



Crastin® SK605 BK851

THERMOPLASTIC POLYESTER RESIN

Common features of Crastin® thermoplastic polyester resin include mechanical and physical properties such as stiffness and toughness, heat resistance, friction and wear resistance, excellent surface finishes and good colourability. Crastin® thermoplastic polyester resin has excellent electrical insulation characteristics and high arc-resistant grades are available. Many flame retardant grades have UL recognition (class V-0). Crastin® thermoplastic polyester resin typically has high chemical and heat ageing resistance.

The good melt stability of Crastin® thermoplastic polyester resin normally enables the recycling of properly handled production waste.

If recycling is not possible, DuPont recommends, as the preferred option, incineration with energy recovery (-24 kJ/g of base polymer) in appropriately equipped installations. For disposal, local regulations have to be observed.

Crastin® thermoplastic polyester resin typically is used in demanding applications in the electronics, electrical, automotive, mechanical engineering, chemical, domestic appliances and sporting goods industry.

Crastin® SK605 BK851 is a 30% glass fiber reinforced, lubricated polybutylene terephthalate resin for injection moulding.

Product information

Resin Identification	PBT-GF30	ISO 1043
Part Marking Code	>PBT-GF30<	ISO 11469

Rheological properties

Melt volume-flow rate	7 cm ³ /10min	ISO 1133
Melt mass-flow rate	10 g/10min	ISO 1133
Temperature	250 °C	ISO 1133
Load	2.16 kg	ISO 1133
Melt mass-flow rate, Temperature	250 °C	ISO 1133
Melt mass-flow rate, Load	2.16 kg	ISO 1133
Moulding shrinkage, parallel	0.3 %	ISO 294-4, 2577
Moulding shrinkage, normal	1.1 %	ISO 294-4, 2577
Postmoulding shrinkage, normal, 48h at 80°C	0.2 %	ISO 294-4
Postmoulding shrinkage, parallel, 48h at 80°C	0.1 %	ISO 294-4

Typical mechanical properties

Tensile Modulus	10000 MPa	ISO 527-1/-2
Stress at break	140 MPa	ISO 527-1/-2
Strain at break	2.7 %	ISO 527-1/-2
Flexural Modulus	9000 MPa	ISO 178
Flexural Strength	200 MPa	ISO 178
Charpy impact strength, 23°C	65 kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	10 kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23°C	9 kJ/m ²	ISO 180/1A



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Izod impact strength, 23°C	60 kJ/m ²	ISO 180/1U
Izod impact strength, -30°C	55 kJ/m ²	ISO 180/1U
Izod impact strength, -40°C	55 kJ/m ²	ISO 180/1U
Ball indentation hardness, H 358/30	205 MPa	ISO 2039-1
Poisson's ratio	0.34 -	

Thermal properties

Melting temperature, 10°C/min	225 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	205 °C	ISO 75-1/-2
Ball pressure test	210 °C	IEC 60695-10-2
Coeff. of linear therm. expansion, parallel	30 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	90 E-6/K	ISO 11359-1/-2
Thermal conductivity of melt	0.28 W/(m K)	
Spec. heat capacity of melt	1730 J/(kg K)	
RTI, electrical, 0.75mm	130 °C	UL 746B
RTI, electrical, 1.5mm	130 °C	UL 746B
RTI, electrical, 3mm	130 °C	UL 746B
RTI, electrical, 6mm	130 °C	UL 746B
RTI, impact, 0.75mm	130 °C	UL 746B
RTI, impact, 1.5mm	130 °C	UL 746B
RTI, impact, 3mm	130 °C	UL 746B
RTI, impact, 6mm	130 °C	UL 746B
RTI, strength, 0.75mm	130 °C	UL 746B
RTI, strength, 1.5mm	130 °C	UL 746B
RTI, strength, 3mm	130 °C	UL 746B
RTI, strength, 6mm	130 °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	0.75 mm	IEC 60695-11-10
UL recognition	yes -	UL 94
Oxygen index	20 %	ISO 4589-1/-2
Glow Wire Flammability Index, 0.75mm	725 °C	IEC 60695-2-12
Glow Wire Flammability Index, 1.5mm	725 °C	IEC 60695-2-12
Glow Wire Flammability Index, 3mm	750 °C	IEC 60695-2-12
Glow Wire Ignition Temperature, 0.75mm	750 °C	IEC 60695-2-13
Glow Wire Ignition Temperature, 1.5mm	750 °C	IEC 60695-2-13
Glow Wire Ignition Temperature, 3mm	775 °C	IEC 60695-2-13
FMVSS Class	B -	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	54 mm/min	ISO 3795 (FMVSS 302)



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Electrical properties

Comparative tracking index	225	IEC 60112
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Other properties

Humidity absorption, 2mm	0.15 %	Sim. to ISO 62
Water absorption, 2mm	0.35 %	Sim. to ISO 62
Density	1530 kg/m ³	ISO 1183

VDA Properties

Emission of organic compounds	110 µgC/g	VDA 277
Odour	3 class	VDA 270
Fogging, F-value (refraction)	99 %	ISO 6452

Injection

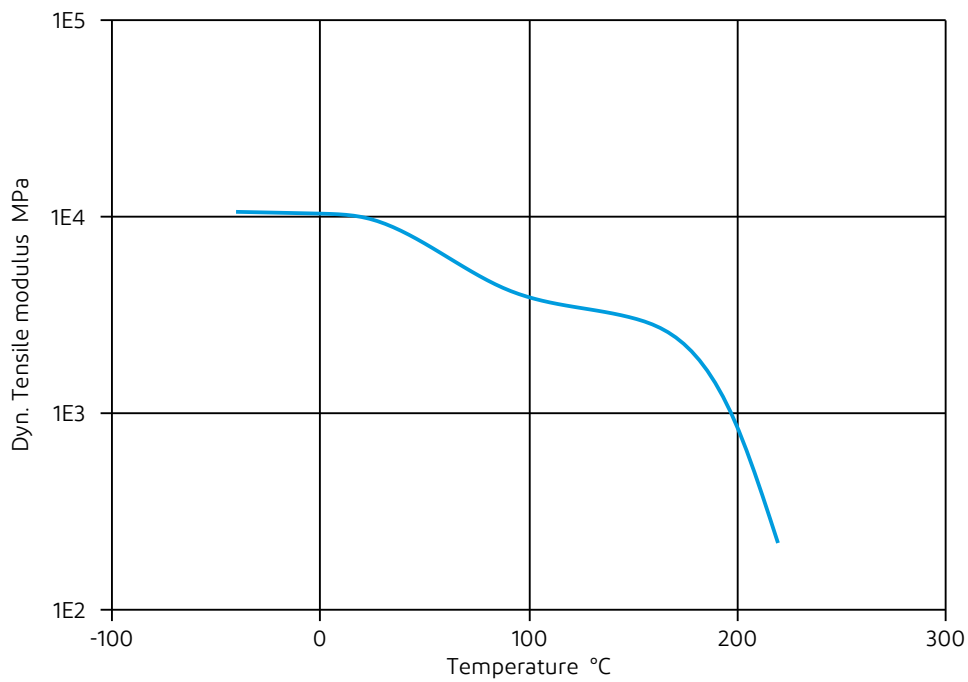
Drying Recommended	yes
Drying Temperature	120 °C
Drying Time, Dehumidified Dryer	2 - 4 h
Processing Moisture Content	≤0.04 %
Melt Temperature Optimum	250 °C
Min. melt temperature	240 °C
Max. melt temperature	260 °C
Mold Temperature Optimum	80 °C
Min. mould temperature	30 °C
Max. mould temperature	130 °C
Hold pressure range	≥60 MPa
Hold pressure time	3 s/mm
Back pressure	As low as MPa possible
Ejection temperature	170 °C



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Dynamic Tensile modulus-temperature
(measured on Crastin® SK605 NC010)

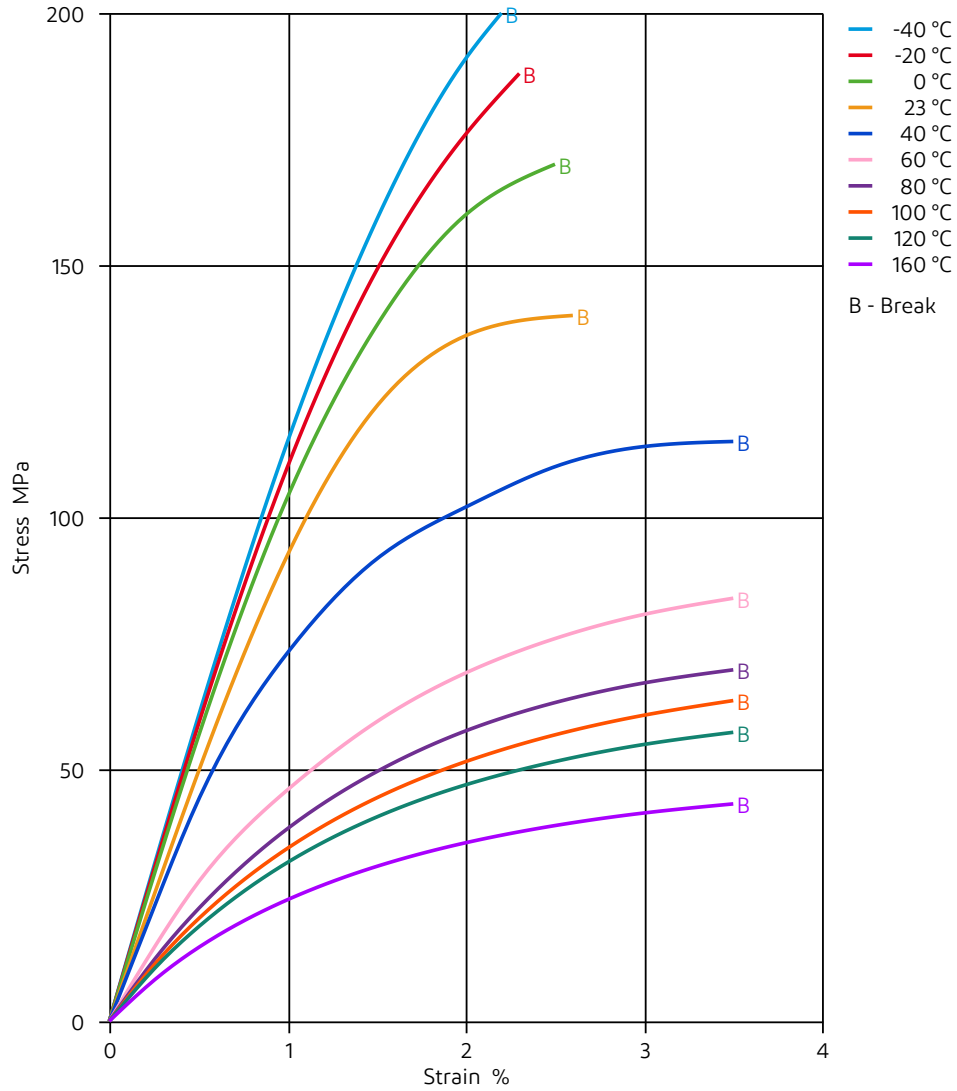




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Stress-strain
(measured on Crastin® SK605 NC010)

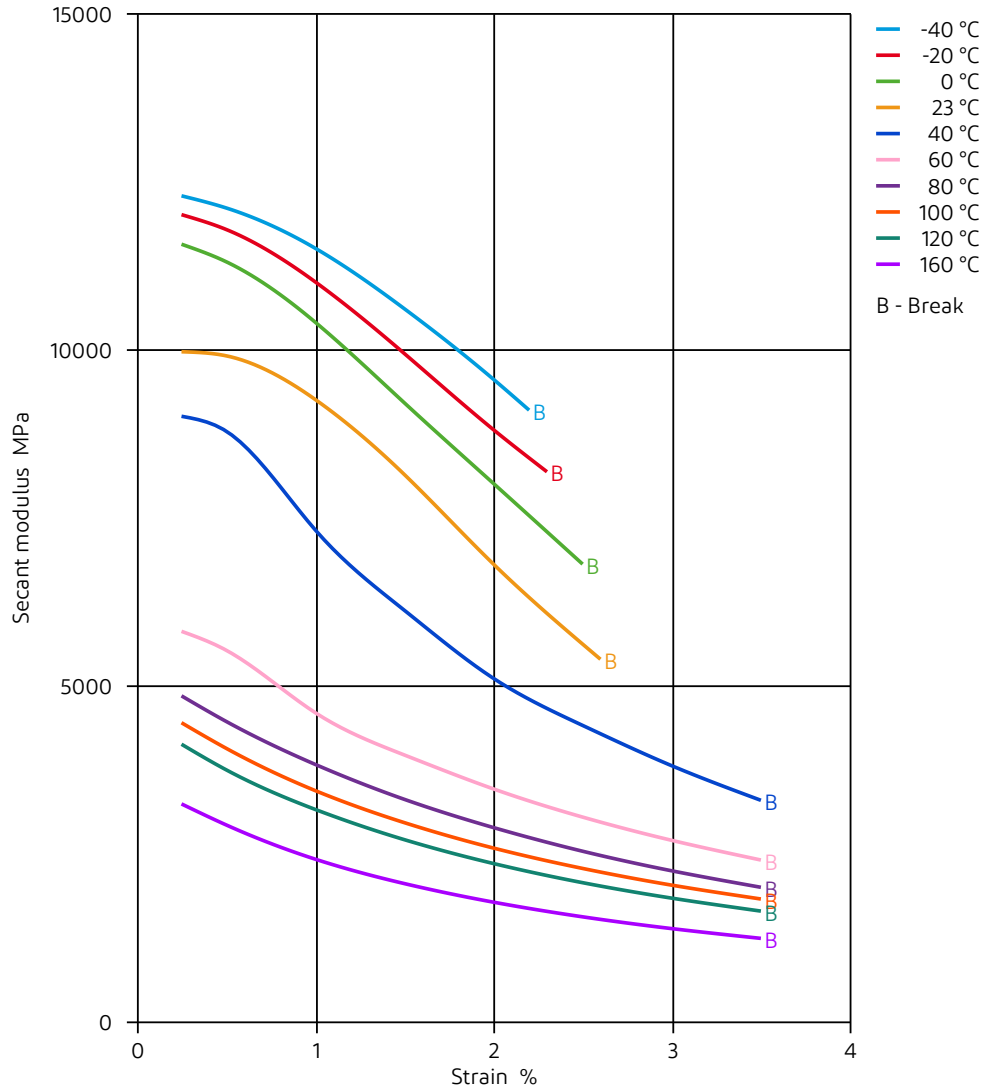




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THERMOPLASTIC POLYESTER RESIN

Secant modulus-strain
(measured on Crastin® SK605 NC010)



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Chemical Media Resistance

Acids

- ✓ Acetic Acid (5% by mass), 23°C
- ✓ Citric Acid solution (10% by mass), 23°C
- ✓ Lactic Acid (10% by mass), 23°C
- ✗ Hydrochloric Acid (36% by mass), 23°C
- ✗ Nitric Acid (40% by mass), 23°C
- ✗ Sulfuric Acid (38% by mass), 23°C
- ✗ Sulfuric Acid (5% by mass), 23°C
- ✗ Chromic Acid solution (40% by mass), 23°C

Bases

- ✗ Sodium Hydroxide solution (35% by mass), 23°C
- ✓ Sodium Hydroxide solution (1% by mass), 23°C
- ✓ Ammonium Hydroxide solution (10% by mass), 23°C

Alcohols

- ✓ Isopropyl alcohol, 23°C
- ✓ Methanol, 23°C
- ✓ Ethanol, 23°C

Hydrocarbons

- ✓ n-Hexane, 23°C
- ✓ Toluene, 23°C
- ✓ iso-Octane, 23°C

Ketones

- ✓ Acetone, 23°C

Ethers

- ✓ Diethyl ether, 23°C

Mineral oils

- ✓ SAE 10W40 multigrade motor oil, 23°C
- ✗ SAE 10W40 multigrade motor oil, 130°C
- ✗ SAE 80/90 hypoid-gear oil, 130°C
- ✓ Insulating Oil, 23°C
- ✗ Motor oil OS206 304 Ref.Eng.Oil, ISP, 135°C
- ✗ Automatic hypoid-gear oil Shell Donax TX, 135°C
- ✗ Hydraulic oil Pentosin CHF 202, 125°C

Standard Fuels

- ✗ ISO 1817 Liquid 1 - E5, 60°C
- ✗ ISO 1817 Liquid 2 - M15E4, 60°C
- ✗ ISO 1817 Liquid 3 - M3E7, 60°C
- ✗ ISO 1817 Liquid 4 - M15, 60°C
- ✓ Standard fuel without alcohol (pref. ISO 1817 Liquid C), 23°C
- ✓ Standard fuel with alcohol (pref. ISO 1817 Liquid 4), 23°C

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- ✓ Diesel fuel (pref. ISO 1817 Liquid F), 23°C
- ✓ Diesel fuel (pref. ISO 1817 Liquid F), 90°C
- ✗ Diesel fuel (pref. ISO 1817 Liquid F), >90°C

Salt solutions

- ✓ Sodium Chloride solution (10% by mass), 23°C
- ✓ Sodium Hypochlorite solution (10% by mass), 23°C
- ✓ Sodium Carbonate solution (20% by mass), 23°C
- ✓ Sodium Carbonate solution (2% by mass), 23°C
- ✓ Zinc Chloride solution (50% by mass), 23°C

Other

- ✓ Ethyl Acetate, 23°C
- ✗ Hydrogen peroxide, 23°C
- ✗ DOT No. 4 Brake fluid, 130°C
- ✗ Ethylene Glycol (50% by mass) in water, 108°C
- ✓ 1% nonylphenoxy-polyethyleneoxy ethanol in water, 23°C
- ✓ 50% Oleic acid + 50% Olive Oil, 23°C
- ✓ Water, 23°C
- ✗ Water, 90°C
- ✓ Phenol solution (5% by mass), 23°C

Symbols used:

- ✓ possibly resistant
Defined as: Supplier has sufficient indication that contact with chemical can be potentially accepted under the intended use conditions and expected service life. Criteria for assessment have to be indicated (e.g. surface aspect, volume change, property change).
- ✗ not recommended - see explanation
Defined as: Not recommended for general use. However, short-term exposure under certain restricted conditions could be acceptable (e.g. fast cleaning with thorough rinsing, spills, wiping, vapor exposure).

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