

# DuPont™ Crastin® PBT

thermoplastic polyester resin

PRELIMINARY DATA

## Crastin® SK615SF NC010

Crastin® SK615SF 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.

| Property                               | Test Method    | Units                                  | Value        |
|--|----------------|--|--------------|
| <b>Identification</b>                  |                |  |              |
| Resin Identification                   | ISO 1043       |  | PBT-GF30     |
| Part Marking Code                      | ISO 11469      |  | >PBT-GF30<   |
| <b>Mechanical</b>                      |                |  |              |
| Stress at Break                        | ISO 527        | MPa (kpsi)                             | 150 (21.7)   |
| Strain at Break                        | ISO 527        | %                                      | 2.5          |
| Tensile Modulus                        | ISO 527        | MPa (kpsi)                             | 10000 (1450) |
| Unnotched Charpy Impact Strength       | ISO 179/1eU    | kJ/m <sup>2</sup>                      | 60           |
| <b>Thermal</b>                         |                |  |              |
| Deflection Temperature<br>1.80MPa      | ISO 75-1/-2    | °C (°F)                                | 210 (410)    |
| Melting Temperature<br>10°C/min        | ISO 11357-1/-3 | °C (°F)                                | 223 (433)    |
| <b>Rheological</b>                     |                |  |              |
| Melt Volume-Flow Rate<br>250°C, 2.16kg | ISO 1133       | cm <sup>3</sup> /10 min                | 19           |
| <b>Other</b>                           |                |  |              |
| Density                                | ISO 1183       | kg/m <sup>3</sup> (g/cm <sup>3</sup> ) | 1540 (1.54)  |
| Molding Shrinkage                      | ISO 294-4      | %                                      |              |
| Normal                                 |                |  | 1.1          |
| Parallel                               |                |  | 0.3          |

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             |
|---------------------------------------|-------------|---------|-------------------|
| <b>Processing - Injection Molding</b> |             |         |                   |
| Melt Temperature Range                |             | °C (°F) | 235-260 (465-500) |
| Melt Temperature Optimum              |             | °C (°F) | 240 (464)         |
| 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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