



Delrin® 911DP 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® 911DP is a low viscosity acetal homopolymer with enhanced crystallisation 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	21 cm ³ /10min	ISO 1133
Melt mass-flow rate	24 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
Moulding shrinkage, parallel	1.9 %	ISO 294-4, 2577
Moulding shrinkage, normal	1.8 %	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	3600 MPa	ISO 527-1/-2
Yield stress	75 MPa	ISO 527-1/-2
Yield strain	10 %	ISO 527-1/-2
Nominal strain at break	20 %	ISO 527-1/-2
Flexural Modulus	3300 MPa	ISO 178
Flexural Stress at 3.5%	90 MPa	ISO 178
Charpy impact strength, 23°C	160 kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	150 kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	6.5 kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	6 kJ/m ²	ISO 179/1eA
Ball indentation hardness, H 961/30	175 ^[DS] MPa	ISO 2039-1
Poisson's ratio	0.36	

[DS]: Derived from similar grade



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Thermal properties

Melting temperature, 10°C/min	178 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	108 °C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	163 °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	100 E-6/K	ISO 11359-1/-2
RTI, electrical, 0.75mm	50 °C	UL 746B
RTI, electrical, 1.5mm	110 °C	UL 746B
RTI, electrical, 3mm	110 °C	UL 746B
RTI, impact, 0.75mm	50 °C	UL 746B
RTI, impact, 1.5mm	85 °C	UL 746B
RTI, impact, 3mm	90 °C	UL 746B
RTI, strength, 0.75mm	50 °C	UL 746B
RTI, strength, 1.5mm	90 °C	UL 746B
RTI, strength, 3mm	95 °C	UL 746B

Flammability

Burning Behav. at 1.5mm 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	25 mm/min	ISO 3795 (FMVSS 302)

Other properties

Humidity absorption, 2mm	0.2 %	Sim. to ISO 62
Water absorption, 2mm	0.9 %	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



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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	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:

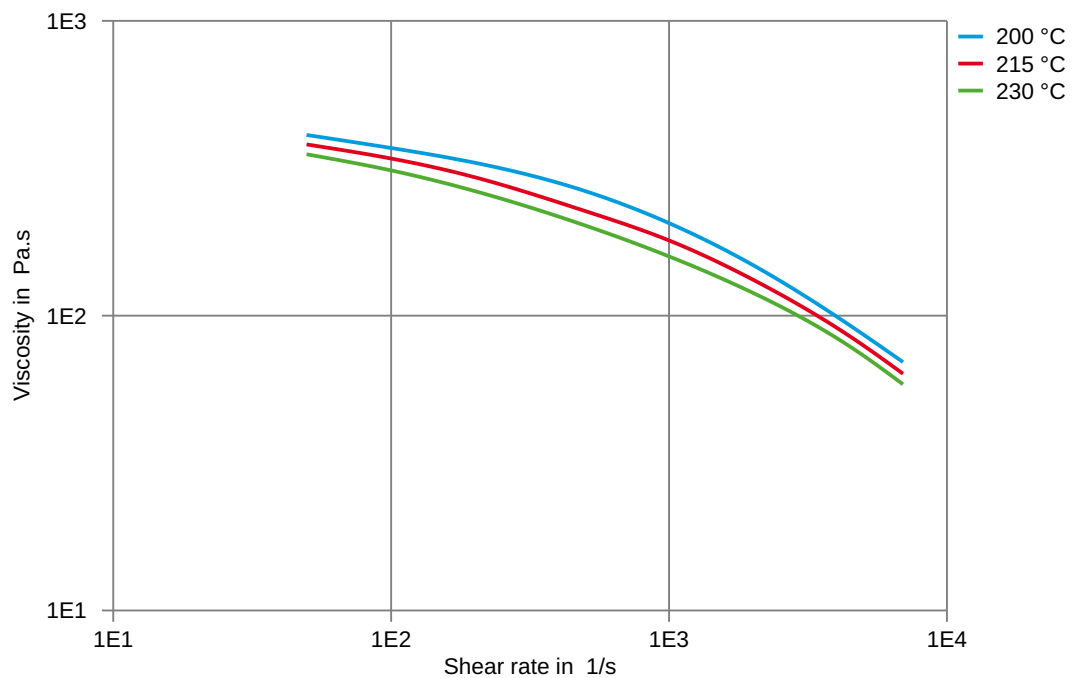
- If moisture is above the Processing Moisture Content recommendation,
- When a resin container is damaged,
- When the material is not properly stored in a dry place at room temperature, or
- When packaging stays open for a significant time.



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Viscosity-shear rate

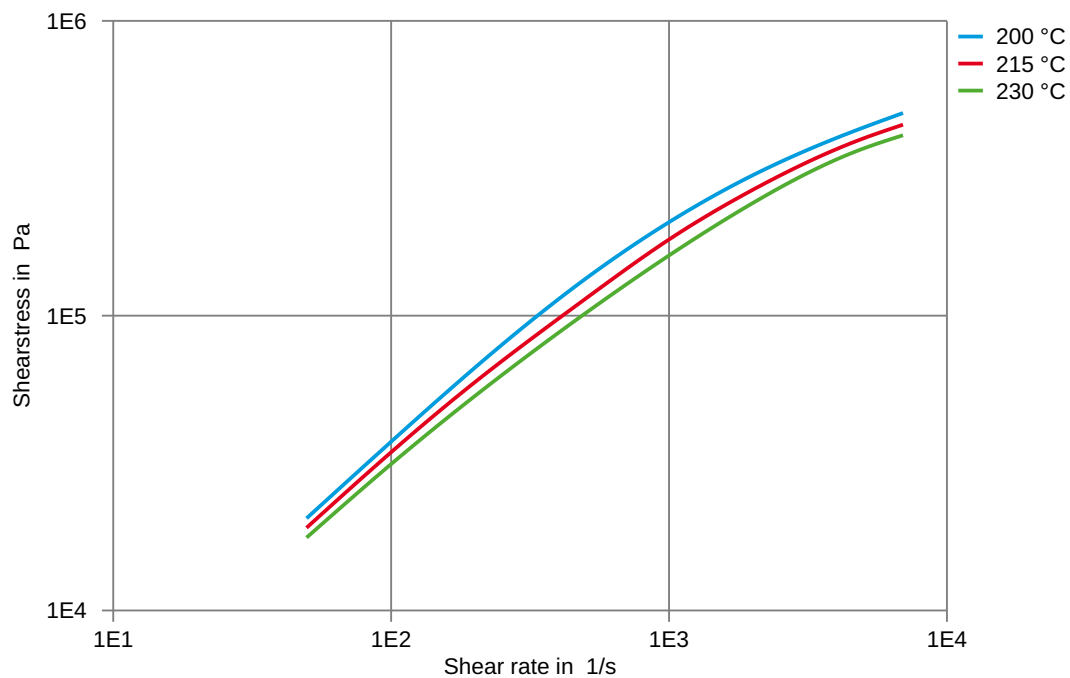




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Shearstress-shear rate





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Stress-strain

