

Crastin® HR5315HF BK503

THERMOPLASTIC POLYESTER RESIN

Crastin® HR5315HF is a 15% glass reinforced PBT with high flow (HF), moderately toughened, hydrolysis resistant (HR) resin. Excellent balance of properties between terminal pullout and impact resistance. Developed for USCAR Class 3 and 4 environments.

General Information

Resin Identification ISO 1043 PBT-IGF15
 Density ISO 1183 1370 kg/m³

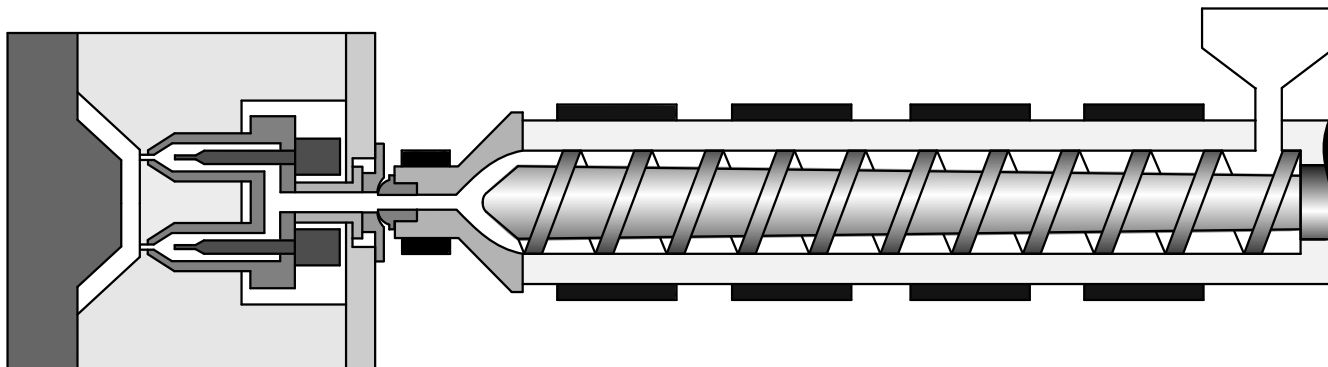
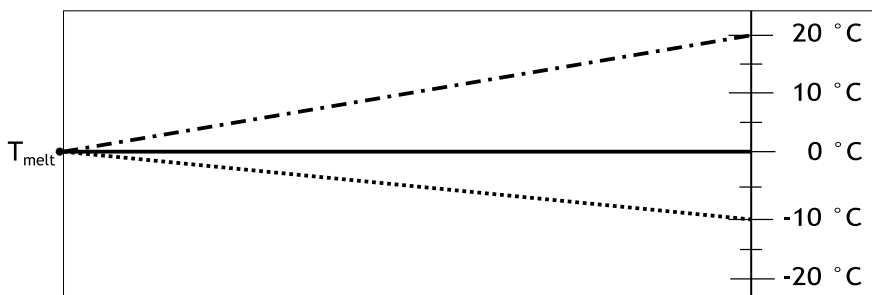
Drying

Drying Recommended yes
 Drying Temperature 120 °C
 Drying Time* 2 - 4 h
 Processing Moisture Content ≤0.04 %

Temperature settings

Melt Temperature Optimum 250 °C
 Min. melt temperature*** 240 °C
 Max. melt temperature 260 °C
 Mold Temperature Optimum 80 °C
 Min. mold temperature 30 °C
 Max. mold temperature 130 °C

3 D (< 3 min) - - - - -
 2 D (3-5 min) ————
 1 D (> 5 min) ······



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Recommended general settings

Hold pressure range	≥60 MPa
Back pressure	As low as possible

Special precautions

During molding, use proper protective equipment and adequate ventilation. Avoid fumes and limit the residence time and temperature of the resin in the machine.

$$\text{Residence time} = \frac{8 * \text{screw } \varnothing \text{ [mm]} * \text{cycle time [s]}}{60 * \text{dosing stroke [mm]}}$$

Hot runner residence time not included in calculation

Links for further information

[Trouble Shooting Guide](#)

For further information e.g. on Shrinkage, Hot runner systems, Venting, Gating, Drying and moisture measurement, Re grind, Purging, please refer to the detailed [Molding Guide](#).

Footnotes:

- * Improper storage may lead to longer drying times
- *** Using melt temperature lower than recommended could create unmelt, leading to weak parts

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