



Designation: D3275 – 18 (Reapproved 2023)

Standard Classification System for E-CTFE-Fluoroplastic Molding, Extrusion, and Coating Materials¹

This standard is issued under the fixed designation D3275; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope

1.1 This classification system covers melt processible molding, extrusion, and coating materials of ethylene-chlorotrifluoroethylene (E-CTFE) fluoroplastics. The resin is a copolymer of ethylene and chlorotrifluoroethylene containing approximately 80 weight % of chlorotrifluoroethylene.

1.2 The values stated in SI units, as detailed in [IEEE/ASTM SI-10](#), are to be regarded as standard.

1.3 The following precautionary statement pertains only to the test methods portion, Section 11 of this classification system. *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

NOTE 1—Although this classification system and ISO 20568-1 and ISO 20568-2 differ in approach or detail, data obtained using either are technically equivalent.

1.4 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 ASTM Standards:²

- [D150](#) Test Methods for AC Loss Characteristics and Permittivity (Dielectric Constant) of Solid Electrical Insulation
- [D618](#) Practice for Conditioning Plastics for Testing

¹ This classification system is under the jurisdiction of ASTM Committee D20 on Plastics and is the direct responsibility of Subcommittee D20.15 on Thermoplastic Materials

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

- [D638](#) Test Method for Tensile Properties of Plastics
- [D792](#) Test Methods for Density and Specific Gravity (Relative Density) of Plastics by Displacement
- [D883](#) Terminology Relating to Plastics
- [D1238](#) Test Method for Melt Flow Rates of Thermoplastics by Extrusion Plastometer
- [D1600](#) Terminology for Abbreviated Terms Relating to Plastics
- [D1708](#) Test Method for Tensile Properties of Plastics by Use of Microtensile Specimens
- [D2863](#) Test Method for Measuring the Minimum Oxygen Concentration to Support Candle-Like Combustion of Plastics (Oxygen Index)
- [D3892](#) Practice for Packaging/Packing of Plastics
- [D4591](#) Test Method for Determining Temperatures and Heats of Transitions of Fluoropolymers by Differential Scanning Calorimetry
- [IEEE/ASTM SI-10](#) Use of the International System of Units (SI): The Modern Metric System

2.2 ISO Standards:³

- [ISO 20568-1](#) Plastics—Fluoropolymer Dispersion and Moulding and Extrusion Materials—Part 1: Designation and Basis for Specification
- [ISO 20568-2](#) Plastics—Fluoropolymer Dispersion and Moulding and Extrusion Materials—Part 2: Preparation of Test Specimens and Determination of Properties

3. Terminology

3.1 Definitions:

3.1.1 Definitions of terms used in this classification system shall be in accordance with Terminology [D883](#).

3.1.2 *lot, n*—one production run or a uniform blend of two or more production runs.

3.2 Abbreviations:

3.2.1 Abbreviations are in accordance with Terminology [D1600](#).

³ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

*A Summary of Changes section appears at the end of this standard

4. Classification

4.1 ECTFE materials are classified into groups in accordance with their physical appearance. The groups are further divided into classes based on melt flow rate. These classes are

subdivided into grades as shown in the Table E-CTFE. An example of a material of this classification system is given as follows: ECTFE 01 1 1

TABLE E-CTFE

Group	Class	Description	Grade	Melt Flow Rate, ^{A,B} g/10 min	Specific Gravity, ^C 23/23°C	Tensile Strength, ^{D,E} min, MPa	Elongation, ^F min, %	Melting Point, °C, ^G min	Oxygen Index, ^H min, %	Dielectric Constant, ^I max, 10 ⁶ Hz	Dissipation Factor, ^J max, 10 ⁶ Hz
01 powder	1	Low melt flow rate	1	0.05–1.50	1.65–1.71	40	200	240	52	2.6	0.015
	2	Medium melt flow rate	1	1.51–6.0	1.65–1.71	40	200	240	52	2.6	0.015
	3	High melt flow rate	1	6.1–25	1.65–1.71	40	200	240	52	2.6	0.015
	0	Other	0								
02 pellet	1	Low melt flow rate	1	0.05–1.50	1.65–1.71	40	200	240	52	2.6	0.015
	2	Medium melt flow rate	1	1.51–6.0	1.65–1.71	40	200	240	52	2.6	0.015
	3	High melt flow rate	1	6.1–25	1.65–1.71	40	200	240	52	2.6	0.015
	4	Ultra Low melt flow rate	1	0.8–1.3	1.65–1.71	40	200	220	52	2.6	0.015
	0	Other	0								
00	0	Other	0								

^A See 11.2 for test method for above parameters.

^B See 11.2 for test method for group 2 class 4 grade 1 replace 2.16 kg mass with 5 kg mass.

^C See 11.4 for test method for above parameters.

^D See 11.5 for test method for above parameters.

^E At 23 ± 2°C (73.4 ± 3.6°F).

^F See 11.5 for test method for above parameters.

^G See 11.3 for test method for above parameters.

^H See 11.7 for test method for above parameters.

^I See 11.6 for test method for above parameters.

^J See 11.6 for test method for above parameters.

where:

01 = ECTFE powder

1 = low melt flow

2 = properties in accordance with Table E-CTFE (Grade 1)

4.1.1 To facilitate incorporation of future material, the other category for Group (00), Class (0) and Grade (0) are shown in Table E-CTFE.

5. Ordering Information

5.1 The purchase order or inquiry for these materials shall state the classification callout. For example, D3275 ECTFE 01 1 2.

6. General Requirements

6.1 The material covered by this classification system shall conform to the requirements prescribed in Table E-CTFE when tested by the procedures specified herein.

7. Detail Requirements

7.1 Test specimens prepared in accordance with Section 10 shall conform to the requirements prescribed for the particular class.

8. Sampling

8.1 Sampling must be statistically adequate to satisfy the requirements of 12.4.

9. Number of Tests

9.1 One set of test specimens as prescribed in Section 11 shall be considered sufficient for testing each sample. The average result of the specimens tested shall conform to the requirements of this classification system.

10. Specimen Preparation

10.1 Test Specimens:

10.1.1 Prepare test moldings 3.18 ± 0.3 mm (0.125 ± 0.012 in.) thick between two 0.38 to 0.51 mm (0.015 to 0.020 in.) thick chromium-plated ferrotype plates. Use a “picture frame” type compression molding chase with inner dimensions of 178 by 178 mm (7 by 7 in.) and having a thickness suitable to produce the required molded sheet. Use a charge of resin sufficient to provide the thickness sheet specified.

10.1.2 Place the mold chase on top of a chromium-plated ferrotype plate. Charge a quantity of resin sufficient to produce a 3.18 ± 0.30-mm (0.125 ± 0.012-in.) sheet in a diagonal pattern from corner to corner forming an “X” pattern. Place the other chromium-plated ferrotype plate on top of the resin charge and place the assembly in a compression molding press which has been heated to 264 ± 3°C (507 ± 5.4°F). Apply a pressure of 0.34 MPa (50 psi) and hold for 4 min. Increase pressure to 1.72 MPa (250 psi) and hold for 1 min followed by increasing the pressure to not less than 2.24 MPa (325 psi) and