

Delrin® 900P BK602

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® 900P is a general purpose low viscosity acetal homopolymer for multicavity and thin wall molding with improved processing thermal stability.

Product information

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

Rheological properties

Melt mass-flow rate	25 g/10min	ISO 1133
Melt mass-flow rate, Temperature	190 °C	ISO 1133
Melt mass-flow rate, Load	2.16 kg	ISO 1133
Molding shrinkage, parallel	1.8 %	ISO 294-4
Molding shrinkage, normal	1.7 %	ISO 294-4

Typical mechanical properties

Tensile Modulus	3300 MPa	ISO 527-1/-2
Yield stress	71 MPa	ISO 527-1/-2
Yield strain	12 %	ISO 527-1/-2
Nominal strain at break	17 %	ISO 527-1/-2
Flexural Modulus	3000 MPa	ISO 178
Charpy impact strength, 73°F	130 kJ/m²	ISO 179/1eU
Charpy notched impact strength, 73°F	7 kJ/m²	ISO 179/1eA
Charpy notched impact strength, -22°F	6 kJ/m²	ISO 179/1eA
Izod notched impact strength, 73°F	7 kJ/m²	ISO 180/1A
Izod notched impact strength, -40°F	7 kJ/m²	ISO 180/1A
Poisson's ratio	0.37	

Thermal properties

Melting temperature, 18°F/min	178 °C	ISO 11357-1/-3
Temp. of deflection under load, 260 psi	98 °C	ISO 75-1/-2
Temp. of deflection under load, 65 psi	161 °C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	100 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal, -40-23°C	90 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	100 E-6/K	ISO 11359-1/-2

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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
Oxygen index	23 %	ISO 4589-1/-2
FMVSS Class	B	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	16 ^[1] mm/min	ISO 3795 (FMVSS 302)

[1]: 2 mm

Other properties

Humidity absorption, 80mil	0.4 %	Sim. to ISO 62
Density	1420 kg/m ³	ISO 1183

VDA Properties

Emissions	<8 mg/kg	VDA 275
Emission of organic compounds	4.3 µgC/g	VDA 277
Fogging, G-value (condensate)	0.2 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
Mold Temperature Optimum	90 °C
Min. mold temperature	80 °C

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Max. mold temperature	100 °C
Hold pressure range	80 - 100 MPa
Hold pressure time	8 s/mm
Annealing time, optional	30 min/mm
Annealing temperature	160 °C

Characteristics

Additives

Release agent

Additional information

Injection molding

Drying is recommended, but not necessary for newly opened packaging stored in a dry location.

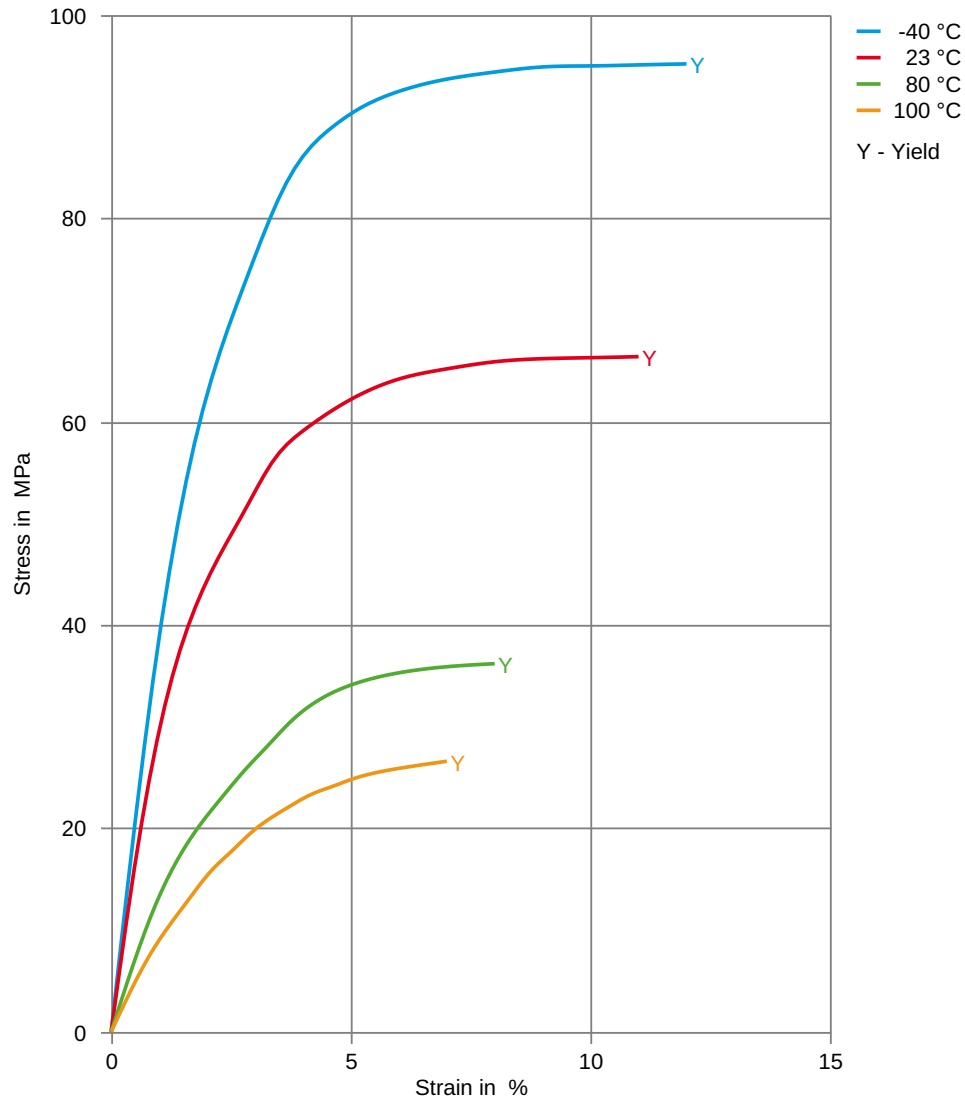
Follow the drying guidelines above in the following cases:

- 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.

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ACETAL RESIN

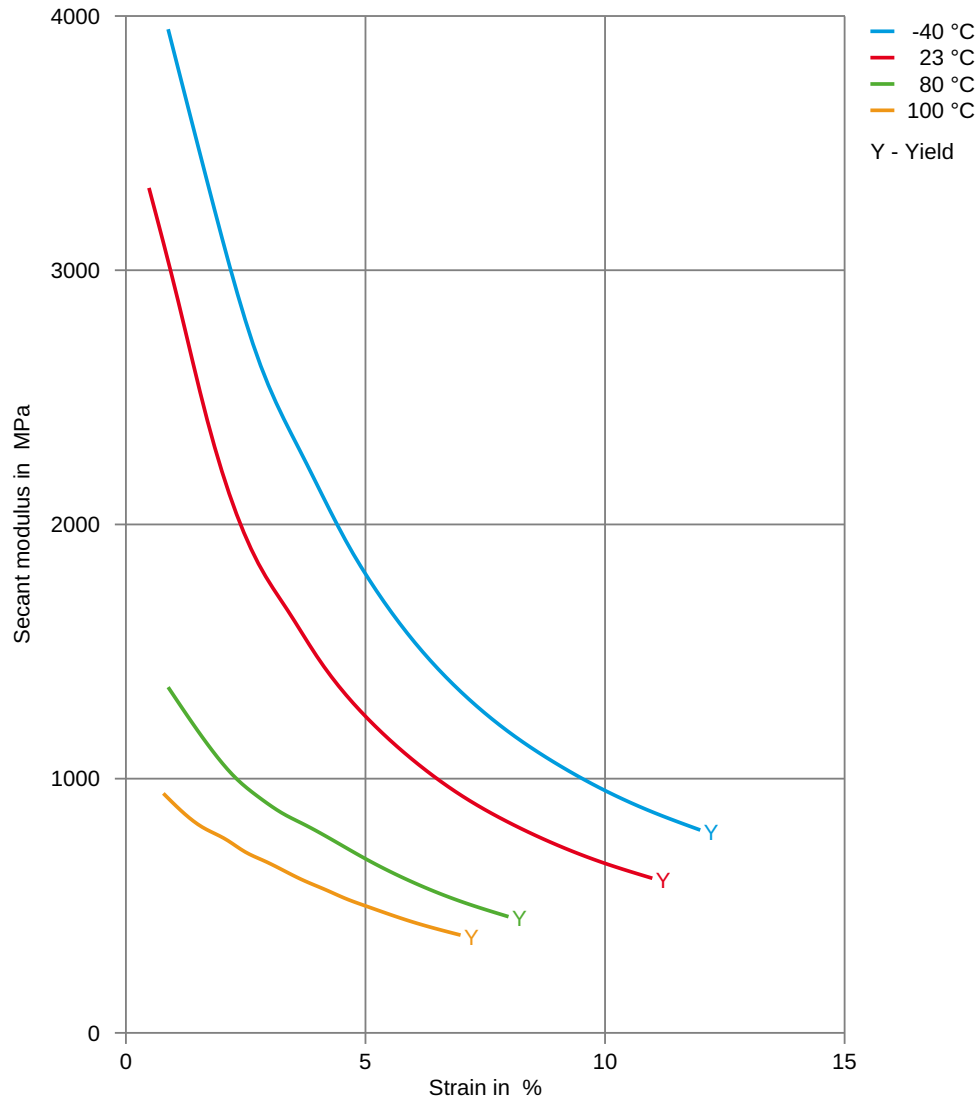
Stress-strain



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Secant modulus-strain



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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).

Delrin

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