



Teflon® AF Overview

Teflon® AF is a family of amorphous fluoroplastics. These materials are similar to other amorphous polymers in optical clarity and mechanical properties, including strength. They also resemble fluoroplastics in their performance over a wide range of temperatures, outstanding electrical properties, and chemical resistance. They are distinct from other fluoroplastics in that they are soluble in selected solvents and have high gas permeability, high compressibility, high creep resistance, and low thermal conductivity. They have the lowest dielectric constant of any known fluoroplastic.

Processing

Teflon® AF can be compression molded, injection molded, or extruded. Through these processes, various solid shapes can be formed using the product. Forms include rods, tubes, bars, and sheet of various thicknesses. In addition, Teflon® AF can be dissolved in certain perfluorinated solvents for the production of highly uniform thin films and coatings. Methods used to produce such forms include spin, spray, and dip coating. Typical molding temperatures for Teflon® AF 1600 range from 240 to 275°C (464 to 527°F); for Teflon® AF 2400, the range is 340 to 360°C (644 to 680°F). The polymer begins to decompose above 360°C (680°F), so processing above that temperature should be avoided. Corrosion-resistant tooling is recommended, as it is for Teflon® FEP and PFA fluoroplastic resins.

Teflon® AF Performance

What could you do with a product that has all of the outstanding properties of Teflon® fluoroplastics, is optically clear, has the lowest known dielectric constant of plastics, is resistant to creep under stress loads, and has limited solubility in select solvents?

Teflon® AF is a family of amorphous fluoroplastics with extraordinary performance characteristics when compared with other products currently available — properties that can be tailored for many high-performance requirements and demanding applications.

The Teflon® AF family of amorphous fluoroplastics is similar to Teflon® PTFE and PFA in many unusual properties, but is unique in the following ways:

- A true amorphous fluoroplastic.
- Somewhat higher coefficient of friction than Teflon® PTFE and PFA, but lower than Tefzel® ETFE.
- Excellent mechanical and physical properties at end-use temperature up to 300°C (572°F).
- Excellent light transmission from ultraviolet (UV) through a good portion of infrared (IR).
- Very low refractive index.
- Lowest dielectric constant of any plastic even at gigahertz frequencies.
- Limited solubility in selected perfluorinated solvents.
- The ability to tailor the glass transition temperatures (T_g) for desired end-use characteristics, thus achieving the best balance of other properties.

Comparison of Performance Characteristics of Teflon® AF versus Teflon® PFA

	Teflon® AF	Teflon® PFA
Morphology	Amorphous	Semicrystalline
Optical Clarity	Clear: >95%	Translucent to Opaque
Upper Use Temperature, °C (°F)	285 (545)	260 (500)
Thermal Stability, °C (°F)	360 (680)	380 (716)
Thermal Expansion (linear), ppm/°C	80	150
Water Absorption	No	No
Weatherability	Outstanding	Outstanding
Flame Resistant LOI, %	95	95
Tensile Modulus, MPa (psi)	950–2150 (137,786–311,832)	271–338 (39,305–49,023)
Creep Resistance	Good	Low
Solubility	Selected solvents	No
Resistance to Chemical Attack	Excellent	Excellent
Surface-Free Energy	Low	Low
Refractive Index	1.29–1.31	1.34–1.35
Dielectric Constant	1.89–1.93	2.1

- * Values are typical.

Teflon® AF shapes are offered in two standard grades 1600 and 2400

Typical Property Data for Teflon® AF Amorphous Fluoroplastics

Property	ASTM Method	Unit	Grade	
			1600	2400
Electrical				
Dielectric Constant	D150		1.93	1.90
Dissipation Factor	D150		0.0001–0.0002	0.0001–0.0003
Dielectric Strength	D149	kV/0.1 mm	2.1	1.9
Optical				
Optical Transmission	D1003	%	>95	>95
Refractive Index	D542		1.31	1.29
ABBE Number			92	113
Mechanical				
Yield Strength		MPa 23°C (73°F) 150°C (302°F) 220°C (428°F)	27.4 ± 1.0 6.7 ± 5.9	26.4 ± 1.9 8.7 ± 4.0

Tensile Strength	D638	MPa 23°C (73°F) 150°C (302°F) 220°C (428°F)	26.9 ± 1.5 7.7 ± 6.1	26.4 ± 1.9 4.2 ± 1.8
Elongation at Break	D638	% 23°C (73°F) 150°C (302°F) 220°C (428°F)	17.1 ± 5.0 89.3 ± 13.1	7.9 ± 2.3 8.4 ± 4.1
Tensile Modulus	D638	GPa	1.6	1.5
Flexural Modulus	D790	GPa 23°C (73°F) 150°C (302°F) 220°C (428°F)	1.8 ± 0.1 1.0 ± 0.1	1.6 ± 0.1 0.7 ± 0.1
Hardness Rockwell Durometer	D785 D1706	23°C (73°F) Shore D	103	97.5
		23°C (73°F)	77	75
		150°C (302°F) 220°C (428°F)	70	65
Impact Strength	Notched Izod	N	-	-
Deflection Temperature (66 psi) (264 psi)	D648	°C (°F)	156 (313)	200 (392)
			154 (309)	174 (345)
Chemical				
Contact Angle with Water	D570	Degrees	104	105
Critical Surface Energy		Dynes/cm	15.7	15.6
Taber Abrasion		cc/2000 cycles	0.107	0.2
Chemical Resistance				
Water Absorption		%	<0.01	<0.01
Gas Permeability				
H ₂ O		Barrer	1142	4026
O ₂		Barrer	340	990
N ₂		Barrer	130	490
CO ₂		Barrer		2800
Other				
T _g	D3418	°C (°F)	160 (320) ± 5	240 (464) ± 10
Specific Gravity	D792		1.78	1.67
Melt Viscosity	D3835	Pa s	2657 at 250°C, 100 s ⁻¹	540 at 350°C, 100 s ⁻¹
Volume Coefficient of Thermal Expansion	E831	ppm/°C	260	301

Optical Applications

Teflon® AF can be used as a low-refractive index coating or covering for optical devices, including those that must operate over a wide temperature range and in chemically aggressive environments. Teflon® AF offers a high level of transmission throughout the optical spectrum from infrared through ultraviolet.

Some specific uses are:

- In fiber optics as a low refractive index, high temperature cladding material over silica, methacrylates, and polycarbonates.
- Its optical properties of high transmission and broad spectrum transmission make it practical as an antireflective coating for high energy laser applications.
- The properties of high temperature tolerance, chemical resistance, high transmission, and mechanical strength make the material ideal for use as a window. It would also be good for optical sensing and diagnostic devices.
- The low refractive index combined with its other optical properties make Teflon® AF useful as an antireflective coating. It is also good as a protective coating where optical transmission is important.

Mechanical Applications

Teflon® AF exhibits excellent mechanical and physical properties at end-use temperatures up to the glass transition temperature. Teflon® AF also demonstrates good dimensional stability, reduced mold shrinkage, a smooth surface, and rigidity at high use temperatures. These characteristics, coupled with machinability and processing versatility, make Teflon® AF an excellent candidate for specialized chemical and industrial applications.

Some specific uses are:

- For chemically resistant molded parts and objects
- Sight windows in harsh chemical environments
- Connectors

Electrical Applications

In electronics, Teflon® AF may be used in optoelectronic devices where its optical clarity, temperature resistance, and dielectric properties are beneficial. It is essentially transparent to microwaves and can function as a “window” for high frequency antennas. The low dielectric constant and dissipation factor may be advantageous in the construction of electronic devices, including special circuit boards and hybrid devices.

Some specific uses are:

- Teflon® AF has the ability to be cast from solution into a thin film that is transparent and stable to very short wavelength radiation (deep UV). This makes it an excellent candidate for use in pellicles. It has superior electrical properties, particularly for low signal distortion at high frequencies.
- Chemically resistant coating—where its low dielectric constant and low electrical absorption coefficient are important.
- Its moldability plus its low thermal expansion coefficient make it an excellent candidate for connectors.
- It can also be used as a sight window in harsh chemical environment

Chemical Applications

As a fluoroplastic, Teflon® AF has high resistance to chemical attack. Teflon® AF can be fabricated into films, coatings, and smooth surfaced products and also molded into high performance mechanical parts that can function in severe exposure conditions of high temperature, harsh chemicals, and destructive environmental agents. Teflon® AF is an excellent candidate for the demanding and stringent conditions that exist in the electronic, chemical, military, and aerospace industries.

Some specific uses are:

- As a protective coating—where chemical resistance as well as the ability to withstand high temperatures is important: pipes and fittings; conveyor belts; sheets that are in contact with chemicals.
- Chemical containers (for specialty applications)—where it is necessary that the container not react with the contents and optical transmission is important: stopper coatings; bottles (can be shaped).
- Process windows—where the optical properties as well as the chemical inertness are important.
- Membranes and/or separators—the high gas permeability and chemical inertness make it an ideal candidate.
- Its low surface energy makes a good release surface.
- Its high gas permeability makes it an excellent separation medium for gases and liquids.

Safety Precautions

WARNING ! VAPORS CAN BE LIBERATED THAT MAY BE HAZARDOUS IF INHALED.

Before using Teflon® AF, 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 (www.fluoropolymers.org); copies may be obtained from your DuPont representative.

Handling Practices

Teflon® AF resins contain parts per million of residual hexafluoroacetone (HFA). Because HFA hydrates are readily absorbed through the skin, it is necessary to avoid skin contact with the resin during processing. DuPont recommends the use of protective gloves when handling resin during manufacturing operations. Residual gases (including HF, COF₂, CO, and HFA) that may be harmful diffuse from Teflon® AF resins even at room temperature. To avoid exposure, all resin containers should be opened and used only in well ventilated areas using local exhaust ventilation (LEV).

For more information, visit www.teflon.com/industrial

For sales and technical support contacts, visit www.teflon.com/industrialglobalsupport

HOW TO USE THE DUPONT™ TEFLON® BRAND NAME WITH YOUR PRODUCT

Teflon® is a registered trademark of DuPont for our brand of fluoroplastic resins. Customer use of the Teflon® brand name must be licensed by DuPont in association with approved applications. Without a license, customers may not identify their product with the DuPont™ Teflon® brand name.

Unlicensed customers may refer to the DuPont product offering when used as an ingredient in their products by the DuPont product code number and generic descriptor. In this instance, when the product offering is to be sold and used without a license, the customer may refer to the ingredient as **DUPONT™ AF** resin.

If you are interested in applying for a trademark licensing agreement for the DuPont™ Teflon® brand, please contact us at (800) 207-0756 in the US or (302) 996-7906 (outside of the US).

CAUTION: Do not use DuPont materials in medical applications involving permanent implantation in the human body or contact with bodily fluids or tissues unless the material has been provided from DuPont under a written contract that is consistent with DuPont policy regarding medical applications and expressly acknowledges the contemplated use. For further information, please contact your DuPont representative. You may also visit www.teflon.com/industrial to download a copy of the “DuPont POLICY Regarding Medical Applications” H-50103 and “DuPont CAUTION Regarding Medical Applications” H-50102.

For medical emergencies, spills, or other critical situations, call (800) 441-7515 within the United States. For those outside of the United States, call (302) 774-1000.

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