

DuPont™ Crastin® SK601 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® SK601 NC010 is a 10% glass fiber reinforced, lubricated polybutylene terephthalate resin for injection molding.

General information	Value	Unit	Test Standard
Resin Identification	PBT-GF10	-	-
Part Marking Code	>PBT-GF10<	-	ISO 11469
Rheological properties	Value	Unit	Test Standard
Viscosity number	110	cm ³ /g	ISO 307, 1157, 1628
Moulding shrinkage, parallel	0.7	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.2	%	ISO 294-4, 2577
Mechanical properties	Value	Unit	Test Standard
Tensile Modulus	4500	MPa	ISO 527-1/-2
Stress at break	90	MPa	ISO 527-1/-2
Strain at break	4.7	%	ISO 527-1/-2
Flexural Strength	140	MPa	ISO 178
Tensile creep modulus			ISO 899-1
1h	4000	MPa	
1000h	2500	MPa	
Charpy impact strength			ISO 179/1eU
23°C	40	kJ/m ²	
-30°C	40	kJ/m ²	
Charpy notched impact strength			ISO 179/1eA
23°C	6	kJ/m ²	
-30°C	6	kJ/m ²	
Izod notched impact strength			ISO 180/1A
23°C	4.5	kJ/m ²	
-30°C	5	kJ/m ²	
Izod impact strength			ISO 180/1U
23°C	27	kJ/m ²	
-30°C	26	kJ/m ²	
Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	225	°C	ISO 11357-1/-3
Temp. of deflection under load			ISO 75-1/-2
1.8 MPa	175	°C	
0.45 MPa	215	°C	
Vicat softening temperature, 50°C/h, 50N	205	°C	ISO 306
Coeff. of linear therm. expansion, parallel	60	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	120	E-6/K	ISO 11359-1/-2
Thermal conductivity of melt	0.24	W/(m K)	-
Spec. heat capacity of melt	1890	J/(kg K)	-
RTI, electrical, 0.8mm	130	°C	UL 746B
RTI, impact, 0.8mm	115	°C	UL 746B

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

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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
UL recognition		UL	-	-
Oxygen index		20	%	ISO 4589-1/-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		3.9	-	
1MHz		3.5	-	
Dissipation factor				IEC 60250
100Hz		20	E-4	
1MHz		200	E-4	
Volume resistivity		>1E13	Ohm*m	IEC 60093
Electric strength		30	kV/mm	IEC 60243-1
Comparative tracking index		300	-	IEC 60112
Electric Strength, 20s, 2mm		17	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		1370	kg/m ³	ISO 1183
Density of melt		1190	kg/m ³	-
VDA Properties		Value	Unit	Test Standard
Burning rate, Thickness 1 mm		36	mm/min	ISO 3795 (FMVSS 302)

Characteristics

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

Processing Texts

Injection molding

PREPROCESSING

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

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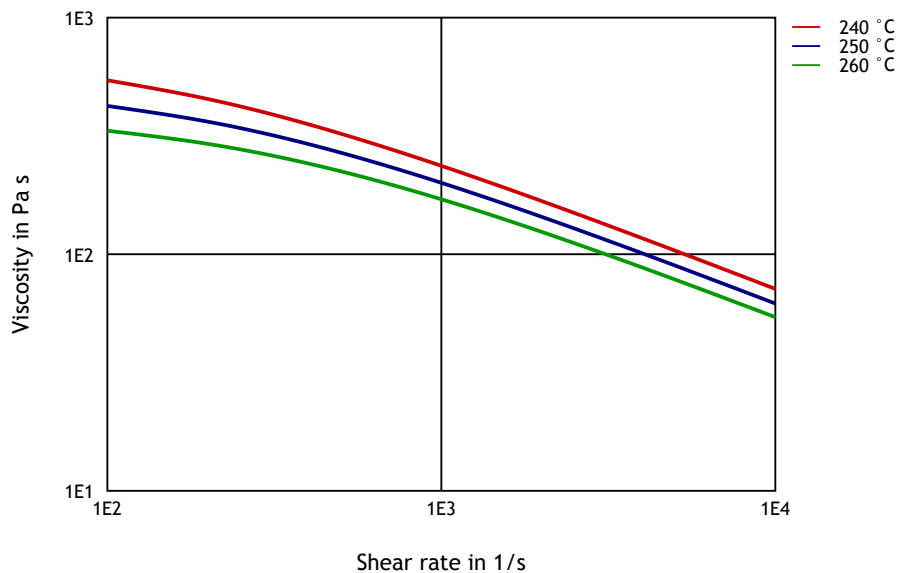


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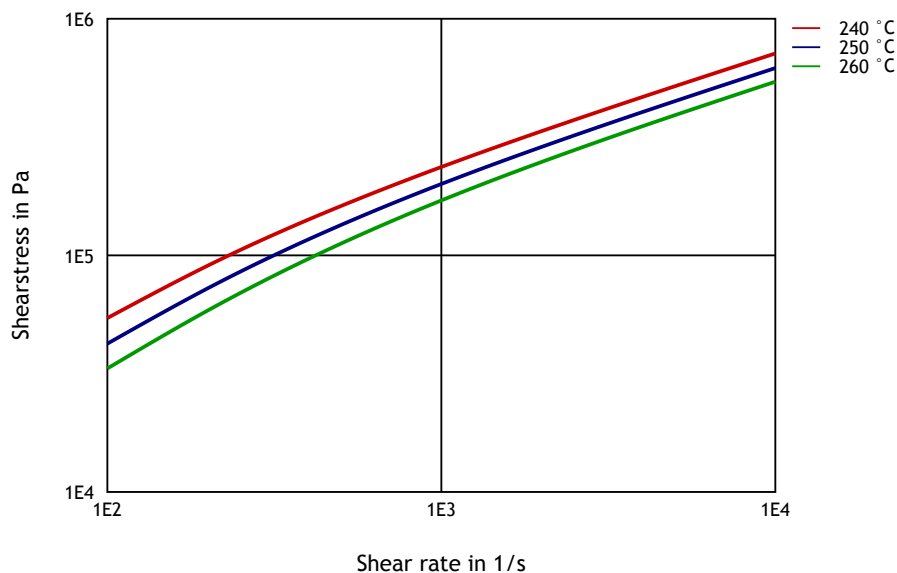
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Diagrams

Viscosity-shear rate



Shearstress-shear rate



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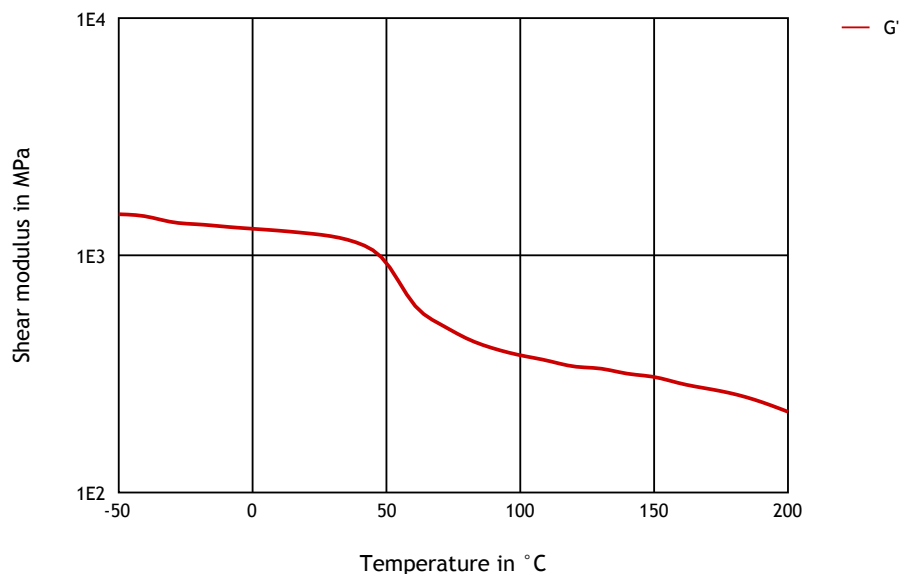
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Dynamic Shear modulus-temperature



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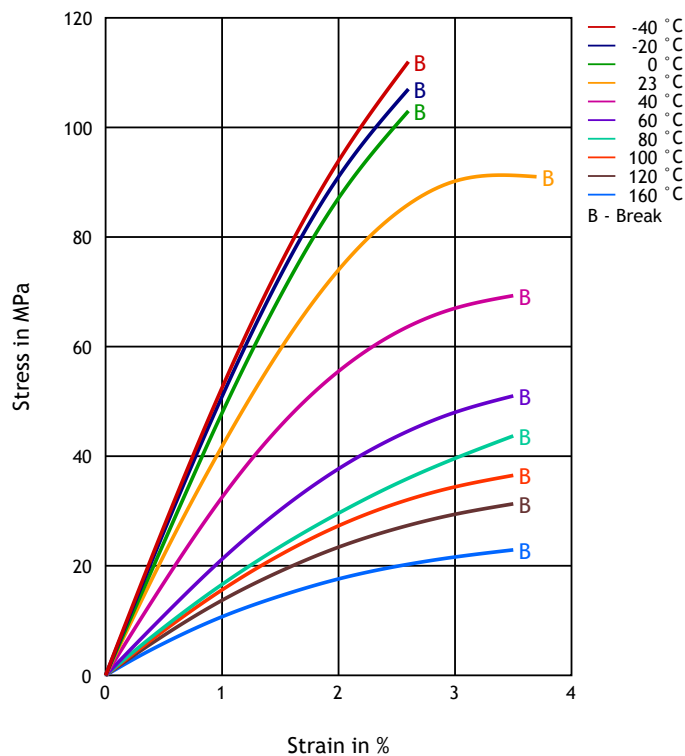
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Stress-strain



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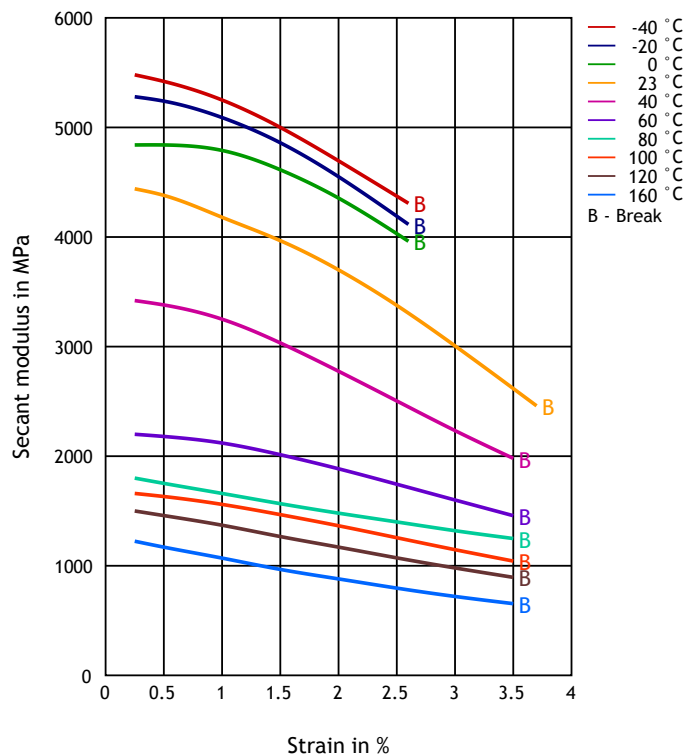
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THERMOPLASTIC POLYESTER RESIN

Secant modulus-strain



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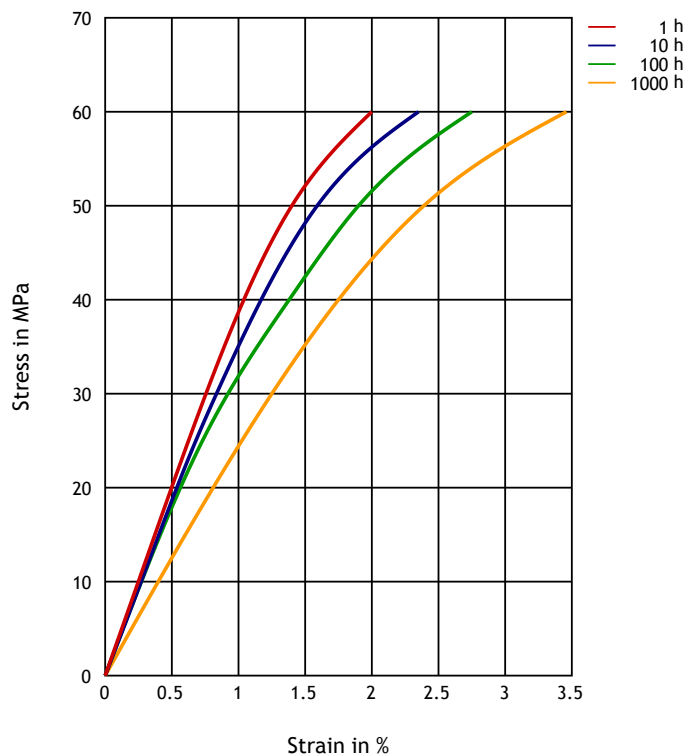
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THERMOPLASTIC POLYESTER RESIN

Stress-strain (isochronous) 23°C



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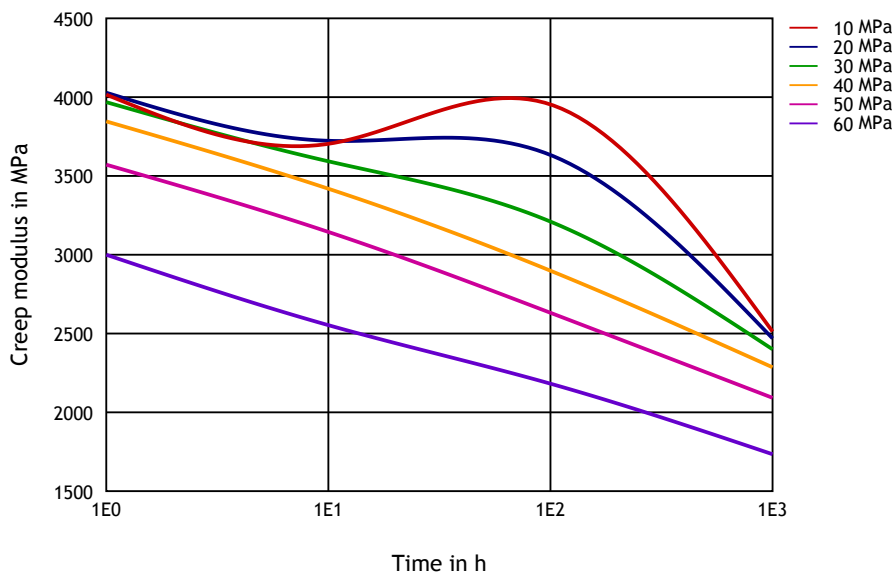
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THERMOPLASTIC POLYESTER RESIN

Creep modulus-time 23 °C



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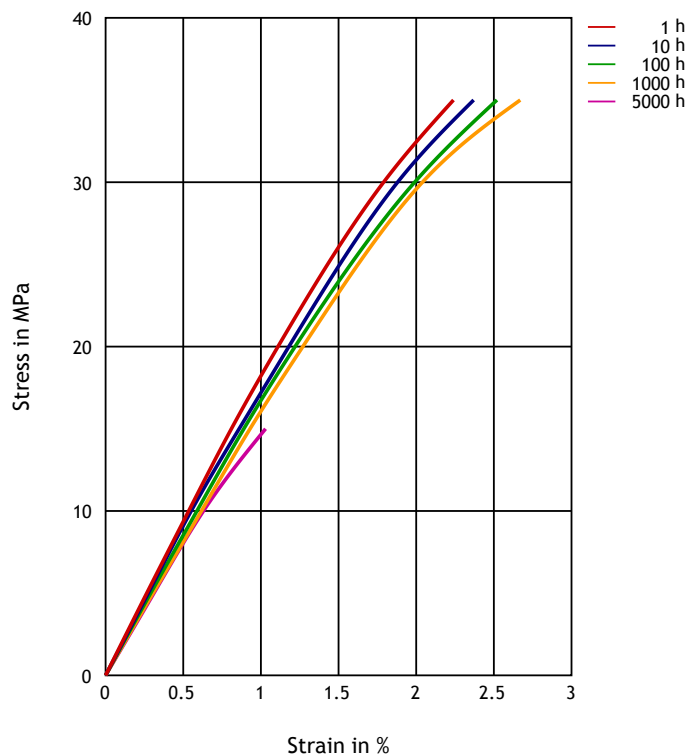
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THERMOPLASTIC POLYESTER RESIN

Stress-strain (isochronous) 60°C



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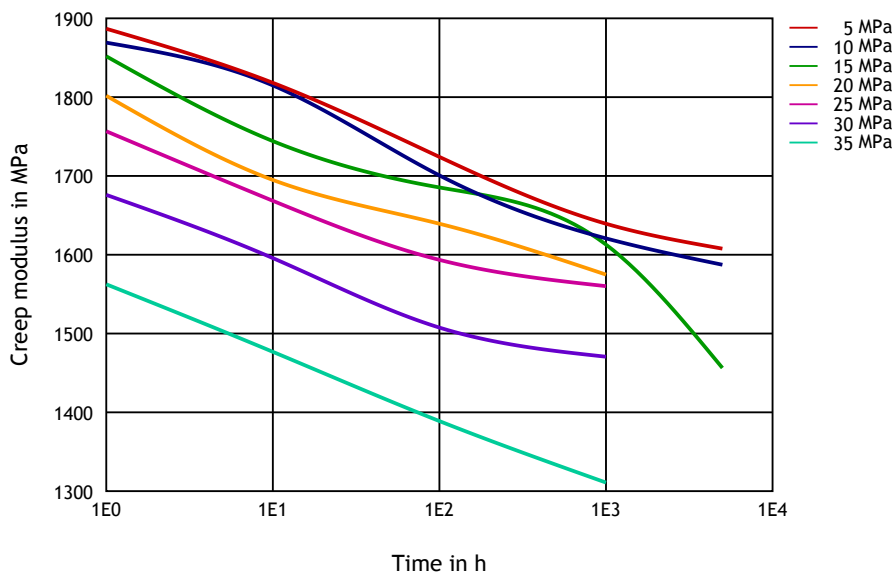
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THERMOPLASTIC POLYESTER RESIN

Creep modulus-time 60 °C



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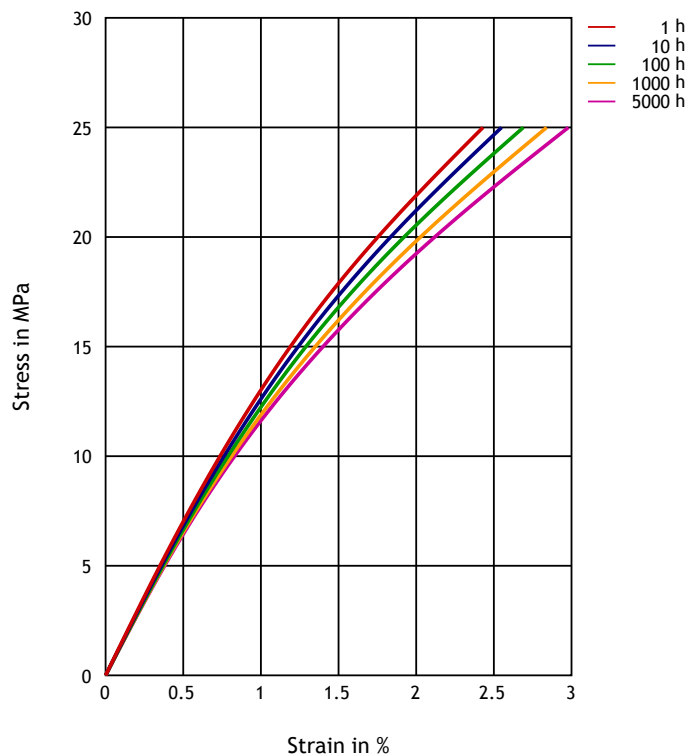
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THERMOPLASTIC POLYESTER RESIN

Stress-strain (isochronous) 110°C



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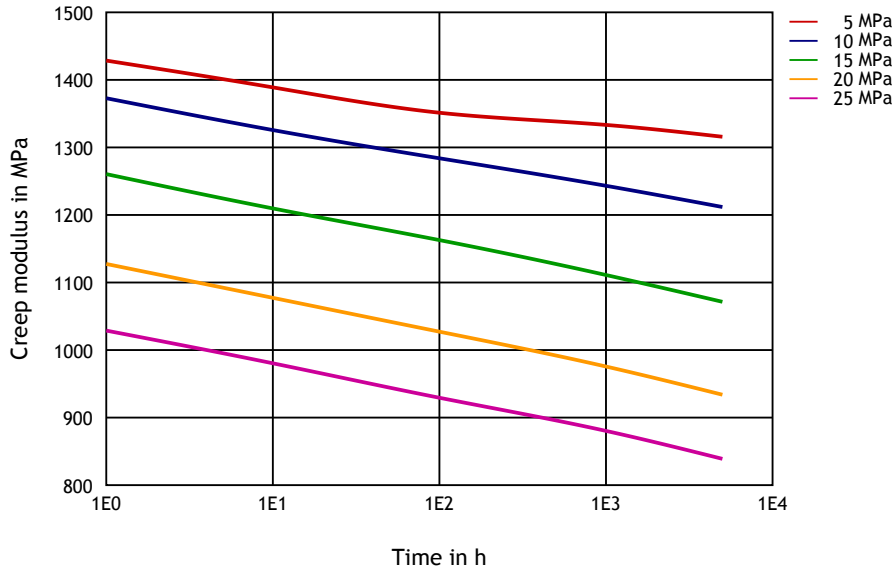
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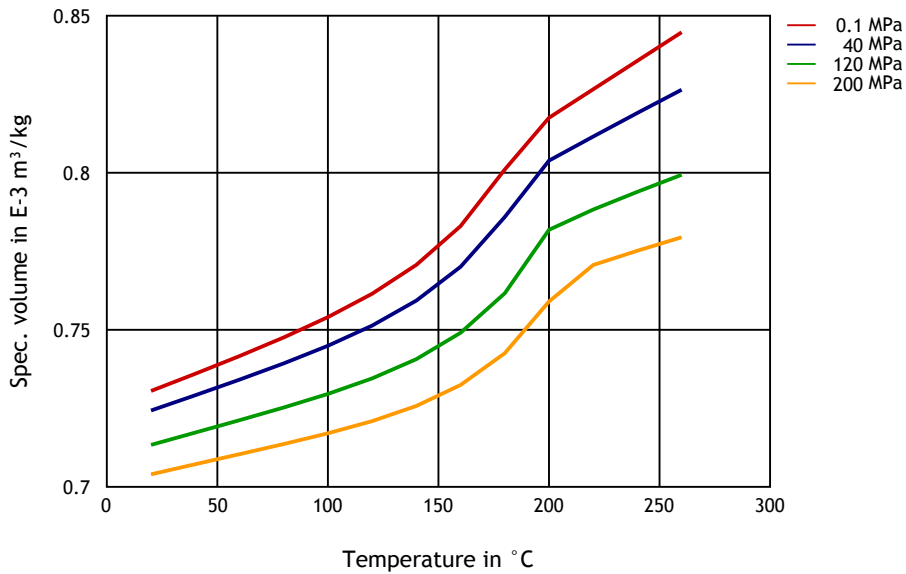
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Creep modulus-time 110 °C



Specific volume-temperature (pvT)



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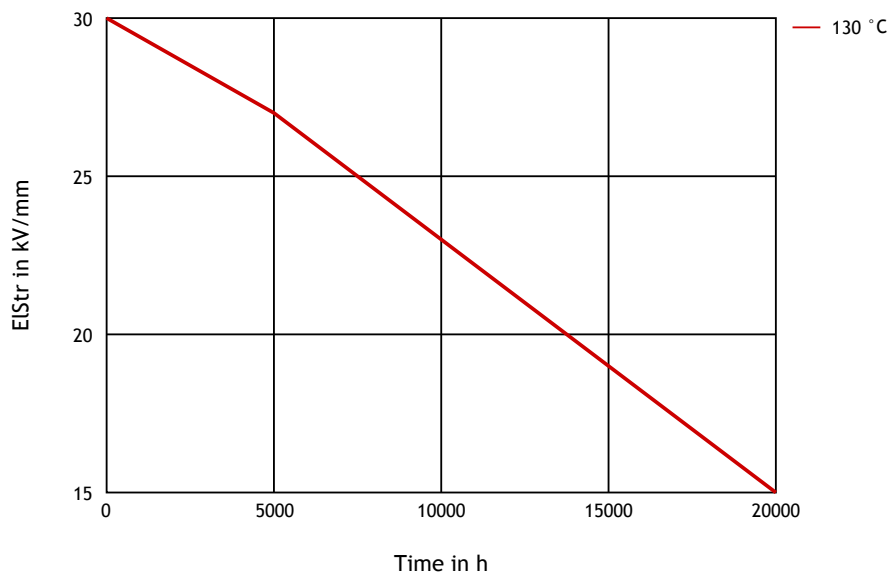
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LTHA-Electric Strength 1mm



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)
- ✓ Methanol (23 °C)
- ✓ Ethanol (23 °C)

Hydrocarbons

- ✓ n-Hexane (23 °C)
- ✓ Toluene (23 °C)

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✓ 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)
- ✗ 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).

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X 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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