

# Crastin® S610SF BK851

## THERMOPLASTIC POLYESTER RESIN

Crastin® S610SF BK851 is an Unreinforced Polybutylene Terephthalate

### General Information

Resin Identification ISO 1043  
Density ISO 1183

PBT  
1310 kg/m<sup>3</sup>

### Drying

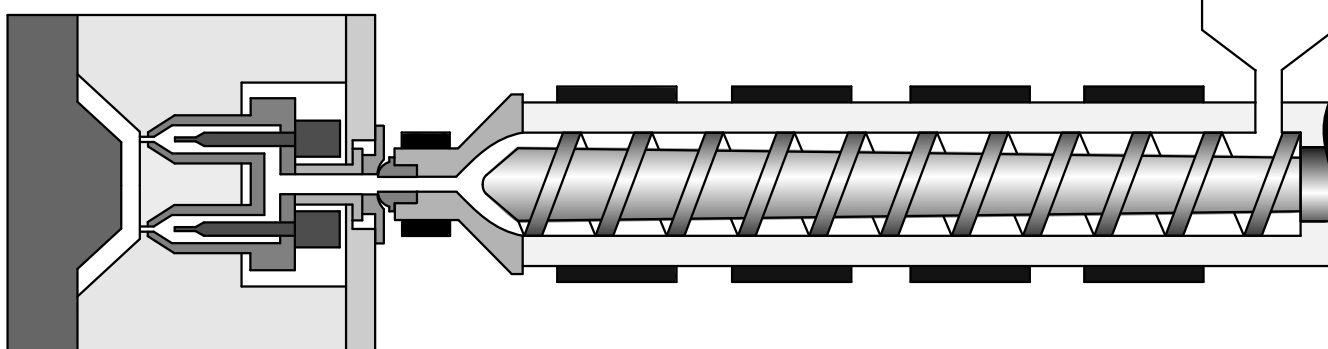
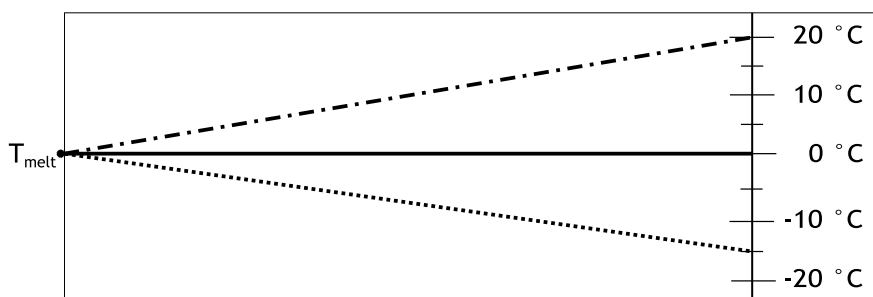
Drying Recommended  
Drying Temperature  
Drying Time\*  
Processing Moisture Content

yes  
120 °C  
2 - 4 h  
≤0.04 %

### Temperature settings

Melt Temperature Optimum	240 °C
Min. melt temperature***	235 °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.

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

*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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