

**DELTRIN 525GR BK000**

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
Filler / Reinforcement	• Glass Fiber, 25% Filler by Weight
Features	• Homopolymer • Medium Viscosity
RoHS Compliance	• Contact Manufacturer
Part Marking Code (ISO 11469)	• >POM-GF25<
Resin ID (ISO 1043)	• POM-GF25

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

Physical	Nominal Value	Unit	Test Method
Density	1.59	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	7.5	g/10 min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	1.2	%	
Flow	0.40	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.38E+6	psi	ISO 527-1
Tensile Stress (Break)	21800	psi	ISO 527-2
Tensile Strain (Break)	3.0	%	ISO 527-2
Flexural Modulus	1.23E+6	psi	ISO 178
Flexural Stress (3.5% Strain)	29000	psi	ISO 178
Poisson's Ratio	0.34		
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	3.6	ft·lb/in <sup>2</sup>	
73°F	4.8	ft·lb/in <sup>2</sup>	
Charpy Unnotched Impact Strength (73°F)	24	ft·lb/in <sup>2</sup>	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	347	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	342	°F	ISO 75-2/A
Melting Temperature <sup>2</sup>	352	°F	ISO 11357-3
Flammability	Nominal Value	Unit	Test Method
Burning Rate <sup>3</sup> (0.0394 in)	1.7	in/min	ISO 3795
FMVSS Flammability	B		FMVSS 302
Additional Information	Nominal Value	Unit	Test Method
Fogging - F-value (refraction) <sup>4</sup>	90	%	ISO 6452

**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	709 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

<sup>4</sup> Derived from Similar Grade, Assessed (Min)

