



Delrin® 577 BK000

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® 577 is a medium viscosity acetal homopolymer containing 20% glass fiber filler for injection molding. It has very high stiffness, low warpage, and good creep resistance for superior performance at elevated temperature. It contains carbon black for improved weathering.

Product information

Resin Identification	POM-GF20	ISO 1043
Part Marking Code	>POM-GF20<	ISO 11469

Rheological properties

Melt volume-flow rate	7 cm ³ /10min	ISO 1133
Temperature	190 °C	ISO 1133
Load	2.16 kg	ISO 1133
Moulding shrinkage, parallel	1.7 %	ISO 294-4, 2577
Moulding shrinkage, normal	1.1 %	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	4800 MPa	ISO 527-1/-2
Stress at break	52 MPa	ISO 527-1/-2
Strain at break	10 %	ISO 527-1/-2
Flexural Modulus	4600 MPa	ISO 178
Charpy notched impact strength, 23°C	3 kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	3 kJ/m ²	ISO 179/1eA
Poisson's ratio	0.36 -	

Thermal properties

Melting temperature, 10°C/min	178 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	118 °C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	164 °C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	56 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	92 E-6/K	ISO 11359-1/-2
RTI, electrical, 1.5mm	105 °C	UL 746B
RTI, electrical, 3mm	105 °C	UL 746B



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RTI, electrical, 6mm	105 °C	UL 746B
RTI, impact, 1.5mm	85 °C	UL 746B
RTI, impact, 3mm	85 °C	UL 746B
RTI, impact, 6mm	85 °C	UL 746B
RTI, strength, 1.5mm	90 °C	UL 746B
RTI, strength, 3mm	90 °C	UL 746B
RTI, strength, 6mm	90 °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	3 mm	IEC 60695-11-10
UL recognition	yes -	UL 94
FMVSS Class	B -	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	<80 mm/min	ISO 3795 (FMVSS 302)

Other properties

Density	1560 kg/m ³	ISO 1183
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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	20 °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
Annealing time, optional	30 min/mm
Annealing temperature	160 °C

Characteristics

Additives	Release agent
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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:

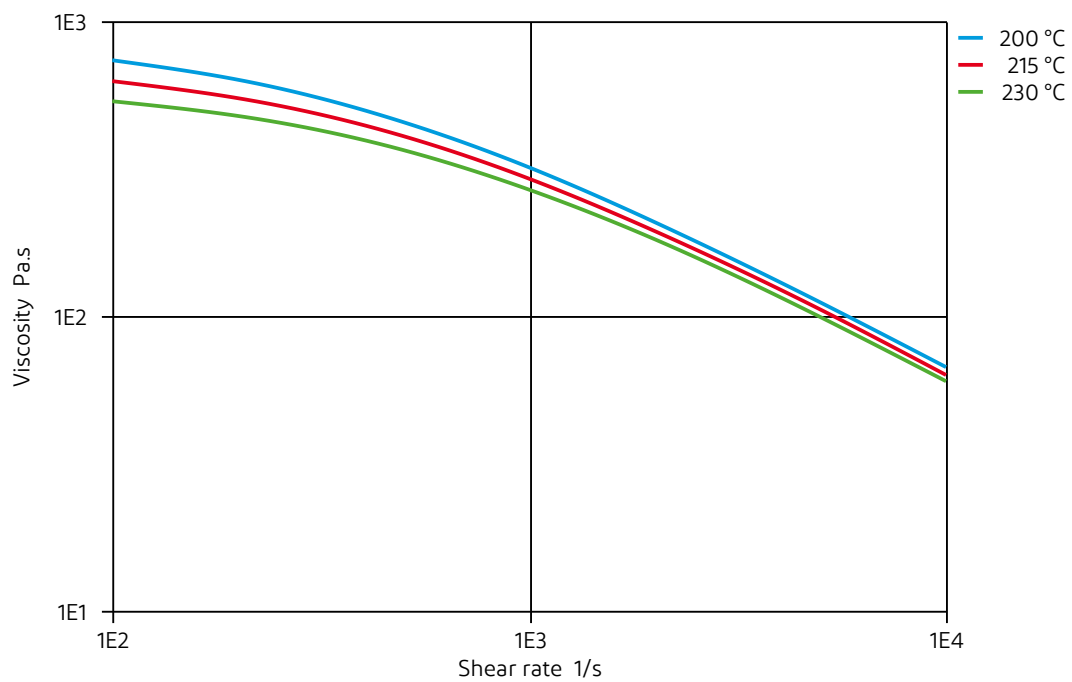
- If moisture is above the Processing Moisture Content recommendation,
- When a resin container is damaged,
- When the material is not properly stored in a dry place at room temperature, or
- When packaging stays open for a significant time.



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Viscosity-shear rate

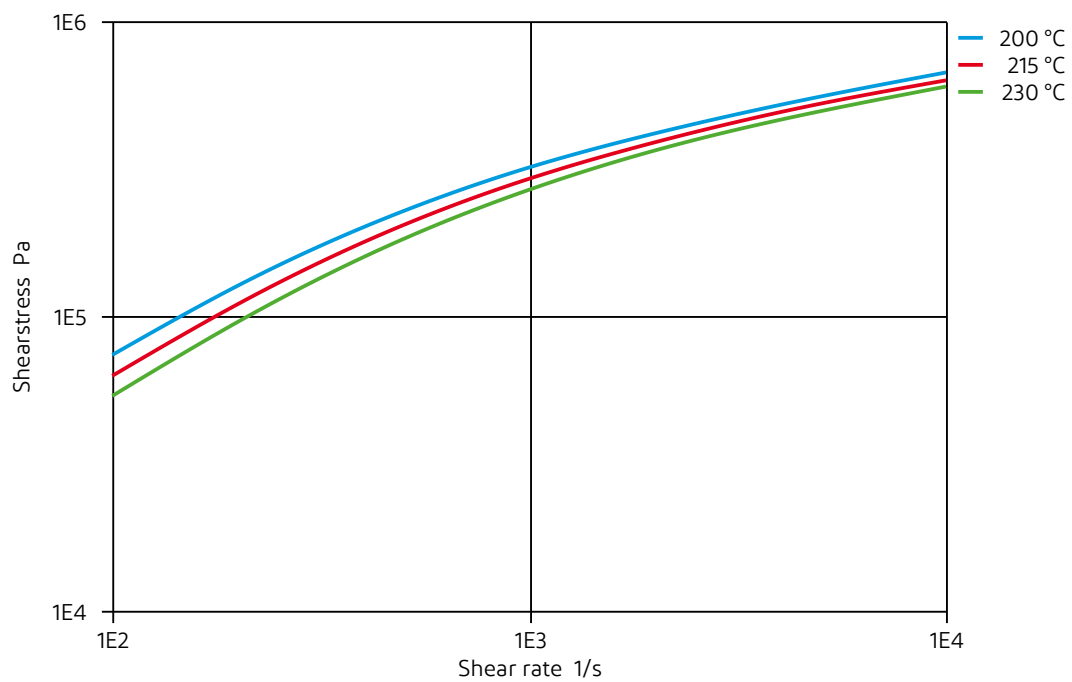




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Shearstress-shear rate

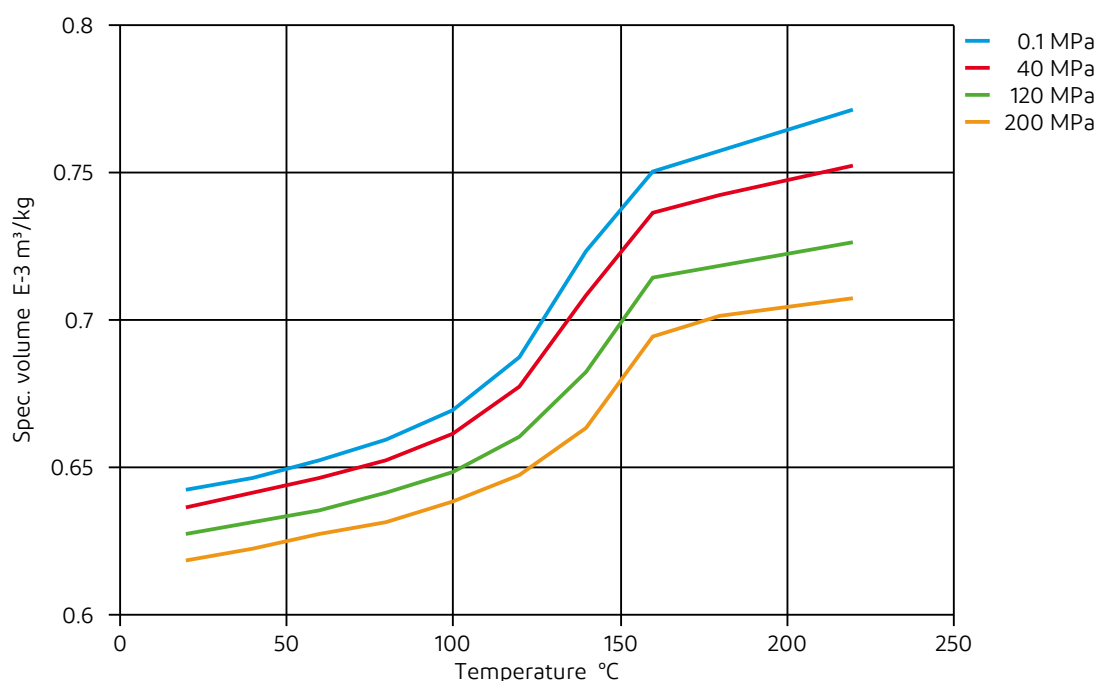




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Specific volume-temperature (pvT)



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