Delrin® 127UVE BK701

ACETAL RESIN

DuPont Performance Polymers

Message:

UV Stabilized High Viscosity Acetal Homopolymer with Very Low Emissions

General Information			
Additive	demoulding UV stabilizer		
Features	UV Stabilized Low volatilization Homopolymer Viscosity, High		
RoHS Compliance	Contact manufacturer		
Forms	Particle		
Processing Method	Extrusion Sheet extrusion molding Profile extrusion molding Injection molding		
Part Marking Code (ISO 11469)	>POM		
Resin ID (ISO 1043)	POM		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.42	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR)	2.4	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	2.00	cm³/10min	ISO 1133
Molding Shrinkage			ISO 294-4
Transverse flow	1.9	%	ISO 294-4
Flow	2.1	%	ISO 294-4
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness			ISO 2039-2
M scale	90		ISO 2039-2
R scale	120		ISO 2039-2
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	2900	MPa	ISO 527-2
Tensile Stress (Yield)	73.0	MPa	ISO 527-2
Tensile Strain (Yield)	25	%	ISO 527-2

Nominal Tensile Strain at Break	40	%	ISO 527-2
Flexural Modulus	3000	MPa	ISO 178
Flexural Stress (3.5% Strain)	82.0	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (23°C)	11	kJ/m^2	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	370	kJ/m^2	ISO 179/1eU
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature			
0.45 MPa, not annealed	161	°C	ISO 75-2/B
1.8 MPa, not annealed	94.0	°C	ISO 75-2/A
Melting Temperature [1]	178	°C	ISO 11357-3
Annealing Time - Optional	30.0	min/mm	
Annealing temperature	160	°C	
Emission		mg/kg	VDA 275
Melt Temperature, Optimum	205	°C	
Mold Temperature, Optimum	90	°C	
Drying Recommended	yes		
Hold Pressure Time	8.00	s/mm	
Extrusion Melt Temperature, Optimum	200	°C	
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	2.0E+13	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	ohms·cm	IEC 60093
Relative Permittivity (100 Hz)	3.96		IEC 60250
Dissipation Factor (100 Hz)	2.7E-3		IEC 60250
Comparative Tracking Index	600	V	IEC 60112
Injection	**Nominal Value**	**Unit**	
Drying Temperature	80	°C	
Drying Time - Desiccant Dryer	2.0 - 4.0	hr	
Suggested Max Moisture	0.20	%	
Processing (Melt) Temp	200 - 210	°C	
Mold Temperature	80 - 100	°C	
Holding Pressure	90.0 - 110	MPa	
Extrusion	**Nominal Value**	**Unit**	
Drying Temperature	75 - 85	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.20	%	
Melt Temperature	195 - 205	°C	
NOTE			
1.	10°C/min		

Recommended distributors for this material

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