Delrin® RA100CPE NC010

ACETAL RESIN

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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® RA100CPE is a high viscosity acetal homopolymer for use in easy-to-fill moulds with very low VOC emissions. Delrin® RA100CPE provides optimum mechanical performance with its excellent combination of toughness and strength with improved processing, thermal stability and productivity for injection moulding.

Delrin® Renewable Attributed base polymer is produced from 100% bio-feedstock from waste*.
This approach helps customers in achieving their sustainability goals.

* according to ISCC Plus mass balance certification.

Product information

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

Rheological properties

Melt volume-flow rate	1.9	cm³/10min	ISO 1133
Melt mass-flow rate	2.3	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	2.2	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.9	%	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	2900	MPa	ISO 527-1/-2
Yield stress	71	MPa	ISO 527-1/-2
Yield strain	28	%	ISO 527-1/-2
Nominal strain at break	45	%	ISO 527-1/-2
Flexural Modulus	2800	MPa	ISO 178
Flexural Stress at 3.5%	76	MPa	ISO 178

Delrin® RA100CPE NC010

ACETAL RESIN

Charpy impact strength, 23°C	N	kJ/m²	ISO 179/1eU
Charpy impact strength, -30°C	450	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	16	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	13	kJ/m²	ISO 179/1eA
Hardness, Rockwell, M-scale	90	-	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	95	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	160	°C	ISO 75-1/-2
CLTE, Parallel, -40-23°C	95	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, parallel	110	E-6/K	ISO 11359-1/-2
CLTE, Normal, -40-23°C	100	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	100	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	0.8	mm	IEC 60695-11-10
UL recognition	yes	-	UL 94
FMVSS Class	B	-	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	25	mm/min	ISO 3795 (FMVSS 302)

Electrical properties

Relative permittivity, 100Hz	4.1	-	IEC 62631-2-1
Relative permittivity, 1MHz	4	-	IEC 62631-2-1
Dissipation factor, 100Hz	25	E-4	IEC 62631-2-1
Dissipation factor, 1MHz	45	E-4	IEC 62631-2-1
Volume resistivity	>1E13	Ohm.m	IEC 62631-3-1
Surface resistivity	6E14	Ohm	IEC 62631-3-2
Comparative tracking index	600	-	IEC 60112

Delrin® RA100CPE NC010

ACETAL RESIN

Other properties

Humidity absorption, 2mm	0.1	%	Sim. to ISO 62
Water absorption, 2mm	1	%	Sim. to ISO 62
Density	1420	kg/m³	ISO 1183
Density of melt	1180	kg/m³	

VDA Properties

Emissions	<2	mg/kg	VDA 275
Emission of organic compounds	0.3	µgC/g	VDA 277
Thermal desorption analysis of organic emissions	0.6	µg/g	VDA 278
Fogging, F-value (refraction)	81	%	ISO 6452
Fogging, G-value (condensate)	1	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	205	°C
Min. melt temperature	200	°C
Max. melt temperature	210	°C
Max. screw tangential speed	0.2	m/s
Mold Temperature Optimum	90	°C
Min. mould temperature	80	°C
Max. mould temperature	100	°C
Hold pressure range	90 - 110	MPa
Hold pressure time	8	s/mm
Annealing time, optional	30[1]	min/mm
Annealing temperature	160	°C

[1]: 30 min + 5 min/mm of thickness

Extrusion

Drying Temperature	75 - 85	°C
Drying Time, Dehumidified Dryer	2 - 4	h
Processing Moisture Content	≤0.2	%
Melt Temperature Optimum	200	°C
Melt Temperature Range	195 - 205	°C

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:

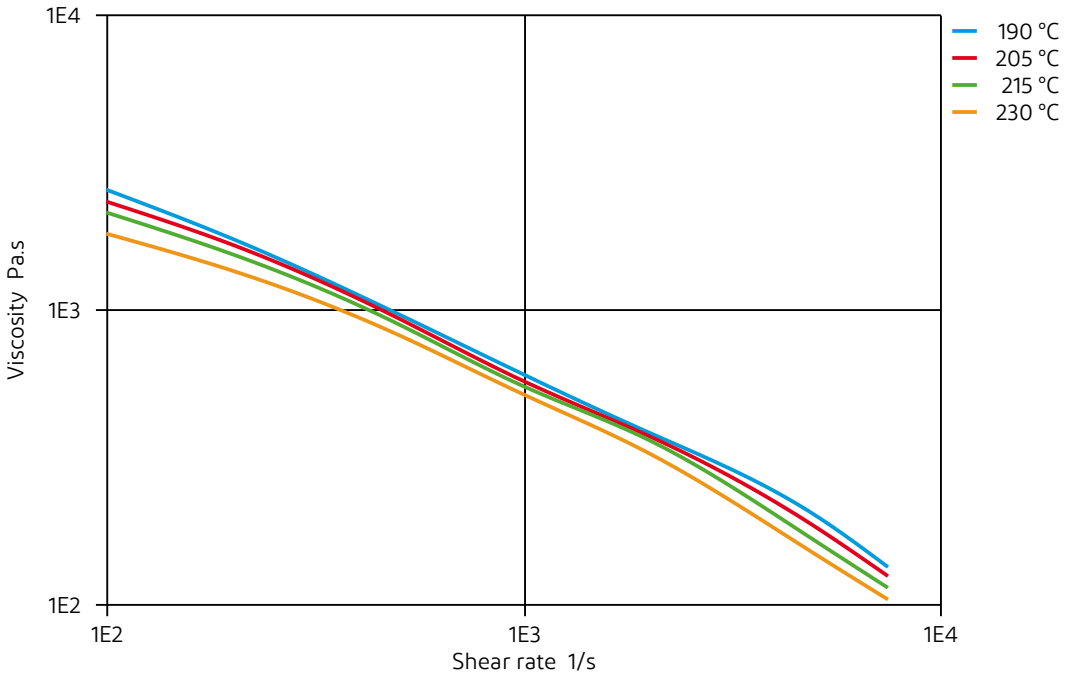
- If moisture is above the Processing Moisture Content recommendation,
- When a resin container is damaged,

Delrin® RA100CPE NC010

ACETAL RESIN

- When the material is not properly stored in a dry place at room temperature, or
- When packaging stays open for a significant time.

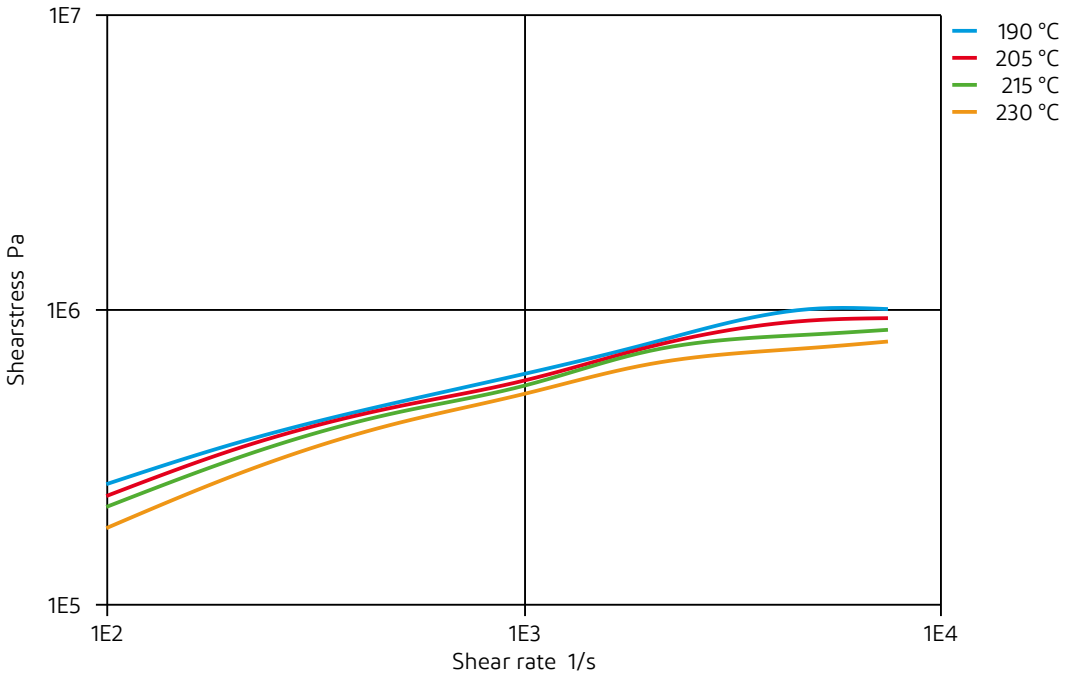
Viscosity-shear rate



Delrin® RA100CPE NC010

ACETAL RESIN

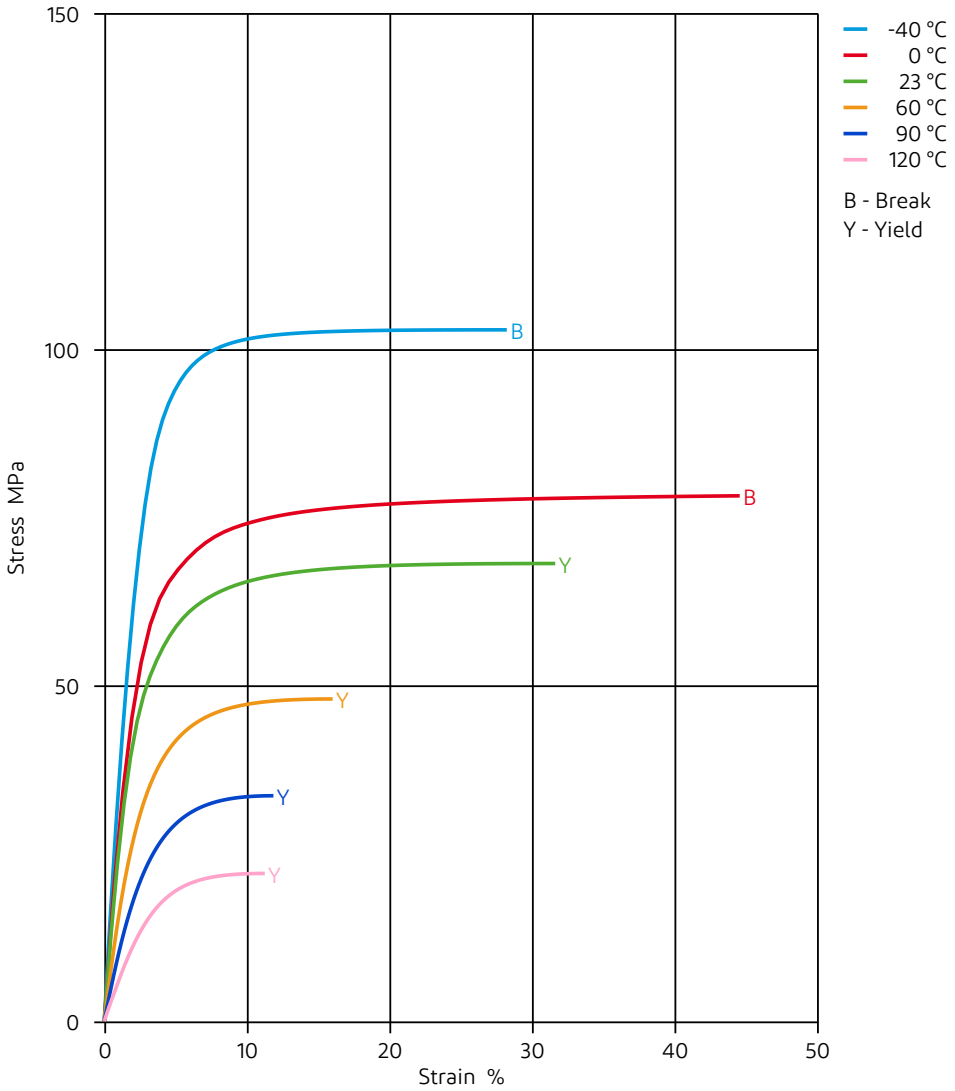
Shearstress-shear rate



Delrin® RA100CPE NC010

ACETAL RESIN

Stress-strain



Delrin® RA100CPE NC010

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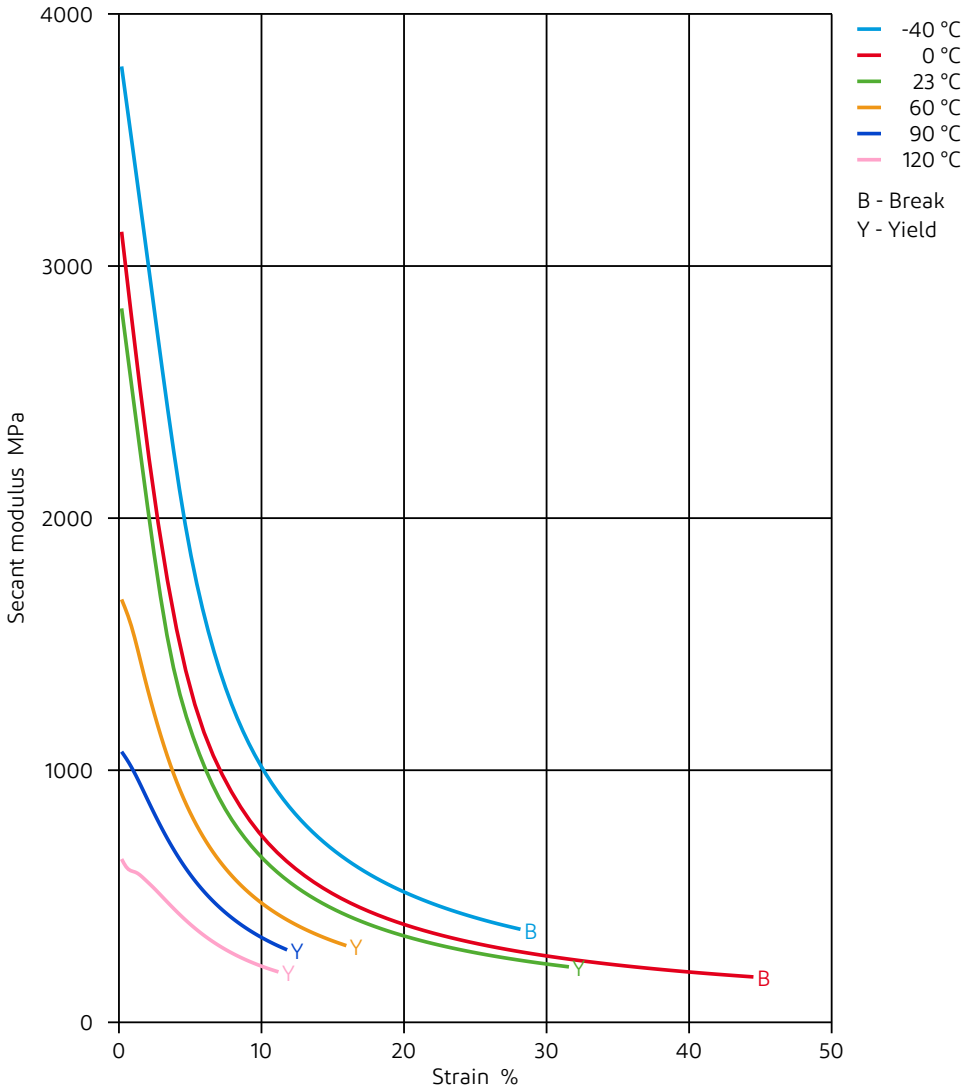
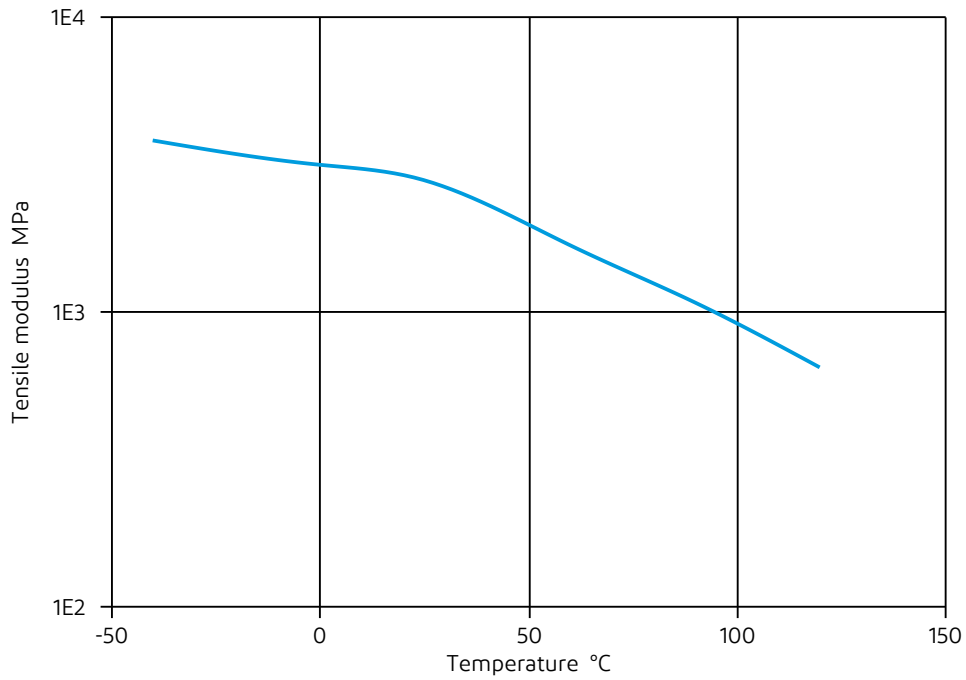
Secant modulus-strain



Delrin® RA100CPE NC010

ACETAL RESIN

Tensile modulus-temperature



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