

# Crastin® SK609 NC010

## THERMOPLASTIC POLYESTER RESIN

Crastin® SK609 NC010 is a 50% glass fiber reinforced, lubricated polybutylene terephthalate resin for injection molding.

### General Information

Resin Identification ISO 1043  
Density ISO 1183

PBT-GF50  
1720 kg/m<sup>3</sup>

### Drying

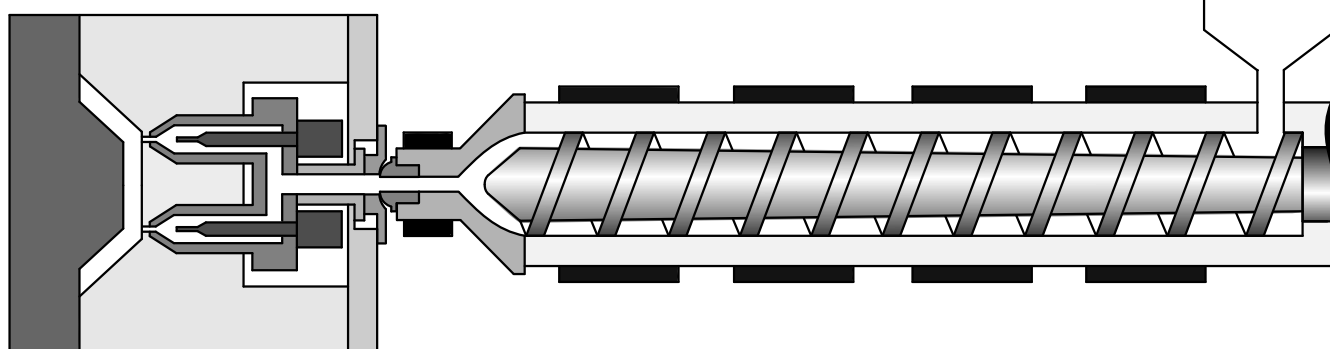
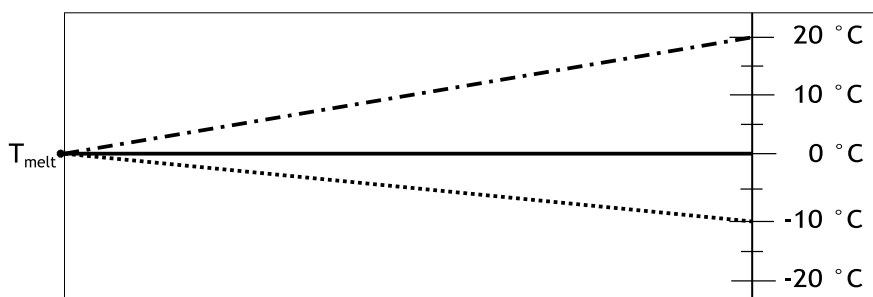
Drying Recommended  
Drying Temperature  
Drying Time\*  
Processing Moisture Content

yes  
120 °C  
2 - 4 h  
≤0.04 %

### Temperature settings

Melt Temperature Optimum	260 °C
Min. melt temperature***	250 °C
Max. melt temperature	270 °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)    . . . . .



# Crastin® SK609 NC010

## THERMOPLASTIC POLYESTER RESIN

### 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

The information set forth herein is furnished free of charge, is based on technical data that DuPont believes to be reliable, and represents typical values that fall within the normal range of properties. This information relates only to the specific material designated and may not be valid for such material used in combination with other materials or in other processes. It is intended for use by persons having technical skill, at their own discretion and risk. This information should not be used to establish specification limits nor used alone as the basis of design. Handling precaution information is given with the understanding that those using it will satisfy themselves that their particular conditions of use present no health or safety hazards and comply with applicable law. Since conditions of product use and disposal are outside our control, we make no warranties, express or implied, and assume no liability in connection with any use of this information. As with any product, evaluation under end-use conditions prior to specification is essential. Nothing herein is to be taken as a license to operate or a recommendation to infringe on patents.

CAUTION: Do not use DuPont materials in medical applications involving implantation in the human body or contact with internal body fluids or tissues unless the material has been provided from DuPont under a written contract or other acknowledgement that is consistent with the DuPont policy regarding medical applications and expressly acknowledges the contemplated use. For further information, please contact your DuPont representative.

DuPont's sole warranty is that our products will meet our standard sales specifications in effect at the time of shipment. Your exclusive remedy for breach of such warranty is limited to refund of purchase price or replacement of any product shown to be other than as warranted. TO THE FULLEST EXTENT PERMITTED BY APPLICABLE LAW, DUPONT SPECIFICALLY DISCLAIMS ANY OTHER EXPRESS OR IMPLIED WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE, MERCHANTABILITY, OR NON-INFRINGEMENT. DUPONT DISCLAIMS LIABILITY FOR ANY SPECIAL, INCIDENTAL, OR CONSEQUENTIAL DAMAGES.