Delrin® RAFG500P NC010

ACETAL RESIN

Common features of Delrin® acetal resins include mechanical and physical properties such as high mechanical strength and rigidity, excellent fatigue and impact resistance, as well as resistance to moisture, gasoline, lubricants, solvents, and many other neutral chemicals. Delrin® acetal resins also have excellent dimensional stability and good electrical insulating characteristics. They are naturally resilient, self-lubricating, and available in a variety of colors and speciality grades.

Delrin® acetal resin typically is used in demanding applications in the automotive, domestic appliances, sports, industrial engineering, electronics, and consumer goods industries.

Delrin® RAFG500P is a general purpose medium viscosity acetal homopolymer for injection moulding, with reduced lifecycle greenhouse gas emissions and lower fossil resource use. Delrin® RAFG500P has improved processing thermal stability and a good combination of mechanical properties. It has been developed for applications in contact with food.

Delrin® Renewable Attributed base polymer is produced from 100% bio-feedstock from waste*. 100% certified renewable electricity is used for its production.
This approach helps customers in achieving their sustainability goals.

* according to ISCC Plus mass balance certification.

FOOD CONTACT

This product is manufactured according to Good Manufacturing Practice (GMP) principles and generally accepted in food contact applications in Europe and the USA when meeting applicable use conditions. For details, individual compliance statements are available from your Delrin representative.

Product information

Resin Identification	POM	ISO 1043
Part Marking Code	>POM<	ISO 11469

Rheological properties

Melt volume-flow rate	13	cm³/10min	ISO 1133
Melt mass-flow rate	15	g/10min	ISO 1133
Temperature	190	°C	ISO 1133
Load	2.16	kg	ISO 1133
Melt mass-flow rate, Temperature	190	°C	ISO 1133
Melt mass-flow rate, Load	2.16	kg	ISO 1133
Moulding shrinkage, parallel	2.0	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.9	%	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	3100	MPa	ISO 527-1/-2
Yield stress	71	MPa	ISO 527-1/-2
Yield strain	17	%	ISO 527-1/-2
Nominal strain at break	30	%	ISO 527-1/-2

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Flexural Modulus	2900	MPa	ISO 178
Flexural Stress at 3.5%	80	MPa	ISO 178
Tensile creep modulus, 1h	2800	MPa	ISO 899-1
Tensile creep modulus, 1000h	1600	MPa	ISO 899-1
Charpy impact strength, 23°C	300	kJ/m²	ISO 179/1eU
Charpy impact strength, -30°C	280	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	9	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	8	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -40°C	8	kJ/m²	ISO 179/1eA
Izod notched impact strength, 23°C	9	kJ/m²	ISO 180/1A
Izod notched impact strength, -30°C	8	kJ/m²	ISO 180/1A
Hardness, Rockwell, M-scale	92		ISO 2039-2
Hardness, Rockwell, R-scale	120		ISO 2039-2
Poisson's ratio	0.37		

Thermal properties

Melting temperature, 10°C/min	178	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	93	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	158	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h, 50N	155	°C	ISO 306
Coeff. of linear therm. expansion, parallel	110	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	110	E-6/K	ISO 11359-1/-2
RTI, electrical, 0.75mm	50	°C	UL 746B
RTI, electrical, 1.5mm	110	°C	UL 746B
RTI, electrical, 3mm	110	°C	UL 746B
RTI, impact, 0.75mm	50	°C	UL 746B
RTI, impact, 1.5mm	85	°C	UL 746B
RTI, impact, 3mm	90	°C	UL 746B
RTI, strength, 0.75mm	50	°C	UL 746B
RTI, strength, 1.5mm	90	°C	UL 746B
RTI, strength, 3mm	95	°C	UL 746B

Flammability

Burning Behav. at 1.5mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	IEC 60695-11-10
UL recognition	yes		UL 94
Burning Behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.75	mm	IEC 60695-11-10
UL recognition	yes		UL 94

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Other properties

Humidity absorption, 2mm	0.4	%	Sim. to ISO 62
Water absorption, 2mm	1.4	%	Sim. to ISO 62
Density	1420	kg/m³	ISO 1183

VDA Properties

Emissions	<8	mg/kg	VDA 275
Emission of organic compounds	3.1	µgC/g	VDA 277
Fogging, F-value (refraction)	90	%	ISO 6452
Fogging, G-value (condensate)	0.35	mg	ISO 6452

Injection

Drying Recommended	yes	
Drying Temperature	80	°C
Drying Time, Dehumidified Dryer	2 - 4	h
Processing Moisture Content	≤0.2	%
Melt Temperature Optimum	215	°C
Min. melt temperature	210	°C
Max. melt temperature	220	°C
Max. screw tangential speed	0.3	m/s
Mold Temperature Optimum	90	°C
Min. mould temperature	80	°C
Max. mould temperature	100	°C
Hold pressure range	80 - 100	MPa
Hold pressure time	8	s/mm

Characteristics

Additives	Release agent, Biobased

Additional information

Injection molding

Drying is recommended, but not necessary for newly opened packaging stored in a dry location.

Follow the drying guidelines above in the following cases:

- If moisture is above the Processing Moisture Content recommendation,
- When a resin container is damaged,
- When the material is not properly stored in a dry place at room temperature, or
- When packaging stays open for a significant time.

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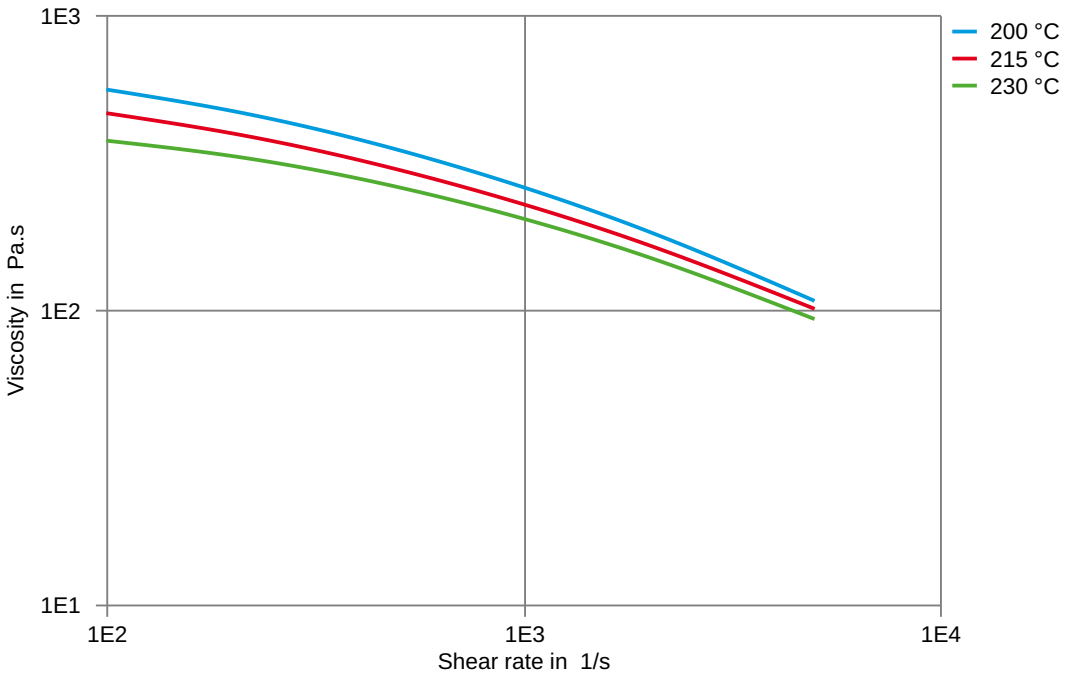
Viscosity-shear rate



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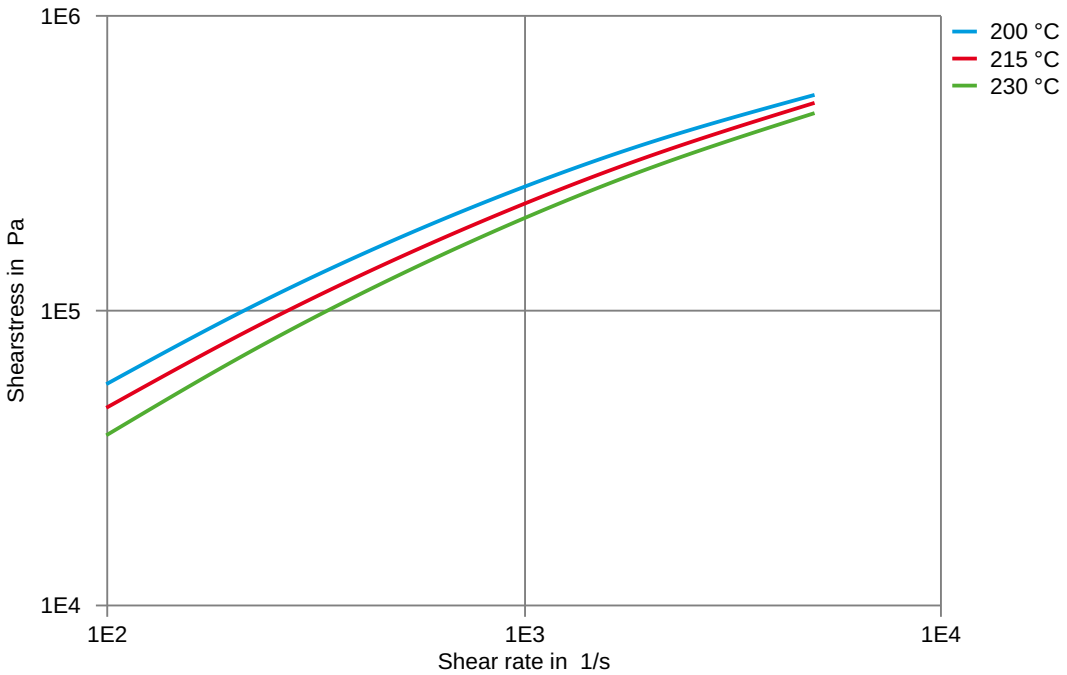
Shearstress-shear rate



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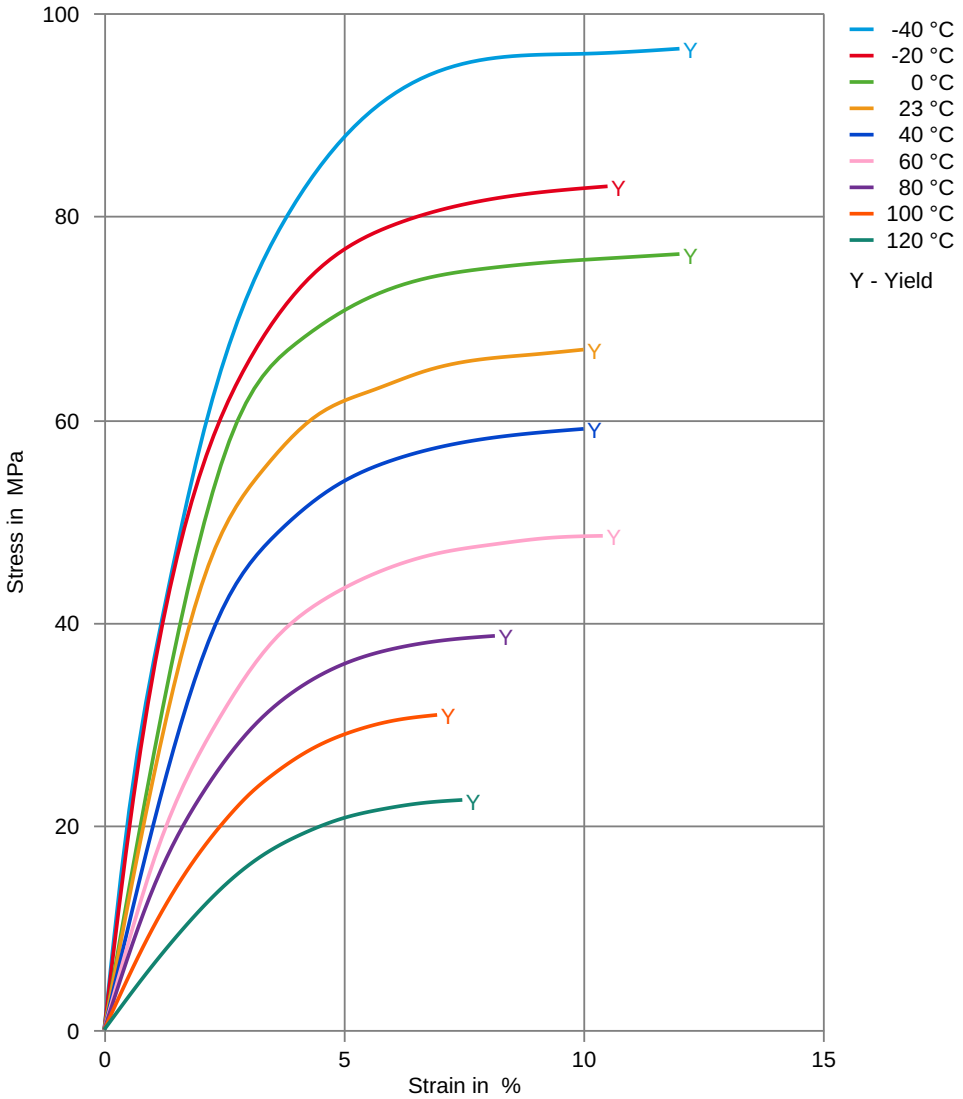
Stress-strain



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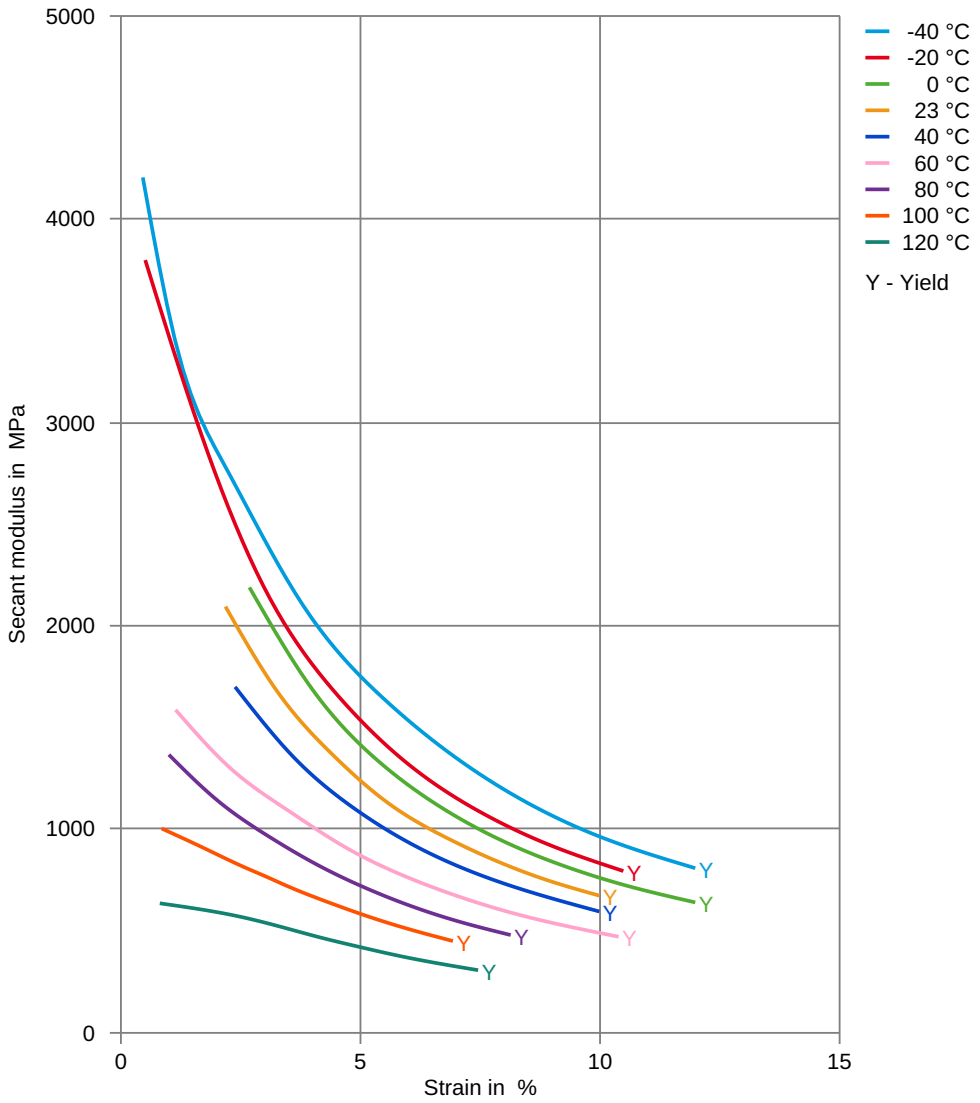
Secant modulus-strain



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Chemical Media Resistance

Acids

- ✔ Acetic Acid (5% by mass), 23°C
- ✘ Citric Acid solution (10% by mass), 23°C
- ✘ Lactic Acid (10% by mass), 23°C
- ✘ Hydrochloric Acid (36% by mass), 23°C
- ✘ Nitric Acid (40% by mass), 23°C
- ✘ Sulfuric Acid (38% by mass), 23°C
- ✘ Sulfuric Acid (5% by mass), 23°C
- ✘ Chromic Acid solution (40% by mass), 23°C

Bases

- ✘ Sodium Hydroxide solution (35% by mass), 23°C
- ✘ Sodium Hydroxide solution (1% by mass), 23°C
- ✘ Ammonium Hydroxide solution (10% by mass), 23°C

Alcohols

- ✔ Isopropyl alcohol, 23°C
- ✔ Methanol, 23°C
- ✔ Ethanol, 23°C

Hydrocarbons

- ✔ n-Hexane, 23°C
- ✔ Toluene, 23°C
- ✔ iso-Octane, 23°C

Ketones

- ✔ Acetone, 23°C

Ethers

- ✔ Diethyl ether, 23°C

Mineral oils

- ✔ SAE 10W40 multigrade motor oil, 23°C
- ✘ SAE 10W40 multigrade motor oil, 130°C
- ✘ SAE 80/90 hypoid-gear oil, 130°C
- ✔ Insulating Oil, 23°C

Standard Fuels

- ✔ ISO 1817 Liquid 1 - E5, 60°C
- ✔ ISO 1817 Liquid 2 - M15E4, 60°C
- ✔ ISO 1817 Liquid 3 - M3E7, 60°C
- ✔ ISO 1817 Liquid 4 - M15, 60°C
- ✔ Standard fuel without alcohol (pref. ISO 1817 Liquid C), 23°C
- ✔ Standard fuel with alcohol (pref. ISO 1817 Liquid 4), 23°C
- ✔ Diesel fuel (pref. ISO 1817 Liquid F), 23°C
- ✘ Diesel fuel (pref. ISO 1817 Liquid F), 90°C
- ✘ Diesel fuel (pref. ISO 1817 Liquid F), >90°C

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Salt solutions

- ✔ Sodium Chloride solution (10% by mass), 23°C
- ✘ Sodium Hypochlorite solution (10% by mass), 23°C
- ✘ Sodium Carbonate solution (20% by mass), 23°C
- ✘ Sodium Carbonate solution (2% by mass), 23°C
- ✘ Zinc Chloride solution (50% by mass), 23°C

Other

- ✔ Ethyl Acetate, 23°C
- ✘ Hydrogen peroxide, 23°C
- ✘ DOT No. 4 Brake fluid, 130°C
- ✘ Ethylene Glycol (50% by mass) in water, 108°C
- ✔ 1% nonylphenoxy-polyethyleneoxy ethanol in water, 23°C
- ✔ 50% Oleic acid + 50% Olive Oil, 23°C
- ✔ Water, 23°C
- ✘ Water, 90°C
- ✘ Phenol solution (5% by mass), 23°C

Symbols used:

✔ possibly resistant
Defined as: Supplier has sufficient indication that contact with chemical can be potentially accepted under the intended use conditions and expected service life. Criteria for assessment have to be indicated (e.g. surface aspect, volume change, property change).

✘ not recommended - see explanation
Defined as: Not recommended for general use. However, short-term exposure under certain restricted conditions could be acceptable (e.g. fast cleaning with thorough rinsing, spills, wiping, vapor exposure).