

# Crastin® SK645FR BK851

## THERMOPLASTIC POLYESTER RESIN

Crastin® SK645FR is a flame retardant, 30% glass reinforced polybutylene terephthalate molding resin. It is recognized as UL94V-0 at 0.75mm.

### General Information

Resin Identification ISO 1043 PBT-GF30FR(17)  
 Density ISO 1183 1690 kg/m<sup>3</sup>

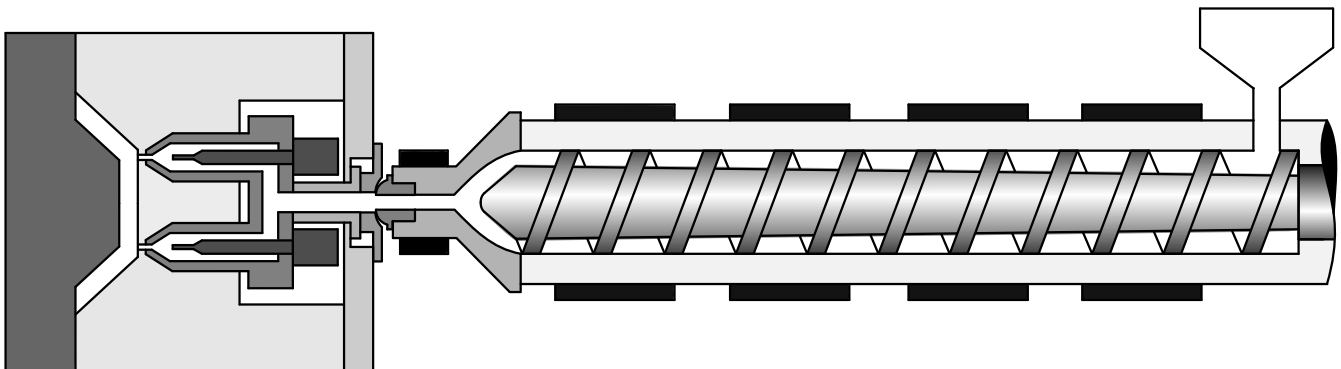
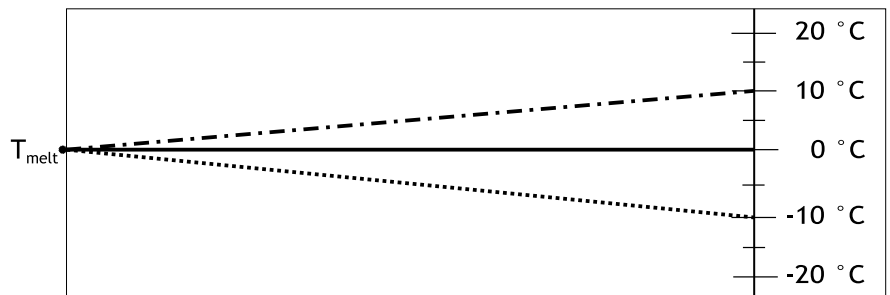
### Drying

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 (< 2 min) - - - - -  
 2 D (2-4 min) ————  
 1 D (4-6 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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