

DuPont™ Crastin® SK643FR BK851

THERMOPLASTIC POLYESTER RESIN

Product Information

Crastin® SK643FR BK851 is a 20% Glass Reinforced, Flame Retardant, Polybutylene Terephthalate

General information	Value	Unit	Test Standard
Resin Identification	PBT-GF20FR(17)	-	ISO 1043
Part Marking Code	>PBT-GF20FR(17)<	-	ISO 11469
Rheological properties	Value	Unit	Test Standard
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
Molding shrinkage, normal	1.2	%	ISO 294-4, 2577
Molding shrinkage, parallel, annealed	0.6	%	ISO 294-4
Molding shrinkage, normal, annealed	1.45	%	ISO 294-4
Mechanical properties	Value	Unit	Test Standard
Tensile Modulus	8300	MPa	ISO 527-1/-2
Stress at break	110	MPa	ISO 527-1/-2
Strain at break	2.8	%	ISO 527-1/-2
Flexural Strength	165	MPa	ISO 178
Charpy impact strength, 73°F	50	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 73°F	7.6	kJ/m ²	ISO 179/1eA
Thermal properties	Value	Unit	Test Standard
Melting temperature, 18°F/min	225	°C	ISO 11357-1/-3
Temp. of deflection under load, 260 psi	200	°C	ISO 75-1/-2
RTI, electrical			UL 746B
30mil	140	°C	
60mil	140	°C	
120mil	140	°C	
240mil	140	°C	
RTI, impact			UL 746B
30mil	130	°C	
60mil	130	°C	
120mil	130	°C	
240mil	130	°C	
RTI, strength			UL 746B
30mil	140	°C	
60mil	140	°C	
120mil	140	°C	
240mil	140	°C	
Flammability	Value	Unit	Test Standard
Burning Behav. at 60mil nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	1.5	mm	IEC 60695-11-10
UL recognition	UL	-	UL 94
Burning Behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	0.75	mm	IEC 60695-11-10
Oxygen index	32	%	ISO 4589-1/-2
Burning rate, Thickness 1 mm	DNI	mm/min	ISO 3795 (FMVSS 302)
Electrical properties	Value	Unit	Test Standard
Comparative tracking index	225	-	IEC 60112
Other properties	Value	Unit	Test Standard
Humidity absorption, 80mil	0.13	%	Sim. to ISO 62
Water absorption, 80mil	0.32	%	Sim. to ISO 62
Density	1630	kg/m ³	ISO 1183
Injection	Value	Unit	Test Standard
Drying Recommended	yes	-	-
Drying Temperature	120	°C	-
Drying Time, Dehumidified Dryer	2 - 4	h	-

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

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Processing Moisture Content	≤0.04 %	-
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	-
Hold pressure range	≥60 MPa	-
Hold pressure time	3 s/mm	-
Back pressure	As low as possible	-
Ejection temperature	170 °C	-

Characteristics

Regional Availability	<ul style="list-style-type: none">• North America• Europe	<ul style="list-style-type: none">• Asia Pacific• South and Central America	<ul style="list-style-type: none">• Near East/Africa• Global
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Contact DuPont for Material Safety Data Sheet, general guides and/or additional information about ventilation, handling, purging, drying, etc. ISO Mechanical properties measured at 160 mil (Hytrel® measured at 80 mil), IEC Electrical properties measured at 80 mil, all ASTM properties measured at 120 mil, and test temperatures are 73°F unless otherwise stated.

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