

# DuPont™ Crastin® SK615SF NC010 (Preliminary Data)

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

General information	Value	Unit	Test Standard
Resin Identification	PBT-GF30	-	-
Part Marking Code	>PBT-GF30<	-	ISO 11469
Rheological properties	Value	Unit	Test Standard
Moulding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.1	%	ISO 294-4, 2577
Mechanical properties	Value	Unit	Test Standard
Tensile Modulus	10000	MPa	ISO 527-1/-2
Stress at break	150	MPa	ISO 527-1/-2
Strain at break	2.5	%	ISO 527-1/-2
Charpy impact strength			ISO 179/1eU
23 °C	60	kJ/m <sup>2</sup>	
-30 °C	30	kJ/m <sup>2</sup>	
Charpy notched impact strength, 23 °C	9	kJ/m <sup>2</sup>	ISO 179/1eA
Thermal properties	Value	Unit	Test Standard
Melting temperature, 10 °C/min	223	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	210	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	30	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	80	E-6/K	ISO 11359-1/-2
Thermal conductivity of melt	0.28	W/(m K)	-
Spec. heat capacity of melt	1730	J/(kg K)	-
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
Burning Behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	3.0	mm	IEC 60695-11-10
Oxygen index	19	%	ISO 4589-1/-2
Electrical properties	Value	Unit	Test Standard
Relative permittivity			IEC 60250
100Hz	4.4	-	
1MHz	3.8	-	
Dissipation factor			IEC 60250
100Hz	25	E-4	
1MHz	180	E-4	
Volume resistivity	>1E13	Ohm*m	IEC 60093
Surface resistivity	>1E15	Ohm	IEC 60093
Electric strength	31	kV/mm	IEC 60243-1
Comparative tracking index	370	-	IEC 60112

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

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Other properties	Value	Unit	Test Standard
Humidity absorption, 2mm	0.15	%	Sim. to ISO 62
Water absorption, 2mm	0.35	%	Sim. to ISO 62
Density	1540	kg/m <sup>3</sup>	ISO 1183
Density of melt	1360	kg/m <sup>3</sup>	-

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

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 = 235-260°C  
 Mould temperature optimum = 80°C  
 Mould temperature range = 30-130°C

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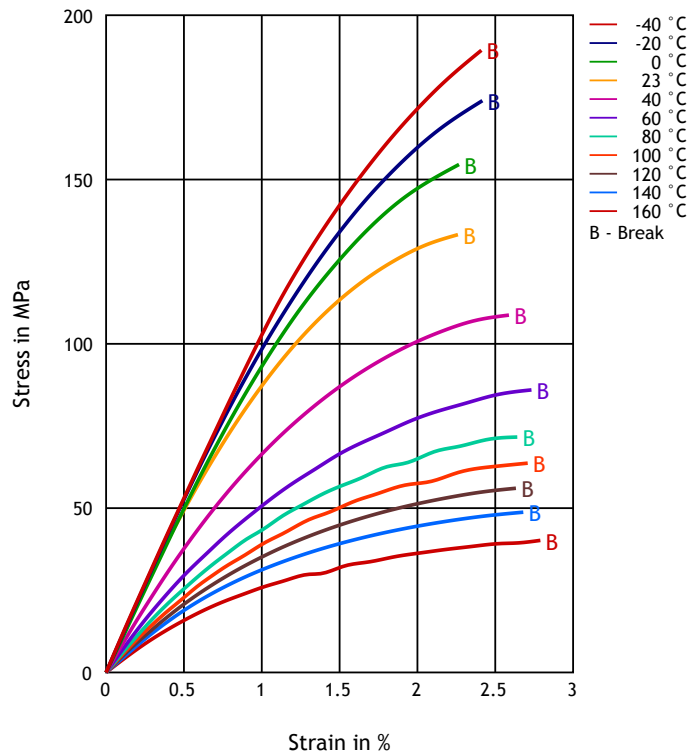


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Diagrams

Stress-strain



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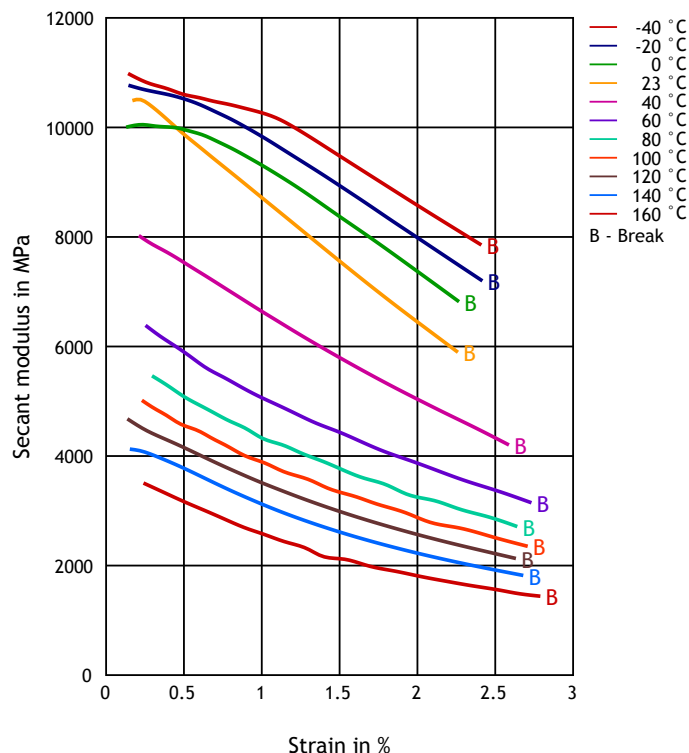
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### Secant modulus-strain



### 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)
- ✓ Water (23°C)
- ✗ Water (90°C)

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✓ 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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