

# DuPont™ Delrin® 525GR BK000

## ACETAL RESIN

**Product Information**

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

General information	Value	Unit	Test Standard
Resin Identification	POM-GF25	-	ISO 1043
Part Marking Code	POM-GF25	-	ISO 11469
Rheological properties	Value	Unit	Test Standard
Melt mass-flow rate	7	g/10min	ISO 1133
Melt mass-flow rate, Temperature	190	°C	ISO 1133
Melt mass-flow rate, Load	2.16	kg	ISO 1133
Mechanical properties	Value	Unit	Test Standard
Tensile Modulus	9500	MPa	ISO 527-1/-2
Flexural Modulus	8500	MPa	ISO 178
Flexural Stress at 3.5%	200	MPa	ISO 178
Charpy impact strength, 73°F	50	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, -22°F	7.5	kJ/m <sup>2</sup>	ISO 179/1eA
Thermal properties	Value	Unit	Test Standard
Melting temperature, 18°F/min	178	°C	ISO 11357-1/-3
Temp. of deflection under load			ISO 75-1/-2
260 psi	172	°C	
65 psi	175	°C	
Flammability	Value	Unit	Test Standard
FMVSS Class	B	-	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	44	mm/min	ISO 3795 (FMVSS 302)
Other properties	Value	Unit	Test Standard
Density	1590	kg/m <sup>3</sup>	ISO 1183
Injection	Value	Unit	Test Standard
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	-
Max. mold temperature	100	°C	-
Hold pressure range	80 - 100	MPa	-
Hold pressure time	8	s/mm	-

**Characteristics**

Processing	• Injection Molding
Delivery form	• Pellets
Regional Availability	• North America      • Asia Pacific      • Near East/Africa • Europe                • South and Central America      • Global

**Processing Texts**

**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,

To find out more, visit [DuPont Performance Polymers](#) or contact nearest DuPont location.

North America

Asia Pacific

Europe/Middle East/Africa

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- When the material is not properly stored in a dry place at room temperature, or
- When packaging stays open for a significant time.

Contact DuPont for Material Safety Data Sheet, general guides and/or additional information about ventilation, handling, purging, drying, etc. ISO Mechanical properties measured at 160 mil (Hytrel® measured at 80 mil), IEC Electrical properties measured at 80 mil, all ASTM properties measured at 120 mil, and test temperatures are 73°F unless otherwise stated.

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### North America

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