

**DELTRIN 300CP BK602**

Delrin USA, LLC - Acetal (POM) Homopolymer

**General Information**
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Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Additive	• Mold Release
Features	• Good Mold Release • Good Thermal Stability • Medium-high Viscosity • Good Processability • Homopolymer
RoHS Compliance	• Contact Manufacturer
Part Marking Code (ISO 11469)	• >POM<
Resin ID (ISO 1043)	• POM

**Properties <sup>1</sup>**

Physical	Nominal Value	Unit	Test Method
Density	1.42	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	7.0	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	6.0	cm <sup>3</sup> /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	1.8	%	
Flow	2.1	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	464000	psi	ISO 527-1
Tensile Stress (Yield)	10700	psi	ISO 527-2
Tensile Strain (Yield)	22	%	ISO 527-2
Nominal Tensile Strain at Break	35	%	ISO 527-2
Poisson's Ratio	0.37		
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	4.3	ft·lb/in <sup>2</sup>	
73°F	4.3	ft·lb/in <sup>2</sup>	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F	150	ft·lb/in <sup>2</sup>	
73°F	No Break		
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	325	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	212	°F	ISO 75-2/A
Melting Temperature <sup>2</sup>	352	°F	ISO 11357-3
Annealing Temperature	320	°F	
Annealing Time - Optional	30.0	min/mm	
Flammability	Nominal Value	Unit	Test Method
Burning Rate <sup>3</sup> (0.0394 in)	< 3.1	in/min	ISO 3795
FMVSS Flammability	B		FMVSS 302
Additional Information	Nominal Value	Unit	Test Method
Emission	< 8	ppm	VDA 275

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	176	°F
Drying Time - Desiccant Dryer	2.0 to 4.0	hr



Suggested Max Moisture	< 0.20 %
Processing (Melt) Temp	410 to 428 °F
Melt Temperature, Optimum	419 °F
Mold Temperature	176 to 212 °F
Mold Temperature, Optimum	194 °F
Holding Pressure	11600 to 14500 psi
Drying Recommended	yes
Hold Pressure Time	8.00 s/mm
Maximum Screw Tangential Speed	472 in/min

#### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> 10°C/min

<sup>3</sup> FMVSS 302

