

# DuPont™ Delrin® PC650 NC010

## ACETAL RESIN

### Product Information

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® PC650 is a medium viscosity acetal homopolymer, developed for parts requiring high precision molding in the healthcare industry.**

### PREMIUM CONTROL for HEALTHCARE APPLICATIONS

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. This product is also tested against ISO 10993-5 and -11 and selected parts of USP Class VI and US FDA drug and device master files (DMF and MAF) have been established. For details, individual compliance statements are available from your DuPont representative.

General information	Value	Unit	Test Standard
Resin Identification	POM	-	ISO 1043
Part Marking Code	POM	-	ISO 11469
Rheological properties	Value	Unit	Test Standard
Melt volume-flow rate	13	cm <sup>3</sup> /10min	ISO 1133
Temperature	190	°C	ISO 1133
Load	2.16	kg	ISO 1133
Melt mass-flow rate	15	g/10min	ISO 1133
Molding shrinkage, parallel	2.0	%	ISO 294-4, 2577
Molding shrinkage, normal	1.9	%	ISO 294-4, 2577
Mechanical properties	Value	Unit	Test Standard
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
Flexural Modulus	2950	MPa	ISO 178
Flexural Stress at 3.5%	80	MPa	ISO 178
Tensile creep modulus			ISO 899-1
1h	2800	MPa	
1000h	1600	MPa	
Charpy impact strength			ISO 179/1eU
73°F	320	kJ/m <sup>2</sup>	
-22°F	280	kJ/m <sup>2</sup>	
Charpy notched impact strength			ISO 179/1eA
73°F	9	kJ/m <sup>2</sup>	
-22°F	8	kJ/m <sup>2</sup>	
Puncture - maximum force, 73°F	2000	N	ISO 6603-2
Puncture energy, 73°F	3	J	ISO 6603-2
Izod notched impact strength			ISO 180/1A
73°F	9	kJ/m <sup>2</sup>	
-22°F	8	kJ/m <sup>2</sup>	
Izod impact strength			ISO 180/1U
73°F	280	kJ/m <sup>2</sup>	
-22°F	250	kJ/m <sup>2</sup>	
Hardness, Rockwell, M-scale	92	-	ISO 2039-2
Hardness, Rockwell, R-scale	120	-	ISO 2039-2
Thermal properties	Value	Unit	Test Standard
Melting temperature, 18°F/min	178	°C	ISO 11357-1/-3

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North America

Asia Pacific

Europe/Middle East/Africa

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Temp. of deflection under load			ISO 75-1/-2
260 psi	95	°C	
65 psi	160	°C	
Vicat softening temperature, 90°F/h, 11 lbf	155	°C	ISO 306
Ball pressure test	165	°C	IEC 60309
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			UL 746B
30mil	50	°C	
60mil	110	°C	
120mil	110	°C	
RTI, impact			UL 746B
30mil	50	°C	
60mil	85	°C	
120mil	90	°C	
RTI, strength			UL 746B
30mil	50	°C	
60mil	90	°C	
120mil	95	°C	
<b>Electrical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Relative permittivity			IEC 62631-2-1
100Hz	3.8	-	
1MHz	3.8	-	
Dissipation factor			IEC 62631-2-1
100Hz	90	E-4	
1MHz	55	E-4	
Volume resistivity	2E12	Ohm*m	IEC 62631-3-1
Surface resistivity	4E14	Ohm	IEC 62631-3-2
Electric strength	44	kV/mm	IEC 60243-1
Comparative tracking index	600	-	IEC 60112
<b>Other properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Humidity absorption, 80mil	0.3	%	Sim. to ISO 62
Water absorption, 80mil	1.4	%	Sim. to ISO 62
Density	1420	kg/m <sup>3</sup>	ISO 1183
<b>VDA Properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Emissions	<8	mg/kg	VDA 275
Fogging, F-value (refraction)	90	%	ISO 6452
Fogging, G-value (condensate)	0.35	mg	ISO 6452
<b>Injection</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
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	-
Mold Temperature Optimum	90	°C	-
Min. mold temperature	80	°C	-
Max. mold temperature	100	°C	-
Hold pressure range	80 - 100	MPa	-
Hold pressure time	8	s/mm	-
Annealing time, optional	30	min/mm	-
Annealing temperature	160	°C	-

### Characteristics

Processing • Injection Molding

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Delivery form  
Additives

- Pellets
- Lubricants

- Release agent

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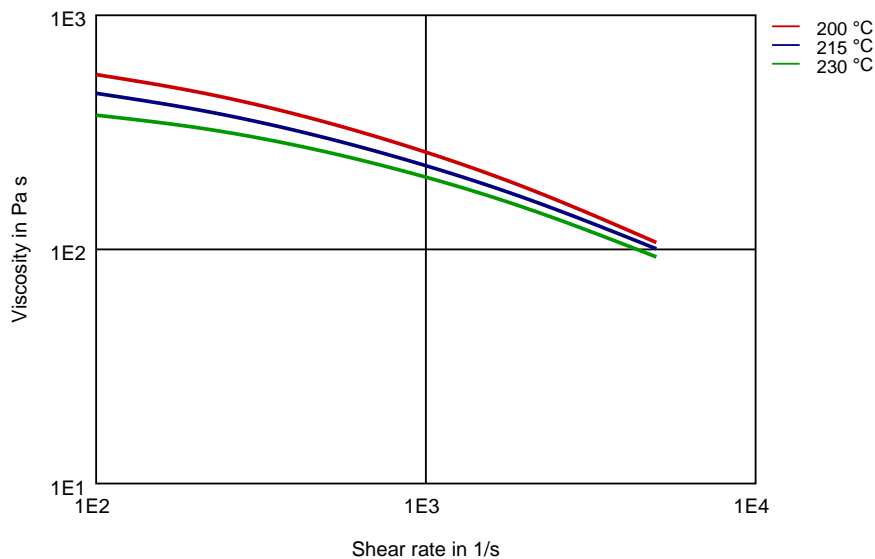


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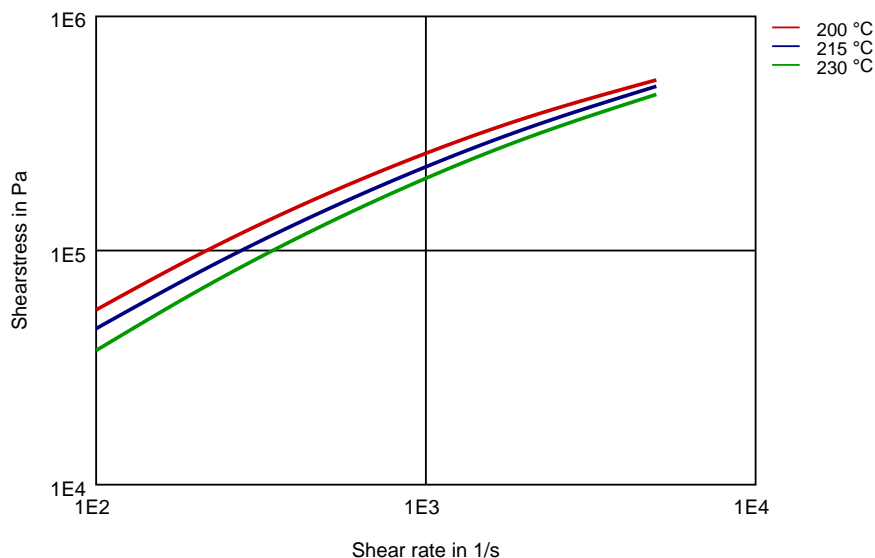
## ACETAL RESIN

### Diagrams

#### Viscosity-shear rate



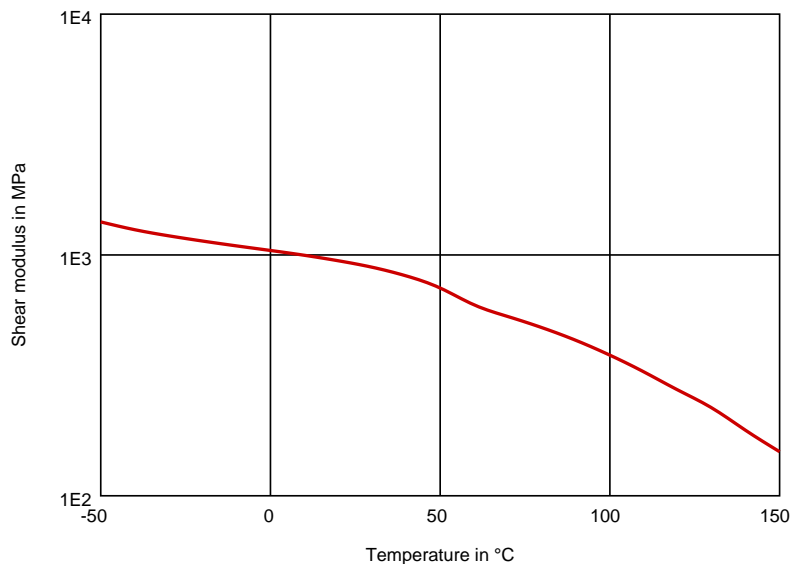
#### Shearstress-shear rate



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## ACETAL RESIN

Dynamic Shear modulus-temperature



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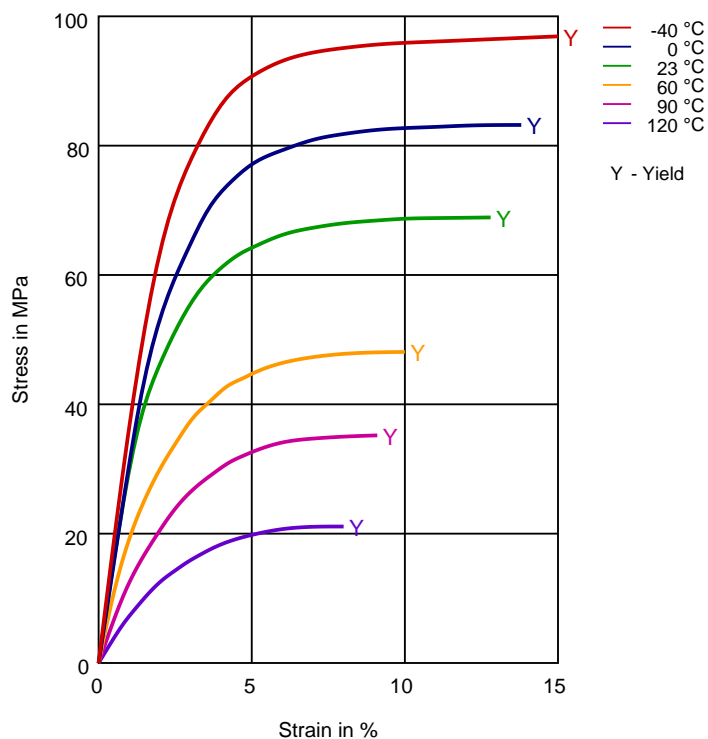
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Stress-strain



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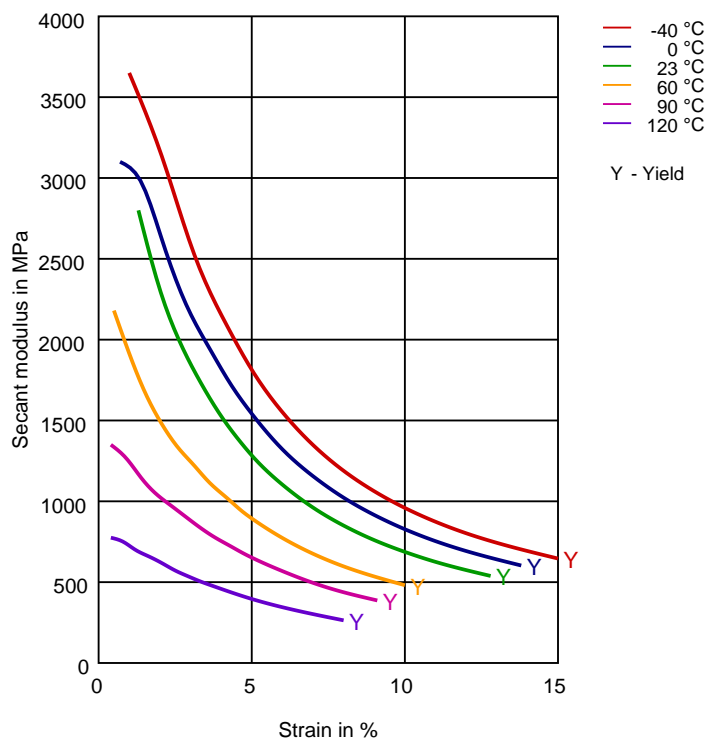
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## ACETAL RESIN

Secant modulus-strain



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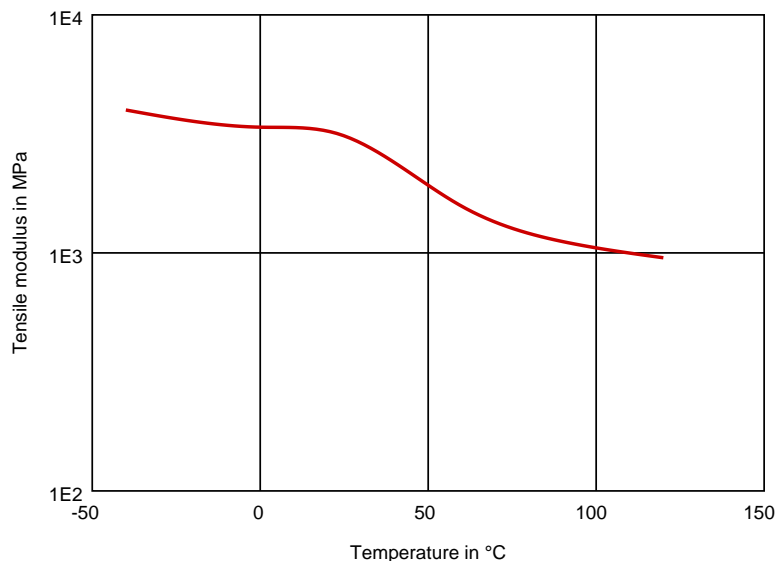
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## ACETAL RESIN

Tensile modulus-temperature



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### Chemical Media Resistance

### Sterilization methods

✓ Ethylene Oxide

#### 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).

Contact DuPont for Material Safety Data Sheet, general guides and/or additional information about ventilation, handling, purging, drying, etc. ISO Mechanical properties measured at 160 mil (Hytrel® measured at 80 mil), IEC Electrical properties measured at 80 mil, all ASTM properties measured at 120 mil, and test temperatures are 73°F unless otherwise stated.

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