

Crastin® SK615SF NC010

THERMOPLASTIC POLYESTER RESIN

Crastin® SK615SF is a 30% glass fiber reinforced, low viscosity polybutylene terephthalate for injection molding. It has high flow characteristics and is specifically suitable for super fast production. It is laser markable.

General Information

Resin Identification ISO 1043

Density ISO 1183

PBT-GF30

1530 kg/m³

Drying

Drying Recommended

Drying Temperature

Drying Time*

Processing Moisture Content

yes

120 °C

2 - 4 h

≤0.04 %

Temperature settings

Melt Temperature Optimum

Min. melt temperature***

Max. melt temperature

Mold Temperature Optimum

Min. mold temperature

Max. mold temperature

240 °C

235 °C

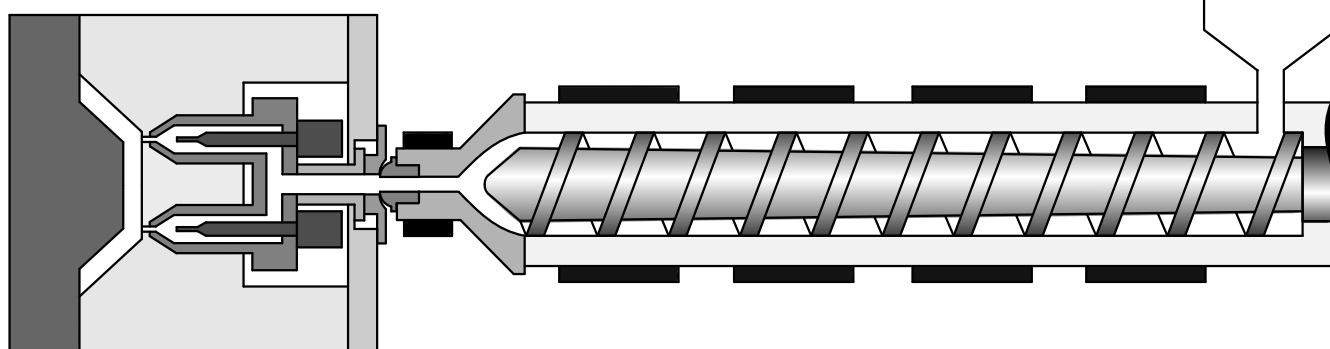
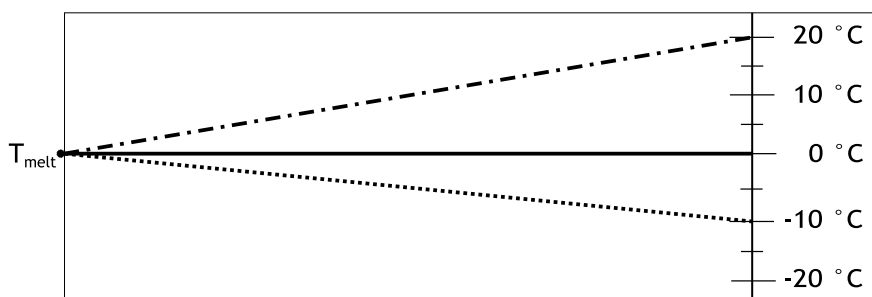
260 °C

80 °C

30 °C

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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