fluoropolymer resin. **Table 1** shows typical property data for Tefzel® HT-2190.

Rotational molding is a favored process for making hollow parts (particularly large parts) or for parts with complex geometries. Depending on part design and processing conditions, Tefzel® HT-2190 can also be used to rotoline items, in which process the Tefzel® is bound to the inner surface of the part, thus forming a lining.

Properly processed rotational moldings made from Tefzel® HT-2190 provide the superior properties typical of the fluoropolymer resins: retention of properties after service at 150°C (302°F), useful properties at -100°C (-148°F), and chemical inertness to most industrial chemicals and solvents. Dielectric properties are excellent. Molded products have excellent stiffness and high ultimate elongation.

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® HT-2190 is ideal for many end products for fluid handling in the chemical processing industries, including pump housings, vessels, columns, elbows, tees, and pipe sections with unusual shapes. In addition, any hollow structure with internal contours that permit uniform coating by powder flow is a candidate for lining, provided it can withstand high temperatures.

### Processing

For rotational molding, Tefzel® HT-2190 powder is placed inside a hollow metal structure that is slowly

rotated biaxially and heated above the melting point of the powder (255°C [491°F]). Frequently, the mold or part containing the resin is preheated (with rotation) to a temperature just below the melting point of the resin. Then, the temperature is raised to above the melting point of the resin to allow for formation of the lining. As the powder melts, it is deposited on the inner surface of the structure. Powder flow and distribution are critical because the high melt viscosity of Tefzel® limits the lateral flow of melted resin. A cooling step then causes the molten resin to solidify and densify in place, creating an integral lining or a removable, hollow plastic part. A typical thickness is about 2.3 mm (0.090 in). A thickness as high as 6.4 mm (0.250 in) has been molded.

Good moldings and linings require close attention to many details, such as choice of metals for the mold, preparation of the metal surface, rate of rotation, venting, and heating/cooling cycles. The equipment must operate at high temperature and resist thermal shock.

The times and temperatures of the preheat, fusion, and cooling cycles will vary according to the part, the oven, the choice of cooling method, etc. For a wall/lining thickness of 2.3 mm (0.090 in), the following times and temperatures are typical.

Preheat 5 min at 250°C (482°F)  
Fusion 75 min at 299°C (570°F)  
Cooling (ambient air)

Within certain limits, the fusion temperature can be increased to allow for use of shorter cycle times. The minimum time/temperature conditions can be defined as those times, at a specified temperature, which just allow for formation of bubble-free parts and linings. A typical minimum time/temperature relationship for Tefzel® HT-2190 is:

Temperature		Time, min
°C	°F	
288	550	125
299	570	95
304	580	75
316	600	55



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The upper temperature is defined as the temperature above which significant polymer decomposition begins to occur and produce bubbles. For *Tefzel*<sup>®</sup> HT-2190, this temperature is 371°C (700°F), depending on the process equipment, the part, etc.

*Tefzel*<sup>®</sup> is relatively dense, when compared with other resins. As a guide, to form a 2.3-mm (0.090-in) lining on a part with an interior surface of 0.093 m<sup>2</sup> (1 ft<sup>2</sup>), use 360 g (0.80 lb) of *Tefzel*<sup>®</sup> HT-2190.

Rotations for major and minor axes that are conventionally used for rotocasting other polymer resins have been applied without modification to *Tefzel*<sup>®</sup> HT-2190, e.g., 8 rpm major, 9 rpm minor for boxes, cylindrical pipe sections, tees, and spool pieces; 8 major, 10 minor for spheres, and ellipsoids. These conventional rotations have given acceptable fluoropolymer resin distribution/casting thicknesses.

Molds must be vented during the rotational molding/rotolining cycle. For best results, use an appropriate tube as a vent with glass wool in the tube to minimize contaminants entering the part.

## Safety Precautions

### WARNING!

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

Before using *Tefzel*<sup>®</sup> HT-2190, 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> HT-2190, may cause flu-like symptoms (chills, fever, sore throat) that may not occur until several hours after exposure and that 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.

## Substrate Considerations

Because the molding/lining process involves molten resin against the interior part wall, any surface structure on this part wall will tend to be translated to the part. Therefore, it is recommended to make the mold surface as uniform as possible, by removing scratches, burrs, etc. Grit blasting with a coarse grit (e.g., 24-grit aluminum oxide for mild steel) will enhance surface uniformity.

## Storage and Handling

The properties of *Tefzel*<sup>®</sup> HT-2190 are not affected by storage time. Ambient storage conditions should be designed to avoid airborne contamination and the formation of water condensation on the powder when it is removed from containers.

## Packaging

*Tefzel*<sup>®</sup> HT-2190 is packaged in drums containing 25-kg (55-lb) net weight.

## Freight Classification

*Tefzel*<sup>®</sup>, when shipped by rail or express, is classified as "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 HT-2190**

Property	ASTM Standard	Unit	Value
<b>Thermal</b>			
Nominal Melting Point	D3418	°C (°F)	255 (491)
Flow Rate	D3159	g/10 min	11.4
Upper Service Temperature*	—	°C (°F)	150 (302)
<b>Mechanical</b>			
Linear Coefficient of Expansion 0–100°C (32–212°F)	D696	mm/mm/°C (in/in/°F)	9 x 10 <sup>-5</sup> (5 x 10 <sup>-5</sup> )
Specific Gravity	D792	—	1.70
<b>Electrical</b>			
Dielectric Strength, 0.25 mm (0.010 in)	D150	kV/mm (V/0.001 in)	70 (1,800)
<b>General</b>			
Water Absorption, 24 hr	D570	%	<0.03
Weather and Chemical Resistance	—	—	Outstanding
Limiting Oxygen Index	D2863	%	30
Average Particle Size		µm	164
Bulk Density		g/L	730

\* The upper service temperature is based on heat-aging tests and represents the temperature at which tensile strength and elongation would be expected to be diminished 50% after 10,000 hr thermal aging. Upper service temperature above 150°C (302°F) may be feasible, depending on such factors as chemical exposure and support from the substrate. Particularly when considering uses of Tefzel® HT-2190 above 150°C (302°F), preliminary testing should be done to verify the acceptability.

**Note:** Typical properties are not suitable for specification purposes.

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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.

