



Delrin® 525GR BK000

ACETAL RESIN

Delrin® 525GR BK000 is a 25% Glass Reinforced Medium Viscosity Acetal Homopolymer

Product information

Resin Identification	POM-GF25	ISO 1043
Part Marking Code	>POM-GF25<	ISO 11469

Rheological properties

Melt mass-flow rate	7.5 g/10min	ISO 1133
Melt mass-flow rate, Temperature	190 °C	ISO 1133
Melt mass-flow rate, Load	2.16 kg	ISO 1133
Moulding shrinkage, parallel	0.4 %	ISO 294-4, 2577
Moulding shrinkage, normal	1.2 %	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	9500 MPa	ISO 527-1/-2
Stress at break	150 MPa	ISO 527-1/-2
Strain at break	3 %	ISO 527-1/-2
Flexural Modulus	8500 MPa	ISO 178
Flexural Stress at 3.5%	200 MPa	ISO 178
Charpy impact strength, 23°C	50 kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	10 kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	7.5 kJ/m²	ISO 179/1eA
Poisson's ratio	0.34	

Thermal properties

Melting temperature, 10°C/min	178 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	172 °C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	175 °C	ISO 75-1/-2

Flammability

FMVSS Class	B	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	44 mm/min	ISO 3795 (FMVSS 302)

Other properties

Density	1590 kg/m³	ISO 1183
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VDA Properties

Fogging, F-value (refraction)

90^[DS, AMin] %

ISO 6452

[DS]: Derived from similar grade

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. mould temperature	80 °C
Max. mould temperature	100 °C
Hold pressure range	80 - 100 MPa
Hold pressure time	8 s/mm

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.