

DuPont™ Crastin® S620F20 NC010

THERMOPLASTIC POLYESTER RESIN

Product Information

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® S620F20 NC010 is an unreinforced, nucleated, lubricated, medium viscosity polybutylene terephthalate resin for fast injection molding.

General information	Value	Unit	Test Standard
Resin Identification	PBT	-	-
Part Marking Code	>PBT<	-	ISO 11469
Rheological properties	Value	Unit	Test Standard
Melt mass-flow rate	19.1	g/10min	ISO 1133
Melt mass-flow rate, Temperature	250	°C	-
Melt mass-flow rate, Load	2.16	kg	-
Viscosity number	130	cm ³ /g	ISO 307, 1157, 1628
Moulding shrinkage, parallel	1.7	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.6	%	ISO 294-4, 2577
Mechanical properties	Value	Unit	Test Standard
Tensile Modulus	2600	MPa	ISO 527-1/-2
Yield stress	59	MPa	ISO 527-1/-2
Yield strain	8	%	ISO 527-1/-2
Nominal strain at break	30	%	ISO 527-1/-2
Strain at Break, 23°C, 50mm/min	>50	%	ISO 527-1/-2
Flexural Strength	88	MPa	ISO 178
Tensile creep modulus			ISO 899-1
1h	2600	MPa	
1000h	1800	MPa	
Charpy impact strength			ISO 179/1eU
23°C	N	kJ/m ²	
-30°C	N	kJ/m ²	
Charpy notched impact strength			ISO 179/1eA
23°C	4.5	kJ/m ²	
-30°C	3.5	kJ/m ²	
Izod notched impact strength			ISO 180/1A
23°C	4	kJ/m ²	
-30°C	5	kJ/m ²	
Izod impact strength			ISO 180/1U
23°C	142	kJ/m ²	
-30°C	70	kJ/m ²	
Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	225	°C	ISO 11357-1/-3

To find out more, visit [DuPont Performance Polymers](#) or contact nearest DuPont location.

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Temp. of deflection under load		ISO 75-1/-2		
1.8 MPa	60 °C			
0.45 MPa	145 °C			
0.45 MPa, annealed	180 °C			
1.8 MPa, annealed	60 °C			
Vicat softening temperature, 50°C/h, 50N	175 °C		ISO 306	
Coeff. of linear therm. expansion, parallel	130 E-6/K		ISO 11359-1/-2	
Coeff. of linear therm. expansion, normal	130 E-6/K		ISO 11359-1/-2	
Thermal conductivity of melt	0.21 W/(m K)		-	
Spec. heat capacity of melt	2100 J/(kg K)		-	
RTI, electrical, 0.8mm	130 °C		UL 746B	
RTI, impact, 0.8mm	115 °C		UL 746B	
RTI, strength, 0.8mm	120 °C		UL 746B	
Flammability		Value	Unit	Test Standard
Burning Behav. at 1.5mm nom. thickn.		HB	class	IEC 60695-11-10
Thickness tested		1.5	mm	IEC 60695-11-10
UL recognition		UL	-	-
Burning Behav. at thickness h		HB	class	IEC 60695-11-10
Thickness tested		0.8	mm	IEC 60695-11-10
Oxygen index		22	%	ISO 4589-1/-2
Glow Wire Flammability Index, 3mm		750	°C	IEC 60695-2-1/2
Glow Wire Ignition Temperature				IEC 60695-2-1/3
0.75mm		750	°C	
1mm		750	°C	
2mm		750	°C	
Electrical properties		Value	Unit	Test Standard
Relative permittivity				IEC 60250
100Hz		3.8	-	
1MHz		3.2	-	
Dissipation factor				IEC 60250
100Hz		20	E-4	
1MHz		200	E-4	
Volume resistivity		>1E13	Ohm*m	IEC 60093
Electric strength		26	kV/mm	IEC 60243-1
Comparative tracking index		600	-	IEC 60112
Electric Strength, 20s, 2mm		15	kV/mm	IEC 60243-1
Other properties		Value	Unit	Test Standard
Humidity absorption, 2mm		0.2	%	Sim. to ISO 62
Water absorption, 2mm		0.4	%	Sim. to ISO 62
Density		1310	kg/m ³	ISO 1183
Density of melt		1110	kg/m ³	-
VDA Properties		Value	Unit	Test Standard
Burning rate, Thickness 1 mm		0 ^[1]	mm/min	ISO 3795 (FMVSS 302)
1: SE/NBR				

Characteristics

Processing	• Injection Moulding
Delivery form	• Pellets
Additives	• Release agent
Regional Availability	• North America • Europe • Asia Pacific • South and Central America • Near East/Africa • Global

Processing Texts

Injection molding

PREPROCESSING

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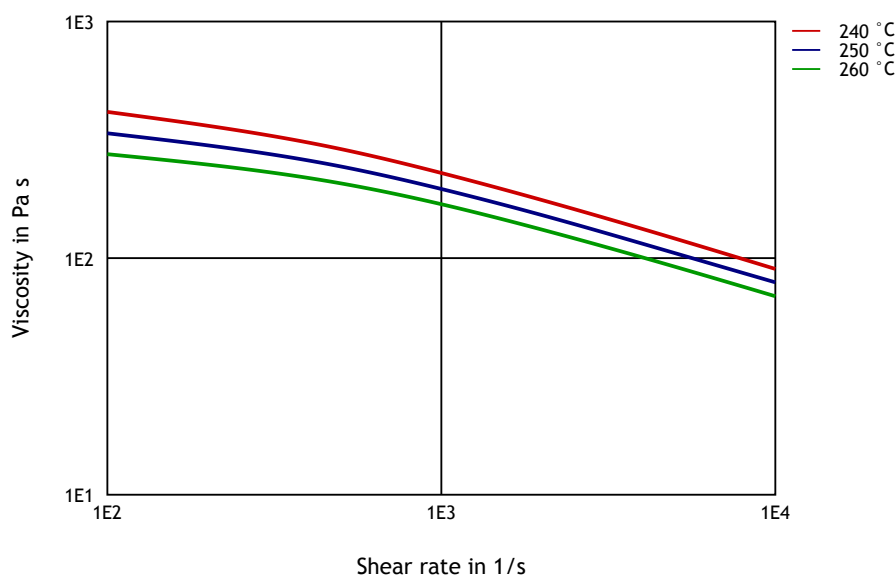
Drying recommended = Yes
Drying temperature = 110-130 °C
Drying time, dehumidified dryer = 2-4 h
Processing moisture content = <0.04 %

PROCESSING

Melt temperature optimum = 250 °C
Melt temperature range = 240-260 °C
Mould temperature optimum = 80 °C
Mould temperature range = 30-130 °C

Diagrams

Viscosity-shear rate



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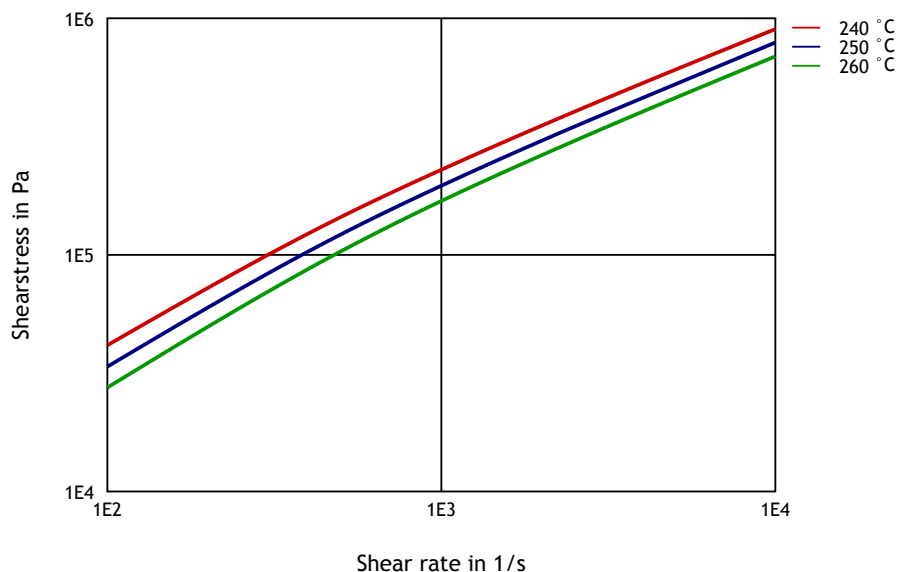
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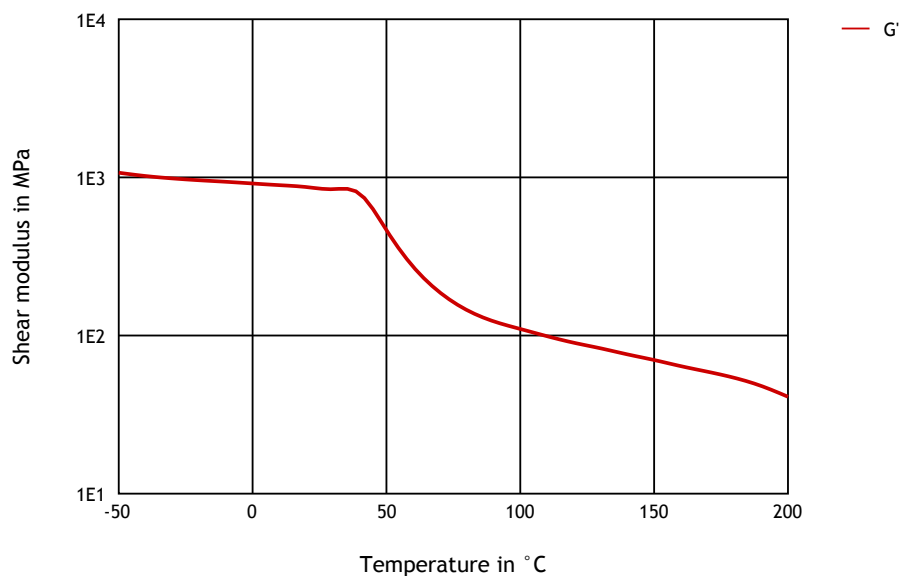
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Shearstress-shear rate



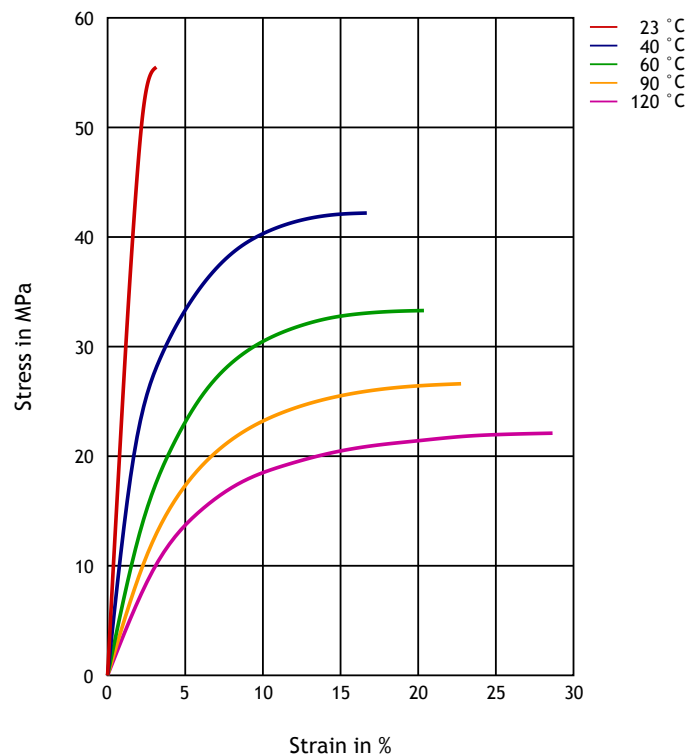
Dynamic Shear modulus-temperature



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Stress-strain



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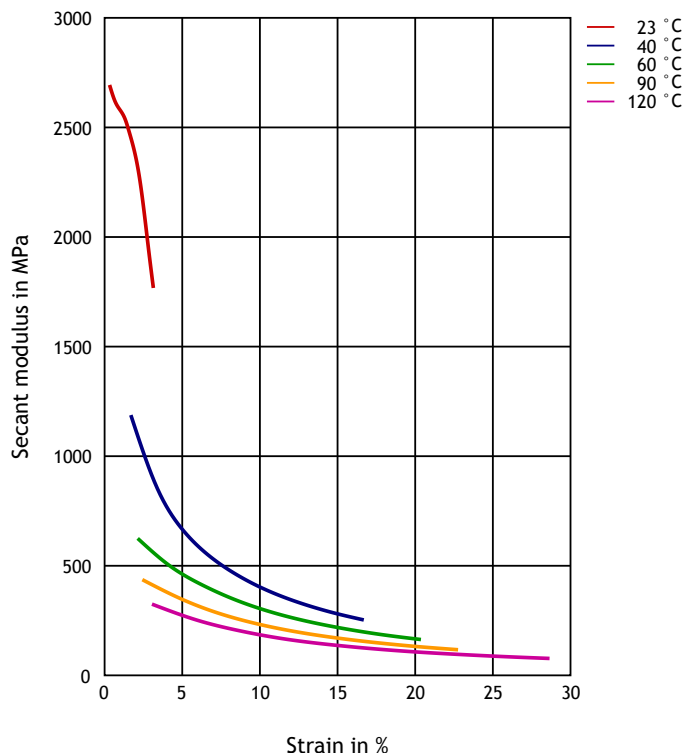
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Secant modulus-strain



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)



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- ✓ 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)

Standard Fuels

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

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-  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).

Contact DuPont for Material Safety Data Sheet, general guides and/or additional information about ventilation, handling, purging, drying, etc. ISO Mechanical properties measured at 4.0mm (Hytrel® measured at 2 mm), IEC Electrical properties measured at 2.0mm, all ASTM properties measured at 3.2mm, and test temperatures are 23°C unless otherwise stated.

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