

Crastin® S650FR NC010

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® S650FR is an unreinforced, flame retardant polybutylene terephthalate for injection moulding.

Product information

Resin Identification	PBT-FR(17)	ISO 1043
Part Marking Code	>PBT-FR(17)<	ISO 11469

Rheological properties

Melt mass-flow rate	12 g/10min	ISO 1133
Melt mass-flow rate, Temperature	250 °C	
Melt mass-flow rate, Load	2.16 kg	
Moulding shrinkage, parallel	1.8 %	ISO 294-4, 2577
Moulding shrinkage, normal	1.6 %	ISO 294-4, 2577
Moulding shrinkage, parallel, annealed	2.2 %	ISO 294-4
Moulding shrinkage, normal, annealed	2.15 %	ISO 294-4

Typical mechanical properties

Tensile Modulus	3000 MPa	ISO 527-1/-2
Yield stress, 50mm/min	65 MPa	ISO 527-1/-2
Yield strain, 50mm/min	4.6 %	ISO 527-1/-2
Nominal strain at break	7.2 %	ISO 527-1/-2
Flexural Strength	100 MPa	ISO 178
Tensile creep modulus, 1h	2500 MPa	ISO 899-1
Tensile creep modulus, 1000h	1800 MPa	ISO 899-1
Charpy impact strength, 23°C	70 kJ/m²	ISO 179/1eU
Charpy impact strength, -30°C	65 kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	4 kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	3.5 kJ/m²	ISO 179/1eA
Izod notched impact strength, 23°C	4 kJ/m²	ISO 180/1A
Izod notched impact strength, -30°C	4 kJ/m²	ISO 180/1A
Izod impact strength, 23°C	45 kJ/m²	ISO 180/1U
Izod impact strength, -30°C	42 kJ/m²	ISO 180/1U

Crastin® S650FR NC010

THERMOPLASTIC POLYESTER RESIN

Poisson's ratio 0.37

Thermal properties

Melting temperature, 10 °C/min	221 °C	ISO 11357-1/-3
Glass transition temperature, 10 °C/min	55 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	65 °C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	160 °C	ISO 75-1/-2
Vicat softening temperature, 50 °C/h, 50N	175 °C	ISO 306
Coeff. of linear therm. expansion, parallel	120 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	120 E-6/K	ISO 11359-1/-2
RTI, electrical, 0.75mm	130 °C	UL 746B
RTI, electrical, 1.5mm	130 °C	UL 746B
RTI, electrical, 3mm	130 °C	UL 746B
RTI, electrical, 6mm	130 °C	UL 746B
RTI, impact, 0.75mm	130 °C	UL 746B
RTI, impact, 1.5mm	130 °C	UL 746B
RTI, impact, 3mm	130 °C	UL 746B
RTI, impact, 6mm	130 °C	UL 746B
RTI, strength, 0.75mm	130 °C	UL 746B
RTI, strength, 1.5mm	130 °C	UL 746B
RTI, strength, 3mm	130 °C	UL 746B
RTI, strength, 6mm	130 °C	UL 746B

Flammability

Burning Behav. at 1.5mm nom. thickn.	V-0 class	UL 94
Thickness tested	1.5 mm	UL 94
UL recognition	yes	UL 94
Burning Behav. at thickness h	V-0 class	UL 94
Thickness tested	0.75 mm	UL 94
UL recognition	yes	UL 94
Oxygen index	30 %	ISO 4589-1/-2
Glow Wire Flammability Index, 3mm	960 °C	IEC 60695-2-12
Glow Wire Ignition Temperature, 3mm	625 °C	IEC 60695-2-13
FMVSS Class	DNI	ISO 3795 (FMVSS 302)

Electrical properties

Relative permittivity, 100Hz	3.4	IEC 62631-2-1
Relative permittivity, 1MHz	3.5	IEC 62631-2-1
Dissipation factor, 100Hz	7.1 E-4	IEC 62631-2-1
Dissipation factor, 1MHz	180 E-4	IEC 62631-2-1
Volume resistivity	>1E13 Ohm.m	IEC 62631-3-1
Surface resistivity	1E15 Ohm	IEC 62631-3-2
Electric strength	25 kV/mm	IEC 60243-1
Comparative tracking index	225	IEC 60112

Crastin® S650FR NC010

THERMOPLASTIC POLYESTER RESIN

Electric Strength, Short Time, 2mm

15 kV/mm

IEC 60243-1

Other properties

Humidity absorption, 2mm

0.15 %

Sim. to ISO 62

Water absorption, 2mm

0.39 %

Sim. to ISO 62

Density

1460 kg/m³

ISO 1183

Injection

Drying Recommended

yes

Drying Temperature

120 °C

Drying Time, Dehumidified Dryer

2 - 4 h

Processing Moisture Content

≤0.04 %

Melt Temperature Optimum

250 °C

Internal

Min. melt temperature

240 °C

Max. melt temperature

260 °C

Mold Temperature Optimum

80 °C

Min. mould temperature

30 °C

Max. mould temperature

130 °C

Hold pressure range

≥60 MPa

Hold pressure time

3 s/mm

Back pressure

As low as possible
MPa

Ejection temperature

170 °C

Internal

Extrusion

Drying Temperature

110 - 130 °C

Drying Time, Dehumidified Dryer

2 - 4 h

Processing Moisture Content

≤0.04 %

Melt Temperature Range

240 - 260 °C

Characteristics

Additives

Flame retardant

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

Crastin® S650FR NC010

THERMOPLASTIC POLYESTER RESIN

- ✗ 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
- ✓ 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
- ✗ Motor oil OS206 304 Ref.Eng.Oil, ISP, 135°C
- ✗ Automatic hypoid-gear oil Shell Donax TX, 135°C
- ✗ Hydraulic oil Pentosin CHF 202, 125°C

Standard Fuels

- ✗ ISO 1817 Liquid 1 - E5, 60°C
- ✗ ISO 1817 Liquid 2 - M15E4, 60°C
- ✗ ISO 1817 Liquid 3 - M3E7, 60°C
- ✗ 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
- ✓ Diesel EN 590, 100°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
-

Crastin® S650FR NC010

THERMOPLASTIC POLYESTER RESIN

Other

- ✓ Ethyl Acetate, 23°C
- ✗ Hydrogen peroxide, 23°C
- ✗ DOT No. 4 Brake fluid, 130°C
- ✗ DOT No. 4 Brake fluid, 120°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
- ✗ Water, 90°C
- ✓ Phenol solution (5% by mass), 23°C
- ✗ Coolant Glysantin G48, 1:1 in water, 125°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).
-