



ISO 75-1/-2

Crastin® S600F40 BK851

THERMOPLASTIC POLYESTER RESIN

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, we recommend, 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® S600F40 NC010 is an unreinforced, lubricated, low viscosity polybutylene terephthalate resin for injection moulding.

Product information			
Resin Identification	PBT		ISO 1043
Part Marking Code	>PBT<		ISO 11469
Rheological properties			
Melt mass-flow rate	40	g/10min	ISO 1133
Melt mass-flow rate, Temperature	250	°C	
Melt mass-flow rate, Load	2.16	kg	
Intrinsic viscosity	0.965	-	ISO 307, 1628
Moulding shrinkage, parallel	1.8	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.8	%	ISO 294-4, 2577
Typical mechanical properties			
Tensile modulus	2600	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	58	MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	4	%	ISO 527-1/-2
Nominal strain at break	20	%	ISO 527-1/-2
Tensile strain at break, 50mm/min	30	%	ISO 527-1/-2
Flexural modulus	2400	MPa	ISO 178
Flexural strength	85	MPa	ISO 178
Charpy notched impact strength, 23°C	4.5	kJ/m²	ISO 179/1eA
Izod notched impact strength, 23°C	4	kJ/m²	ISO 180/1A
Izod notched impact strength, -40°C	4.0	kJ/m²	ISO 180/1A
Ball indentation hardness, H 961/30	139	MPa	ISO 2039-1
Poisson's ratio	0.38		
Thermal properties			
Melting temperature, 10 °C/min	225	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min		°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa,		°C	ISO 75-1/-2

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150 °C

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Temperature of deflection under load, 0.45 MPa

annealed





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Temperature of deflection under load, 0.45 MPa, annealed	180	°C	ISO 75-1/-2
RTI, electrical, 0.75mm	130	°C	UL 746B
RTI, electrical, 0.75mm	130		UL 746B
RTI, electrical, 3.0mm	130		UL 746B
	130		UL 746B
RTI, electrical, 6mm			
RTI, impact, 0.75mm	115 115		UL 746B UL 746B
RTI, impact, 1.5mm			
RTI, impact, 3.0mm	115 115		UL 746B
RTI, impact, 6mm	120		UL 746B
RTI, strength, 0.75mm			UL 746B
RTI, strength, 1.5mm	120		UL 746B
RTI, strength, 3.0mm	120		UL 746B
RTI, strength, 6mm	120	-0	UL 746B
Flammability			
Burning Behav. at 1.5mm nom. thickn.		class	IEC 60695-11-10
Thickness tested		mm	IEC 60695-11-10
UL recognition	yes		UL 94
Burning Behav. at thickness h		class	IEC 60695-11-10
Thickness tested	0.75	mm	IEC 60695-11-10
UL recognition	yes		UL 94
Glow Wire Flammability Index, 3.0mm	750	°C	IEC 60695-2-12
FMVSS Class	В	, .	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	28	mm/min	ISO 3795 (FMVSS 302)
Electrical properties			
Comparative tracking index	375 ^[DS]		IEC 60112
[DS]: Derived from similar grade			
Physical/Other properties			
Density	1310	kg/m³	ISO 1183
VDA Properties			
•	0	-1	\/DA 070
Odour		class	VDA 270
Fogging, F-value (refraction)	95		ISO 6452
Fogging, G-value (condensate)	0.2	mg	ISO 6452
Injection			
Drying Recommended	yes		
Drying Temperature	120	°C	
Drying Time, Dehumidified Dryer	2 - 4		
Processing Moisture Content	≤0.04	%	
Melt Temperature Optimum	250		
Min. melt temperature	240		
Max. melt temperature	260		
Mold Temperature Optimum	80	°C	

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Min. mould temperature60 °CMax. mould temperature130 °CHold pressure range≥60 MPaHold pressure time4 s/mmBack pressureAs low as MPapossiblepossibleEjection temperature170 °C

Characteristics

Processing Injection Moulding
Additives Release agent

Additional information

Injection molding

To minimize the volatile content in the final product, dry the resin to ≤0.01% water content. In injection molding, use the lowest possible melt temperature (recommended 240 °C) and shortest feasible residence time (recommended 2-3 minutes). Store the parts in a ventilated, clean area before use. If assistance is needed please contact your Celanese account representative.

These recommendations are based on internal Celanese testing. For drying and injection molding conditions outside the above parameters, customer must test for and verify suitably low volatiles emissions on molded articles to confirm the final product is suitably pure for its intended use.

Automotive

 OEM
 STANDARD

 Ford
 WSK-M4D636-A2

 Ford
 WSS-M4D1014-A

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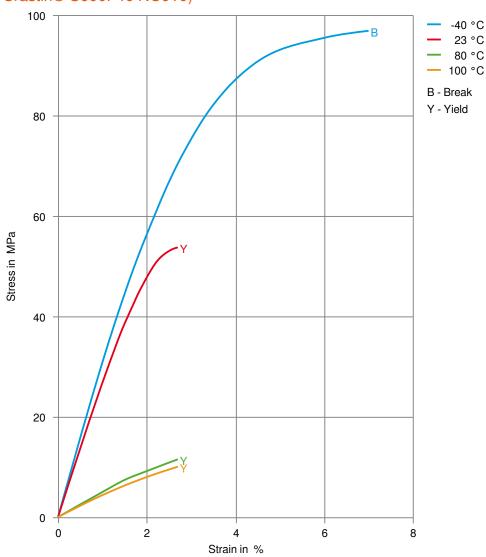
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THERMOPLASTIC POLYESTER RESIN

Stress-strain (measured on Crastin® S600F40 NC010)



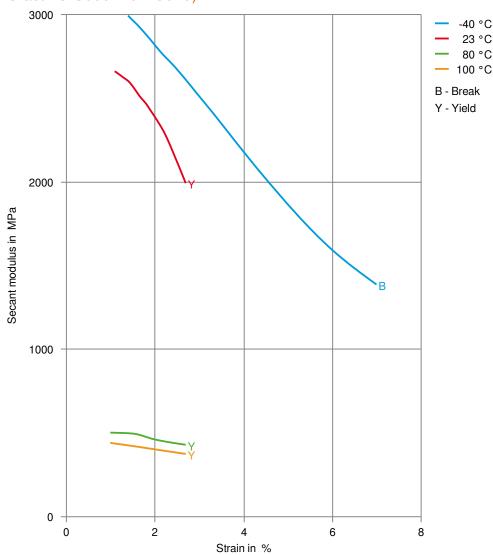
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THERMOPLASTIC POLYESTER RESIN

Secant modulus-strain (measured on Crastin® S600F40 NC010)



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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
- X Hydrochloric Acid (36% by mass), 23°C
- X Nitric Acid (40% by mass), 23°C
- X Sulfuric Acid (38% by mass), 23°C
- X Sulfuric Acid (5% by mass), 23°C
- X Chromic Acid solution (40% by mass), 23°C

Bases

- X 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
- ✓ iso-Octane, 23°C

Ketones

✓ Acetone, 23°C

Ethers

✓ Diethyl ether, 23°C

Mineral oils

- ✓ SAE 10W40 multigrade motor oil, 23°C
- X SAE 10W40 multigrade motor oil, 130°C
- X SAE 80/90 hypoid-gear oil, 130°C
- ✓ Insulating Oil, 23°C

Standard Fuels

- X ISO 1817 Liquid 1 E5, 60°C
- ★ ISO 1817 Liquid 2 M15E4, 60°C
- X ISO 1817 Liquid 3 M3E7, 60°C
- X ISO 1817 Liquid 4 M15, 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

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- ✓ 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
- X Hydrogen peroxide, 23°C
- X 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
- X 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).

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).

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NOTICE TO USERS: Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colourants or other additives may processing conditions and environmental exposure. Other than those products expressly identified as medical grade (including by MT® product designation or otherwise), Celanese's products are not intended for use in medical or dental implants. Regardless of any such product designation, any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use. To the best of our knowledge, the information contained in this publication is accurate; however, we do not assume any liability whatsoever for the accuracy and completeness of such information. The information contained in this publication should not be construed as a promise or guarantee of specific properties of our products. It is the sole responsibility of the users to investigate whether any existing patents are infringed by the use of the materials mentioned in this publication. Moreover, there is a need to reduce human exposure to many materials to the lowest practical limits in view of possible adverse effects. To the extent that any hazards may have been mentioned in this publication, we neither suggest nor guarantee that such hazards are the only ones that exist. We recommend that persons intending to rely on any recommendation or to use any equipment, processing technique or material mentioned in this publication should satisfy themselves that they can meet all applicable safety and health standards. We strongly recommend that users

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