

Delrin® 525GR BK000

ACETAL RESIN

DuPont Performance Polymers

Message:

25% Glass Reinforced Medium Viscosity Acetal Homopolymer

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 25% filler by weight		
Features	Homopolymer		
	Medium viscosity		
RoHS Compliance	Contact manufacturer		
Forms	Particle		
Processing Method	Injection molding		
Part Marking Code (ISO 11469)	>POM-GF25		
Resin ID (ISO 1043)	POM-GF25		
Physical	Nominal Value	Unit	Test Method
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	7.0	g/10 min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	9500	MPa	ISO 527-2
Flexural Stress (3.5% Strain)	200	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength (23°C)	50	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	175	°C	ISO 75-2/B
1.8 MPa, not annealed	172	°C	ISO 75-2/A
Melting Temperature ¹	178	°C	ISO 11357-3
Flammability	Nominal Value	Unit	Test Method
Burning Rate ² (1.00 mm)	44	mm/min	ISO 3795
FMVSS Flammability	B		FMVSS 302
Melt Temperature, Optimum	215	°C	
Mold Temperature, Optimum	90	°C	
Drying Recommended	yes		
Hold Pressure Time	8.00	s/mm	
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	210 - 220	°C
Mold Temperature	80 - 100	°C
Holding Pressure	80.0 - 100	MPa
NOTE		
1.	10°C/min	
2.	FMVSS 302	

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Recommended distributors for this material

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