



# Teflon®

Fluoropolymer

## Teflon® 3417B-N PTFE aqueous dispersion

### Typical applications

Teflon® 3417B-N is used for coated glass fabric for high-performance industrial or food conveyor belting and non-adhesive separator sheets for laminating or press blankets requiring high quality surface finish; electrical insulation for wire, printed circuit boards; cast film for capacitors or chemical barriers; and surface coatings for other substrates.

### Description

Teflon® 3417B-N PTFE aqueous is a negatively charged hydrophobic colloid, containing approximately 61 % (by total weight) of 0,05 to 0,5 µm polytetrafluoroethylene (PTFE) resin particles suspended in water. A milky white liquid, it also contains approximately 8,5 % (by weight of PTFE) of a non-ionic wetting agent and stabilizer. Viscosity at room temperature is approximately 40 mPa·s. Nominal pH is 10.

Compared to other grades of PTFE dispersions, Teflon® 3417B-N is especially formulated to provide void-free coatings with enhanced surface smoothness and gloss. It imparts many of the unique properties of PTFE resin to porous structures.

When properly processed, the PTFE resin in Teflon® 3417B-N exhibits the superior properties typical of the fluoropolymer resins: retention of properties after service at 260°C, useful properties at -240°C, chemical inertness to nearly all industrial chemicals and solvents, low friction and non-stick surface. Dielectric properties are outstanding and stable over a wide frequency and temperature range.

### FDA compliance

Properly processed products (sintered at high temperatures common to the industry) made from Teflon® 3417B-N resin can qualify for use in contact with food in compliance with FDA regulation 21 CFR 177.1550 and the German BGA. Articles made from unsintered dispersions do not comply.

### Processing

PTFE resins can not be processed by solvent or melt techniques. A dispersion of PTFE particles provides an alternate method for coating or impregnating various products.

Conventional dip or flow techniques can be used for coating or impregnating various products with DuPont 3417B-N. The resin particles can be consolidated by heat into a coherent matrix such as a coating or left as particles to influence the properties of a finished product.

A continuous PTFE resin coating on woven fabrics can be made by dip coating. Successive passes must be used to build up thickness slowly and without cracks. Teflon® 3417B-N aqueous dispersion provides good rewetting on each pass and void-free buildup suitable for more demanding electrical and chemical service applications. Each coating layer is usually dried to remove water (typically at 120°C), baked to remove the wetting agent (typically at 290°C), sometimes calendered, and finally heated above the crystalline melting point of the resin particles (approximately 337°C). Glass, PTFE, Nomex® aramid fiber, Kevlar® aramid fiber, or other high-temperature resistant fibers must be used.

Products using entrained PTFE resin particles only for their lubricating or hydrophobic properties are dried and baked, but not heated above the crystalline melting point of the particles. For example, rope-like products, such as shaft packings, can be made from braided yarn in a variety of cross sections. The dispersion wets internal surfaces and promotes penetration of the extremely small particles. The unmelted particles are sheared and retained as an impregnant, even when compressed in service and exposed to steam or chemicals. Unmelted particles also can improve flexibility and flex life. High-temperature resistant fibers are not necessarily required in these applications. Other solid or liquid ingredients can be added to Teflon® 3417B-N to provide specific processing or finished product behaviour.

## **Safety precautions**

Industrial experience has proven that adequate ventilation, in properly maintained processing and handling areas, will eliminate known hazards to personnel. Resin containers should be opened and used in well-ventilated areas.

Equipment used to process at melt temperatures should be provided with local exhaust ventilation to completely remove all fumes and vapours from the processing area. In addition, care should be exercised to avoid the contamination of cigarettes and other forms of smoking tobacco when using fluoropolymer resins.

**Dispersion may irritate skin and eyes. Avoid prolonged or repeated contact with skin and eyes. Vapours liberated during processing at elevated temperatures may be harmful.**

Wash hands before eating or smoking. In case of contact, flush with water: for eyes, get medical attention.

Before using fluoropolymer resins, read the Material Safety Data Sheet (MSDS) and the detailed information in "Guide for the safe handling of Fluoropolymer Resins" published by APME. Copies can be obtained through your local DuPont representative.

## **Storage and handling**

The dispersion particles in Teflon® 3417B-N dispersion will settle on prolonged standing or upon heating above 65°C to form a gelatinous layer on the container bottom. This layer can usually be redispersed by mild agitation. Drums may be rolled or the product stirred gently just prior to use. Freezing will cause irreversible settling, therefore the product must be protected against freezing.

Ammonium hydroxide is used by DuPont to set the pH to 10 at the time of shipment. High ambient temperatures can deplete the ammonia level and reduce the pH. Declining pH eventually favors bacterial growth, which causes odor and scum. The pH should be measured and maintained with ammonia between 9,5 to 10.

Both very high and very low temperatures may be detrimental. Dispersions must not be allowed to freeze. The optimum storage temperature range is 7-25°C, with temperatures low in the range preferred. Storage at 7-32°C is acceptable within nominal shelf life for standard dispersions. If dispersions are to be stored for extended periods beyond their nominal shelf life, lower temperature storage is especially desirable because the particles are harder at lower temperatures and are, therefore, less likely to stick together as they settle.

High-speed stirring, pumping, or any other violent agitation must be avoided to minimize sheared particles or coagulation and to minimize foaming. Ideally, the dispersion should be conveyed by gravity from storage to processing stations.

Storage and handling areas should be clean. Keep dispersion containers closed and clean to avoid both contamination and coagulation by drying at the liquid surface. High processing temperatures can cause even very small foreign particles to either be visible or become defects in finished products. Good housekeeping and careful handling are essential at all times.

## **Packaging**

Teflon® 3417-N PTFE aqueous dispersion is packaged in 30 litre drums and 1000 litre containers.

## Typical Property Data for Teflon® 3417B-N

Property	Test method <sup>1)</sup>		Unit	Typical value
<b>General</b>				
Solids content (% PTFE by weight)	ISO 12086	D 4441	%	61
Density of dispersion (at 61 % solids)	ISO 8962	D 4441	g/cm <sup>3</sup>	1,52
Resin dry weight (at 61 % solids)		DuPont	g/l	927
Dispersion particle size, average diameter		DuPont	µm	0,210
pH of dispersion	ISO 1148	E 70		10,0
Brookfield viscosity (at 25°C)	ISO 2555	D 2196	mPa·s	40
Standard specific gravity of sintered resin	ISO 12086			2,220
<b>Thermal</b>				
Melting, peak temperature	ISO 12086	D 4591/D 3418		
Initial			°C	337
Second			°C	327
<b>Other</b>				
Water absorption		D 570	%	< 0,01
Weather and chemical resistance				Excellent

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

<sup>1)</sup> ASTM unless otherwise specified.

### For further information contact:

#### Deutschland

Du Pont de Nemours (Deutschland) GmbH  
DuPont Straße 1  
D-61343 Bad Homburg  
Tel. (06172) 87 0  
Telefax (06172) 87 13 18

#### France

Du Pont de Nemours (France) S.A.  
137, rue de l'Université  
F-75334 Paris Cedex 07  
Tel. 01 45 50 65 50  
Telefax 01 45 50 61 51

#### Italia

Du Pont de Nemours Italiana S.p.A.  
Via A. Volta, 16  
I-20093 Cologno Monzese (Mi)  
Tel. (02) 25 30 21  
Telefax (02) 25 47 765

#### Nederland

Du Pont de Nemours (Nederland) B.V.  
Baanhoekweg 22  
NL-3313 LA Dordrecht  
Tel. (078) 630 10 11  
Telefax (078) 630 16 77

#### United Kingdom

Du Pont (U.K.) Limited  
Maylands Avenue  
GB-Hemel Hempstead,  
Herts. HP2 7DP  
Tel. (01442) 21 85 00  
Telefax (01442) 21 85 75

Requests for further information from countries not listed above should be sent to:

#### Du Pont de Nemours International S.A.

2, chemin du Pavillon  
CH-1218 Le Grand-Saconnex, Geneva  
Tel. (022) 717 51 11  
Telefax (022) 717 54 11

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