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Standard Test Method for Measurement of Enthalpy of Fusion, Percent Crystallinity, and Melting Point of Ultra-High-Molecular Weight Polyethylene by Means of Differential Scanning Calorimetry¹

This standard is issued under the fixed designation F2625; 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.

1. Scope

1.1 This test method discusses the measurement of the heat of fusion and the melting point of ultra-high-molecular weight polyethylene (UHMWPE), and the subsequent calculation of the percentage of crystallinity.

1.2 This test method can be used for UHMWPE in powder form, consolidated form, finished product, or a used product. It can also be used for irradiated or chemically-crosslinked UHMWPE.

1.3 This test method does not suggest a desired range of crystallinity or melting points for specific applications.

1.4 The values stated in SI units are to be regarded as standard. No other units of measurement are included in this standard.

1.5 *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 and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 *ASTM Standards:*²

[D3418 Test Method for Transition Temperatures and Enthalpies of Fusion and Crystallization of Polymers by Differential Scanning Calorimetry](#)

[E691 Practice for Conducting an Interlaboratory Study to Determine the Precision of a Test Method](#)

[E793 Test Method for Enthalpies of Fusion and Crystallization by Differential Scanning Calorimetry](#)

[E967 Test Method for Temperature Calibration of Differential Scanning Calorimeters and Differential Thermal Analyzers](#)

[E968 Practice for Heat Flow Calibration of Differential Scanning Calorimeters](#)

[E1953 Practice for Description of Thermal Analysis and Rheology Apparatus](#)

3. Terminology

3.1 *Symbols:*

3.1.1 $\Delta H_f, n$ —theoretical heat of fusion of 100 % crystalline material (J/g).

3.1.2 $\Delta H_s, n$ —mass normalized heat of fusion of the test sample (J/g).

3.1.3 T_p, n —melting temperature at the peak of the melting endotherm (°C).

3.1.4 T_o, n —onset temperature of the melting endotherm (°C).

3.1.5 %X, n—percentage of crystallinity of material.

4. Summary of Test Method

4.1 This test method consists of placing a known mass of UHMWPE in a sample pan and heating the sample pan at a controlled temperature while measuring the heat flow to the sample pan and an empty reference pan. The area under the melting endotherm,

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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.

indicative of the enthalpy of melting, is normalized with the sample mass. This value is then normalized with the theoretical enthalpy of melting of 100 % crystalline polyethylene to determine the percentage of crystallinity in the test sample.

5. Significance and Use

5.1 The crystallinity of UHMWPE will influence its mechanical properties, such as creep and stiffness. The reported crystallinity will depend on the integration range used to determine the heat of fusion, and the theoretical heat of fusion of 100 % crystalline polyethylene used to calculate the percent crystallinity in an unknown specimen. Differential scanning calorimetry is an effective means of accurately measuring both heat of fusion and melting temperature.

5.2 This test method is useful for both process control and research.

6. Interferences

6.1 As machining processes can affect the crystalline structure of UHMWPE, care should be taken to obtain a representative sample away from the surface of a component if bulk measurements are desired.

6.2 The integration range used to measure the area of the melting endotherm will affect the measured value, as can heating rate. Therefore, the same ranges and test conditions must be used to ensure comparative results between laboratories.

6.3 The sample must not be too tall, as temperature gradients can then be generated in the sample, leading to erroneous results. It is suggested that the sample height should be less than 2 mm.

7. Apparatus

7.1 *Differential scanning calorimeter (DSC)*, as described in Test Method [D3418](#) and Practice [E1953](#).

7.2 *Aluminum DSC sample pans, crimpable*. Pans with venting holes are optional. The same type of pan must be used for the sample and reference pan.

7.3 *Analytical balance*, accurate to ± 0.01 mg.

NOTE 1—According to Test Method [E793](#), the repeatability standard deviation for the enthalpy of fusion of a polyolefin is 1.2 % when using a balance resolution of 0.01 mg.

8. Sampling, Test Specimens, and Test Units

8.1 The UHMWPE test specimen can be in the form of powder, flake, film, or pellet.

8.2 If a specimen is to be cut from a larger piece of polyethylene, it is recommended that a clean, sharp razor blade or other equivalent tool is used to cut a slice. The specimen must not be cut with a tool that generates enough heat to melt the UHMWPE. A core borer or punch can also be used to cut a sample from a film of UHMWPE.

8.3 The specimen should be fairly flat to ensure good thermal contact with the sample pan.

8.4 It is recommended that a minimum of three specimens per test location are tested.

NOTE 2—"Test location" is defined as the location on the sample where the DSC analysis is performed.

9. Preparation of Apparatus

9.1 The DSC test chamber should be purged with dry nitrogen, argon, or helium at a controlled flow rate during all tests. The same rate and gas should be used for all calibrations and tests. A purge rate of 10 to 50 ml/min is recommended.

10. Calibration and Standardization

10.1 Calibrate the temperature and heat flow signals of the DSC according to Test Method [E967](#) and Practice [E968](#), respectively. Typically, pure indium is used as a reference material. Both onset of the melting endotherm of the reference standard and the heat of fusion shall be reported and compared with published values ($T_o = 156.6^\circ\text{C}$, $\Delta H_f = 28.57 \text{ J/g}$).³ The DSC calibration should be verified on at least a monthly basis.

NOTE 3—The value of the ΔH_f will vary with the lot of the indium by as much as 3 %. Users should refer to the certificate of analysis for the ΔH_f of their specific lot of indium.

11. Procedure

11.1 Weigh an UHMWPE specimen on an analytical balance to a resolution of 0.01 mg. The specimen weight should be between 5 and 10 mg. The replicate specimens should all be within ± 2 mg of each other.

11.2 Place the specimen into an aluminum DSC sample pan, cover with an aluminum lid, and crimp to seal the sample. If the DSC software allows compensation for the pan weight, record the weight.

³ Linde, D. R., ed., *CRC Handbook of Chemistry and Physics*, 76th ed, CRC Press, Boca Raton, 1995.