

DuPont™ Crastin® PBT

thermoplastic polyester resin

PRELIMINARY DATA

Crastin® SK615SF BK591

Crastin® SK615SF BK591 is a 30% glass fiber reinforced, low viscosity polybutylene terephthalate for injection molding. It has high flow characteristics and is specifically suitable for super fast production. It is laser markable.

Property	Test Method	Units	Value
Identification			
Resin Identification	ISO 1043		PBT-GF30
Part Marking Code	ISO 11469		>PBT-GF30<
Mechanical			
Stress at Break	ISO 527	MPa (kpsi)	145 (21)
Strain at Break	ISO 527	%	2.5
Tensile Modulus	ISO 527	MPa (kpsi)	10000 (1450)
Notched Charpy Impact Strength	ISO 179/1eA	kJ/m ²	8.0
Thermal			
Deflection Temperature 1.80MPa	ISO 75-1/-2	°C (°F)	209 (408)
Melting Temperature 10°C/min	ISO 11357-1/-3	°C (°F)	222 (432)
Rheological			
Melt Volume-Flow Rate 250°C, 2.16kg	ISO 1133	cm ³ /10 min	20

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, ISO Electrical properties measured at 2.0mm, and all ASTM properties measured at 3.2mm.
 Test temperatures are 23°C unless otherwise stated.

The above data are preliminary and are subject to change as additional data are developed on subsequent lots

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Property	Test Method	Units	Value
Other			
Density	ISO 1183	kg/m ³ (g/cm ³)	1540 (1.54)
Molding Shrinkage	ISO 294-4	%	
Normal			1.1
Parallel			0.3
Processing - Injection Molding			
Melt Temperature Range		°C (°F)	240-260 (465-500)
Melt Temperature Optimum		°C (°F)	250 (480)
Mold Temperature Range		°C (°F)	30-130 (85-265)
Mold Temperature Optimum		°C (°F)	80 (175)
Drying Time, Dehumidified Dryer		h	2-4
Drying Temperature		°C (°F)	110-130 (230-265)
Processing Moisture Content		%	<0.04

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