INJECTION DATASHEET

Crastin® SK612SF NC010

THERMOPLASTIC POLYESTER RESIN

Crastin® SK612SF is a 15% glass fiber reinforced, low viscosity polybutylene terephthalate for injection molding. It has high flow characteristics and is specifically suitable for super fast production.

General Information

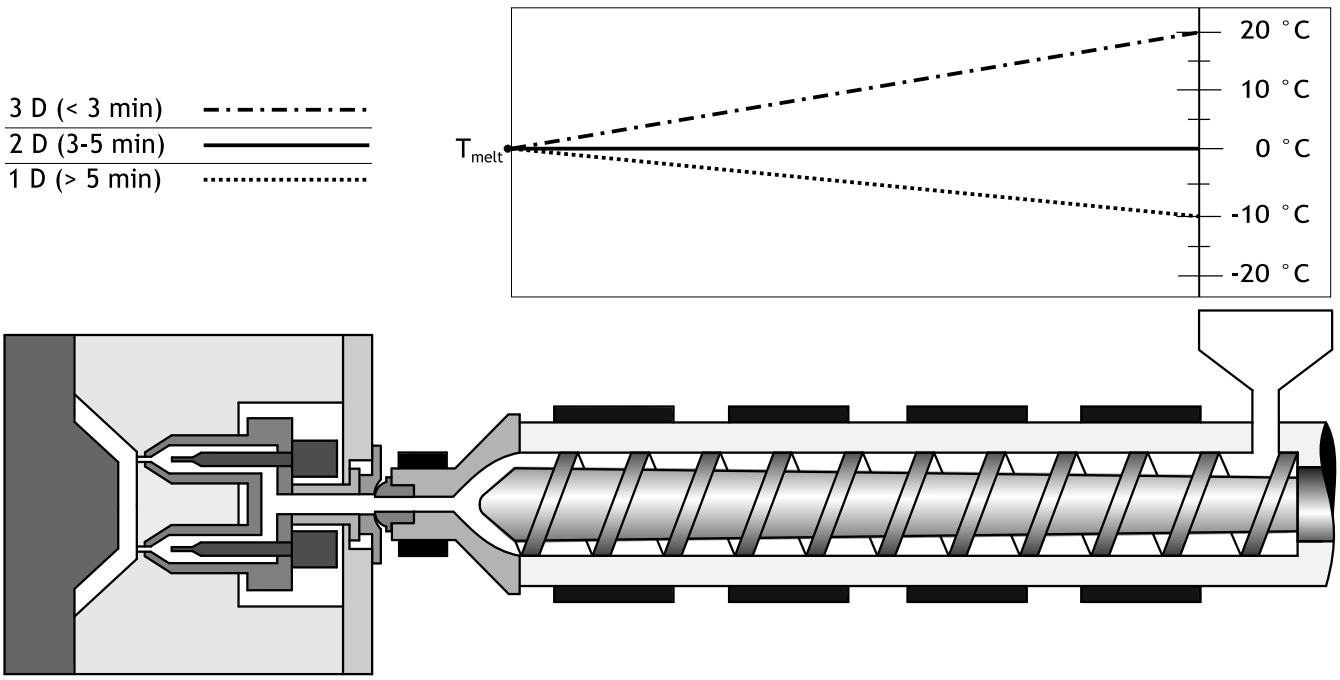
Resin Identification ISO 1043	PBT-GF15
Density ISO 1183	1410 kg/m³

Drying

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

Temperature settings

Melt Temperature Optimum	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



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Recommended general settings

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

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

Hot runner residence time not included in calculation

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.

Links for further information

Trouble Shooting Guide
For further information e.g. on Shrinkage, Hot runner systems, Venting, Gating, Drying and moisture measurement, Regrind, 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