Delrin® 511DP NC010

ACETAL RESIN

Common features of Delrin® acetal resins include mechanical and physical properties such as high mechanical strength and rigidity, excellent fatigue and impact resistance, as well as resistance to moisture, gasoline, lubricants, solvents, and many other neutral chemicals. Delrin® acetal resins also have excellent dimensional stability and good electrical insulating characteristics. They are naturally resilient, self-lubricating, and available in a variety of colors and speciality grades.

Delrin® acetal resin typically is used in demanding applications in the automotive, domestic appliances, sports, industrial engineering, electronics, and consumer goods industries.

Delrin® 511DP is a medium viscosity acetal homopolymer with enhanced crystallization for faster cycle times and excellent creep and fatigue resistance. It has improved thermal stability, excellent dimensional stability, low warpage and fewer voids.

Product information

Resin Identification	POM	ISO 1043
Part Marking Code	>POM<	ISO 11469

Rheological properties

Melt volume-flow rate	13	cm³/10min	ISO 1133
Melt mass-flow rate	14	g/10min	ISO 1133
Temperature	190	°C	ISO 1133
Load	2.16	kg	ISO 1133
Melt mass-flow rate, Temperature	190	°C	ISO 1133
Melt mass-flow rate, Load	2.16	kg	ISO 1133
Molding shrinkage, parallel	1.9	%	ISO 294-4
Molding shrinkage, normal	1.8	%	ISO 294-4

Typical mechanical properties

Tensile Modulus	3500	MPa	ISO 527-1/-2
Yield stress	75	MPa	ISO 527-1/-2
Yield strain	12	%	ISO 527-1/-2
Nominal strain at break	25	%	ISO 527-1/-2
Flexural Modulus	3200	MPa	ISO 178
Flexural Stress at 3.5%	89	MPa	ISO 178
Charpy impact strength, 73°F	220	kJ/m²	ISO 179/1eU
Charpy impact strength, -22°F	200	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 73°F	6.5	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -22°F	6	kJ/m²	ISO 179/1eA
Ball indentation hardness, H 961/30	175[DS]	MPa	ISO 2039-1
Poisson's ratio	0.37		

[DS]: Derived from similar grade

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Thermal properties

Melting temperature, 18°F/min	178	°C	ISO 11357-1/-3
Temp. of deflection under load, 260 psi	105	°C	ISO 75-1/-2
Temp. of deflection under load, 65 psi	163	°C	ISO 75-1/-2
Vicat softening temperature, 90°F/h, 11 lbf	160	°C	ISO 306
Coeff. of linear therm. expansion, parallel	100	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	110	E-6/K	ISO 11359-1/-2
RTI, electrical, 30mil	50	°C	UL 746B
RTI, electrical, 60mil	110	°C	UL 746B
RTI, electrical, 120mil	110	°C	UL 746B
RTI, impact, 30mil	50	°C	UL 746B
RTI, impact, 60mil	85	°C	UL 746B
RTI, impact, 120mil	90	°C	UL 746B
RTI, strength, 30mil	50	°C	UL 746B
RTI, strength, 60mil	90	°C	UL 746B
RTI, strength, 120mil	95	°C	UL 746B

Flammability

Burning Behav. at 60mil nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	IEC 60695-11-10
UL recognition	yes		UL 94
Burning Behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.8	mm	IEC 60695-11-10
UL recognition	yes		UL 94
FMVSS Class	B		ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	29[1]	mm/min	ISO 3795 (FMVSS 302)

[1]: 2 mm

Electrical properties

Relative permittivity, 100Hz	3.9		IEC 62631-2-1
Relative permittivity, 1MHz	3.9		IEC 62631-2-1
Dissipation factor, 100Hz	30	E-4	IEC 62631-2-1
Dissipation factor, 1MHz	45	E-4	IEC 62631-2-1
Volume resistivity	>1E13	Ohm.m	IEC 62631-3-1
Surface resistivity	>1E15	Ohm	IEC 62631-3-2
Comparative tracking index	600		IEC 60112
Comparative tracking index, 3.0mm	0	PLC	UL 746A

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Other properties

Humidity absorption, 80mil	0.3	%	Sim. to ISO 62
Water absorption, 80mil	0.9	%	Sim. to ISO 62
Water absorption, Immersion 24h	0.3	%	Sim. to ISO 62
Density	1420	kg/m³	ISO 1183

VDA Properties

Emissions	<8	mg/kg	VDA 275
Fogging, F-value (refraction)	97	%	ISO 6452
Fogging, G-value (condensate)	0.1	mg	ISO 6452

Injection

Drying Recommended	yes	
Drying Temperature	80	°C
Drying Time, Dehumidified Dryer	2 - 4	h
Processing Moisture Content	≤0.2	%
Melt Temperature Optimum	215	°C
Min. melt temperature	210	°C
Max. melt temperature	220	°C
Max. screw tangential speed	0.3	m/s
Mold Temperature Optimum	90	°C
Min. mold temperature	80	°C
Max. mold temperature	100	°C
Hold pressure range	80 - 100	MPa
Hold pressure time	7.5	s/mm
Annealing time, optional	30	min/mm
Annealing temperature	160	°C

Extrusion

Drying Temperature	75 - 85	°C
Drying Time, Dehumidified Dryer	2 - 4	h
Processing Moisture Content	≤0.2	%
Melt Temperature Optimum	200	°C
Melt Temperature Range	195 - 205	°C

Characteristics

Additives	Release agent

Additional information

Injection molding	Drying is recommended, but not necessary for newly opened packaging stored in a dry location. Follow the drying guidelines above in the following cases:

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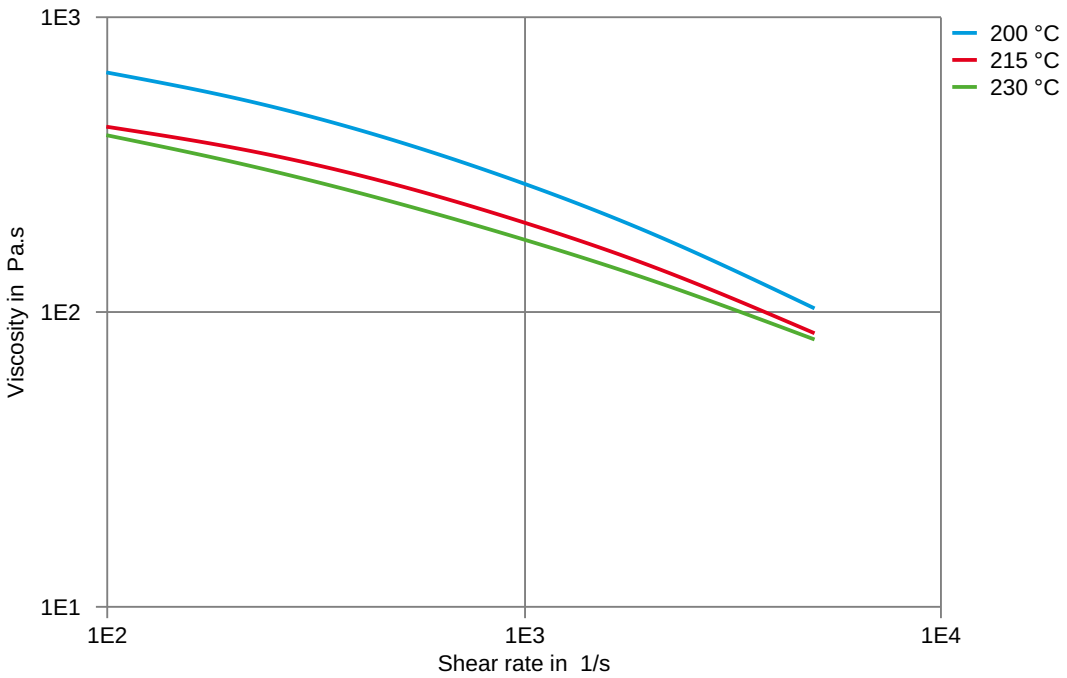
- If moisture is above the Processing Moisture Content recommendation,
- When a resin container is damaged,
- When the material is not properly stored in a dry place at room temperature, or
- When packaging stays open for a significant time.

Viscosity-shear rate



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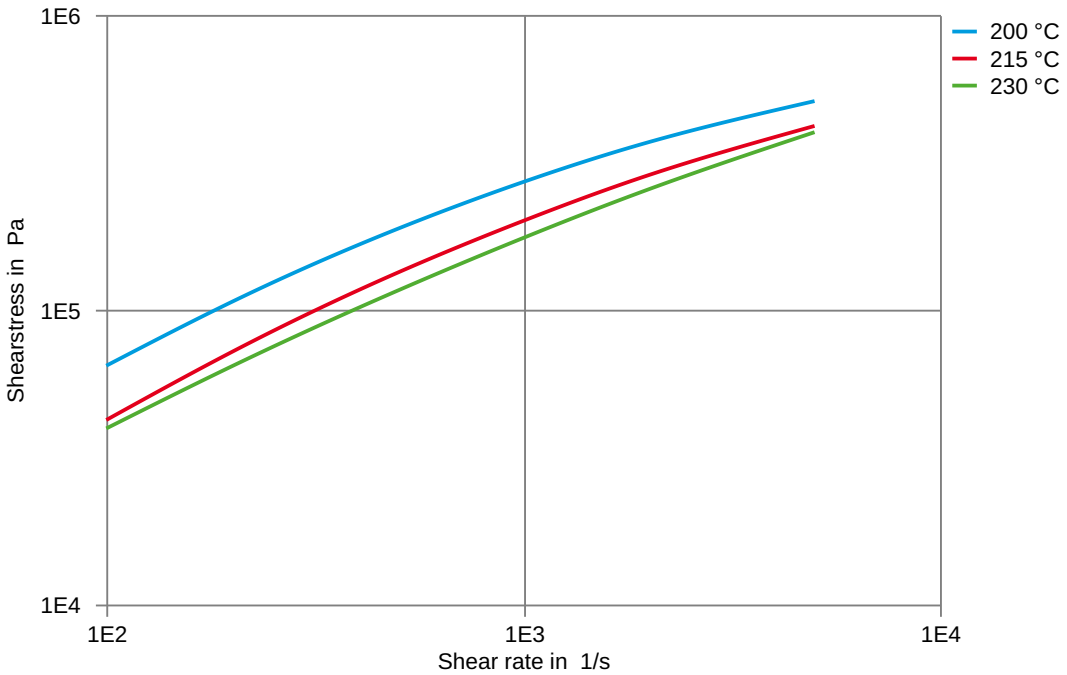
Shearstress-shear rate



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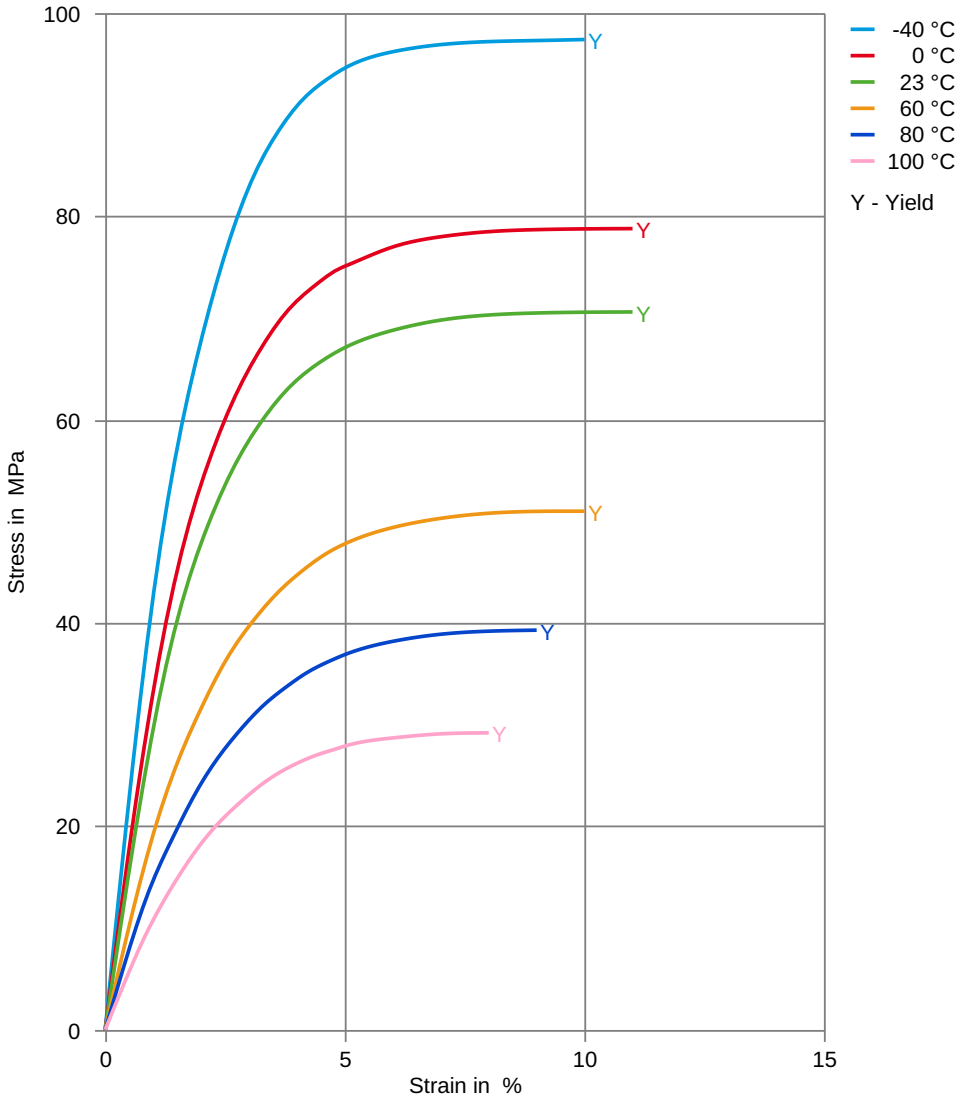
Stress-strain



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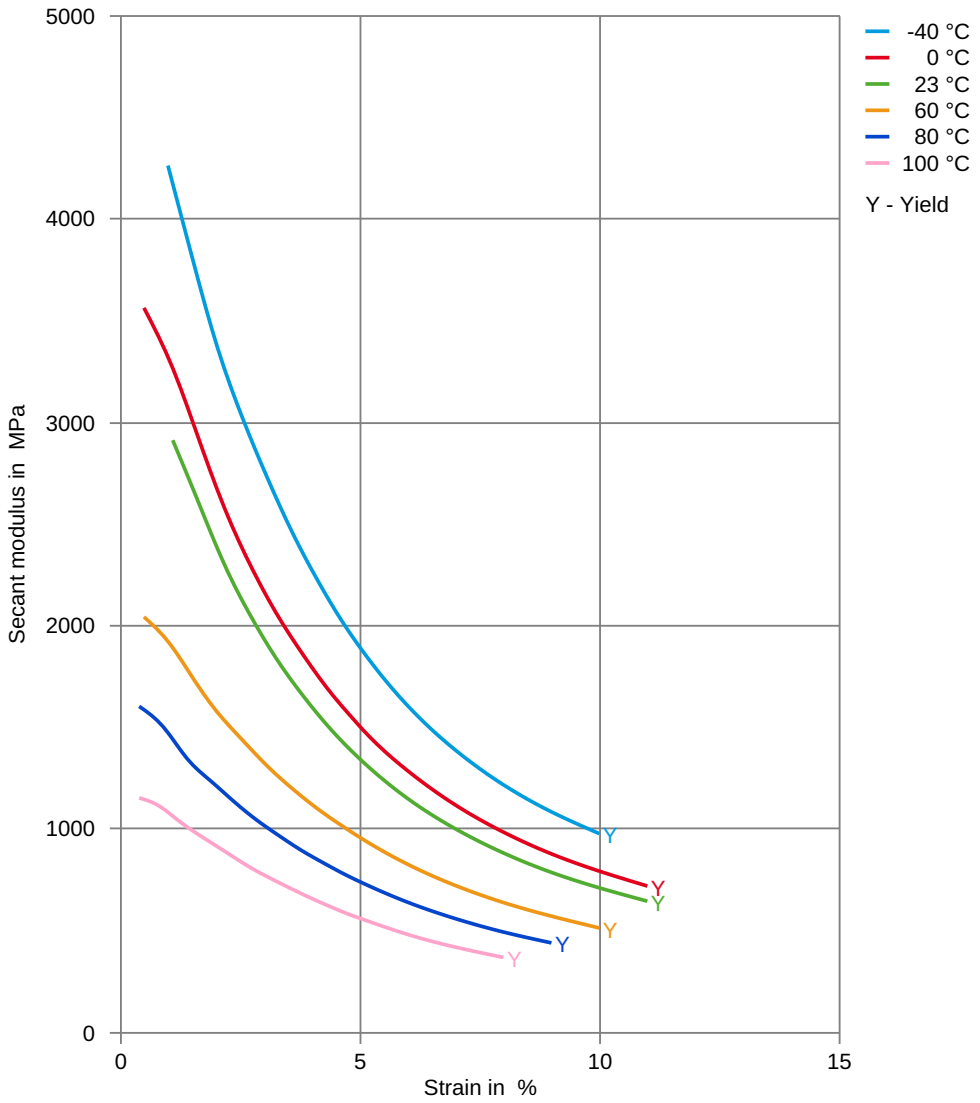
Secant modulus-strain



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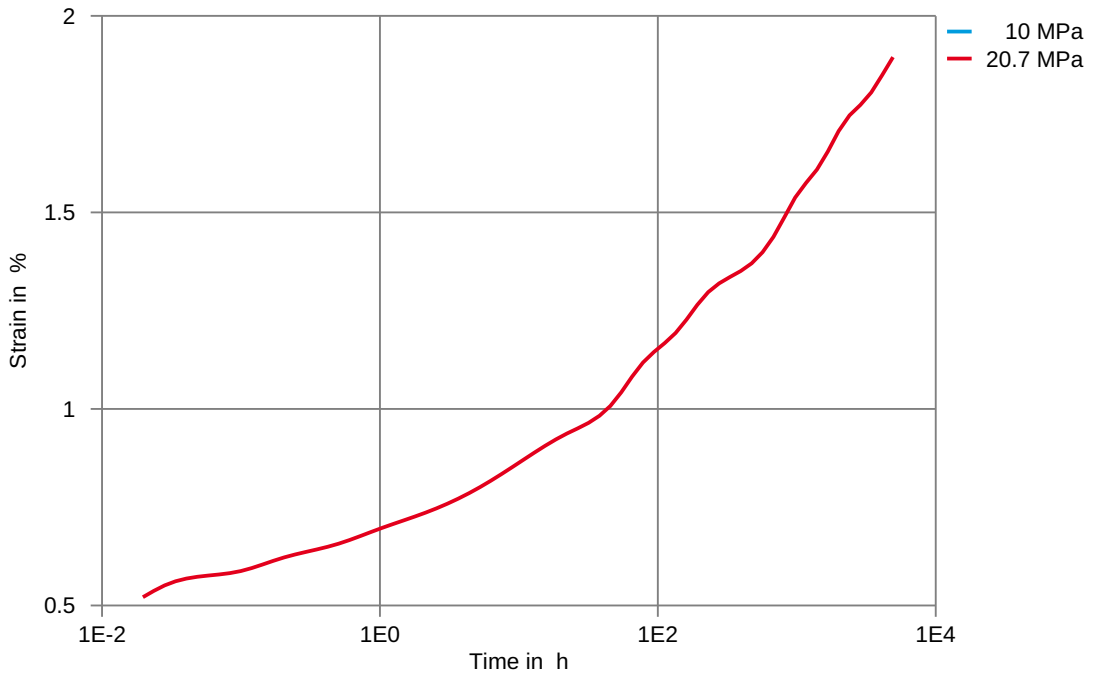
Creep curve 23°C



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Creep curve 40°C

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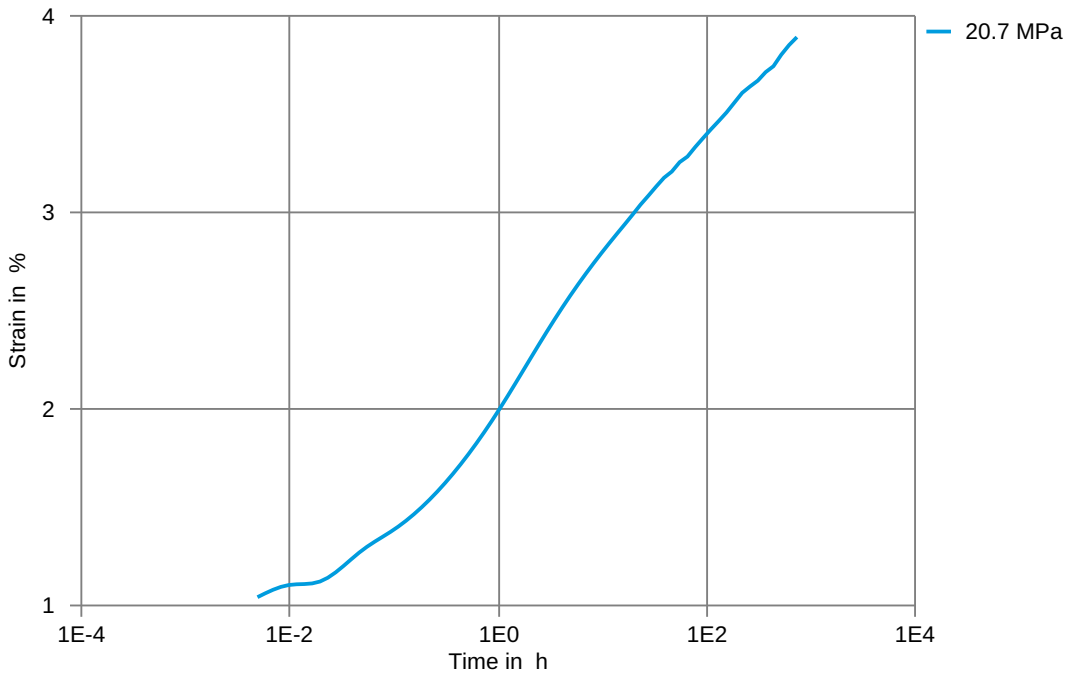
Creep curve 50°C



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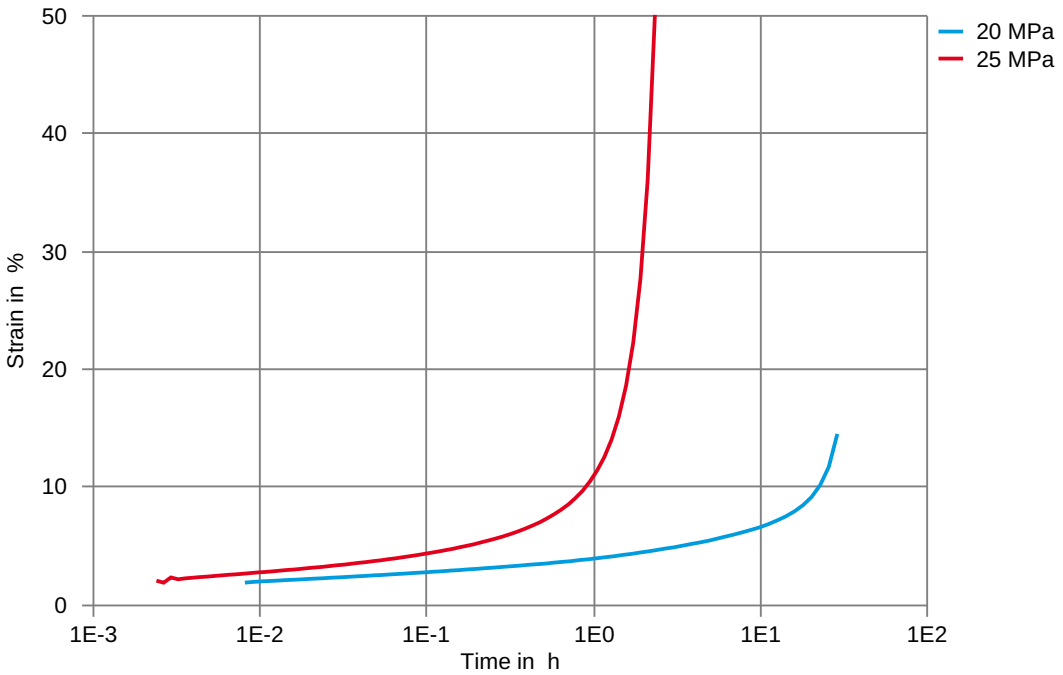
ACETAL RESIN

Creep curve 90°C



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Chemical Media Resistance

Acids

- ✔ Acetic Acid (5% by mass), 23°C
- ✘ Citric Acid solution (10% by mass), 23°C
- ✘ Lactic Acid (10% by mass), 23°C
- ✘ Hydrochloric Acid (36% by mass), 23°C
- ✘ Nitric Acid (40% by mass), 23°C
- ✘ Sulfuric Acid (38% by mass), 23°C
- ✘ Sulfuric Acid (5% by mass), 23°C
- ✘ Chromic Acid solution (40% by mass), 23°C

Bases

- ✘ Sodium Hydroxide solution (35% by mass), 23°C
- ✘ Sodium Hydroxide solution (1% by mass), 23°C
- ✘ Ammonium Hydroxide solution (10% by mass), 23°C

Alcohols

- ✔ Isopropyl alcohol, 23°C
- ✔ Methanol, 23°C
- ✔ Ethanol, 23°C

Hydrocarbons

- ✔ n-Hexane, 23°C
- ✔ Toluene, 23°C
- ✔ iso-Octane, 23°C

Ketones

- ✔ Acetone, 23°C

Ethers

- ✔ Diethyl ether, 23°C

Mineral oils

- ✔ SAE 10W40 multigrade motor oil, 23°C
- ✘ SAE 10W40 multigrade motor oil, 130°C
- ✘ SAE 80/90 hypoid-gear oil, 130°C
- ✔ Insulating Oil, 23°C

Standard Fuels

- ✔ ISO 1817 Liquid 1 - E5, 60°C
- ✔ ISO 1817 Liquid 2 - M15E4, 60°C
- ✔ ISO 1817 Liquid 3 - M3E7, 60°C
- ✔ ISO 1817 Liquid 4 - M15, 60°C
- ✔ Standard fuel without alcohol (pref. ISO 1817 Liquid C), 23°C
- ✔ Standard fuel with alcohol (pref. ISO 1817 Liquid 4), 23°C
- ✔ Diesel fuel (pref. ISO 1817 Liquid F), 23°C
- ✘ Diesel fuel (pref. ISO 1817 Liquid F), 90°C
- ✘ Diesel fuel (pref. ISO 1817 Liquid F), >90°C

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Salt solutions

- ✔ Sodium Chloride solution (10% by mass), 23°C
- ✘ Sodium Hypochlorite solution (10% by mass), 23°C
- ✘ Sodium Carbonate solution (20% by mass), 23°C
- ✘ Sodium Carbonate solution (2% by mass), 23°C
- ✘ Zinc Chloride solution (50% by mass), 23°C

Other

- ✔ Ethyl Acetate, 23°C
- ✘ Hydrogen peroxide, 23°C
- ✘ DOT No. 4 Brake fluid, 130°C
- ✘ Ethylene Glycol (50% by mass) in water, 108°C
- ✔ 1% nonylphenoxy-polyethyleneoxy ethanol in water, 23°C
- ✔ 50% Oleic acid + 50% Olive Oil, 23°C
- ✔ Water, 23°C
- ✘ Water, 90°C
- ✘ Phenol solution (5% by mass), 23°C

Symbols used:

✔ possibly resistant
Defined as: Supplier has sufficient indication that contact with chemical can be potentially accepted under the intended use conditions and expected service life. Criteria for assessment have to be indicated (e.g. surface aspect, volume change, property change).

✘ not recommended - see explanation
Defined as: Not recommended for general use. However, short-term exposure under certain restricted conditions could be acceptable (e.g. fast cleaning with thorough rinsing, spills, wiping, vapor exposure).

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