

Crastin® SK603 BK851

THERMOPLASTIC POLYESTER RESIN

Crastin® SK603 BK851 is a 20% glass fiber reinforced, lubricated polybutylene terephthalate resin for injection molding.

General Information

Resin Identification ISO 1043 PBT-GF20
 Density ISO 1183 1450 kg/m³

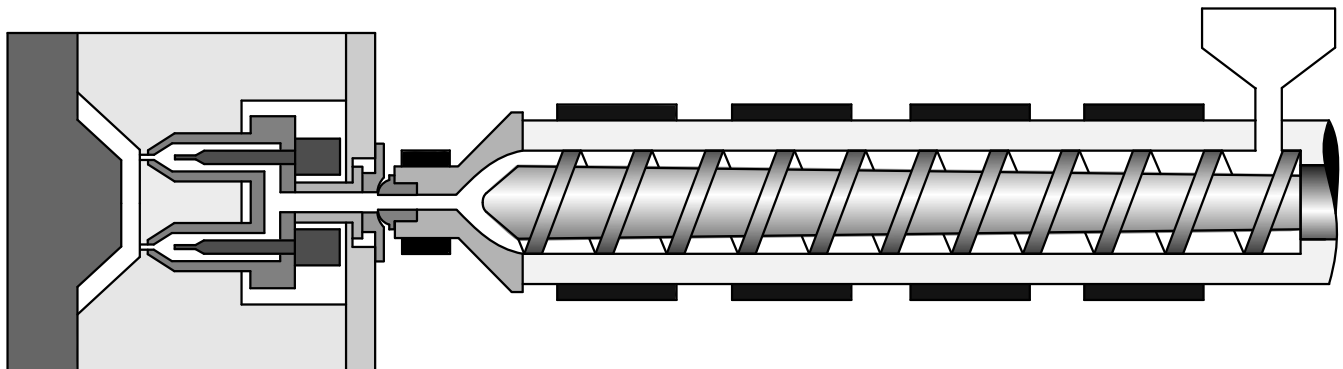
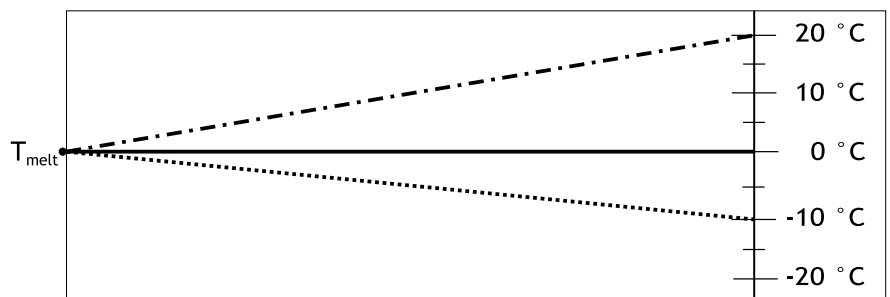
Drying

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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