



**UL 746B** 

# Crastin® SK603 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® SK603 BK851 is a 20% glass fiber reinforced, lubricated polybutylene terephthalate resin for injection moulding.

#### Product information Resin Identification PBT-GF20 ISO 1043 >PBT-GF20< ISO 11469 Part Marking Code Rheological properties Moulding shrinkage, parallel 0.3 % ISO 294-4, 2577 Moulding shrinkage, normal 1.0 % ISO 294-4, 2577 Typical mechanical properties Tensile modulus 7000 MPa ISO 527-1/-2 110 MPa ISO 527-1/-2 Tensile stress at break, 5mm/min Tensile strain at break, 5mm/min 3 % ISO 527-1/-2 Flexural modulus 6500 MPa ISO 178 180 MPa ISO 178 Flexural strength Charpy impact strength, 23°C 55 kJ/m<sup>2</sup> ISO 179/1eU Charpy notched impact strength, 23°C 8 kJ/m<sup>2</sup> ISO 179/1eA Charpy notched impact strength, -30°C 7 kJ/m<sup>2</sup> ISO 179/1eA Izod notched impact strength, 23°C $7 \text{ kJ/m}^2$ ISO 180/1A Poisson's ratio 0.35 Thermal properties Melting temperature, 10°C/min 225 °C ISO 11357-1/-3 60 °C Glass transition temperature, 10°C/min ISO 11357-1/-3 Temperature of deflection under load, 1.8 MPa 205 °C ISO 75-1/-2 130 °C **UL 746B** RTI, electrical, 0.75mm RTI, electrical, 1.5mm 130 °C **UL 746B** RTI, electrical, 3.0mm 130 °C **UL 746B** RTI, electrical, 6mm 130 °C UI 746B RTI, impact, 0.75mm 130 °C **UL 746B** 130 °C **UL 746B** RTI, impact, 1.5mm RTI, impact, 3.0mm 130 °C **UL 746B**

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130 °C

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RTI, impact, 6mm





## THERMOPLASTIC POLYESTER RESIN

RTI, strength, 0.75mm	130 °C	UL 746B
RTI, strength, 1.5mm	130 °C	UL 746B
RTI, strength, 3.0mm	130 °C	UL 746B
RTI, strength, 6mm	130 °C	UL 746B

## Flammability

Burning Behav. at 1.5mm nom. thickn.	НВ	class	IEC 60695-11-10
Thickness tested	1.5	mm	IEC 60695-11-10
UL recognition	yes		UL 94
Burning Behav. at thickness h	HB	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	775	°C	IEC 60695-2-12
Glow Wire Ignition Temperature, 3.0mm	775	°C	IEC 60695-2-13
FMVSS Class	В		ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	28	mm/min	ISO 3795 (FMVSS 302)

## **Electrical properties**

Relative permittivity, 100Hz	3.8	IEC 62631-2-1
Relative permittivity, 1MHz	3.7	IEC 62631-2-1
Dissipation factor, 100Hz	7 E-4	IEC 62631-2-1
Dissipation factor, 1MHz	168 E-4	IEC 62631-2-1
Volume resistivity	>1E13 Ohm.m	IEC 62631-3-1
Surface resistivity	1E14 Ohm	IEC 62631-3-2
Electric strength	34 kV/mm	IEC 60243-1
Comparative tracking index	225	IEC 60112

## Physical/Other properties

Density 1450 kg/m<sup>3</sup> 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
Min. melt temperature	240	°C
Max. melt temperature	260	°C
Mold Temperature Optimum	80	°C
Min. mould temperature	60	°C
Max. mould temperature	130	°C
Hold pressure range	≥60	MPa
Hold pressure time	3	s/mm
Back pressure	As low as	MPa
	possible	
Ejection temperature	180	°C

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### THERMOPLASTIC POLYESTER RESIN

### Characteristics

Processing Injection Moulding

### **Automotive**

OEM STANDARD ADDITIONAL INFORMATION

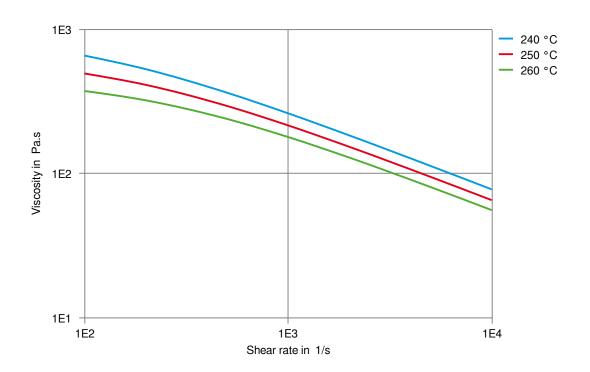
 BMW
 GS93016-PBT-GF20

 Bosch
 N28 BN07-GF012

 Hyundai
 MS216-03 Type F-1

Stellantis MS.50103 / PBT-GF20.6400F.7I PE 190.70

Viscosity-shear rate (measured on Crastin® SK603 NC010)



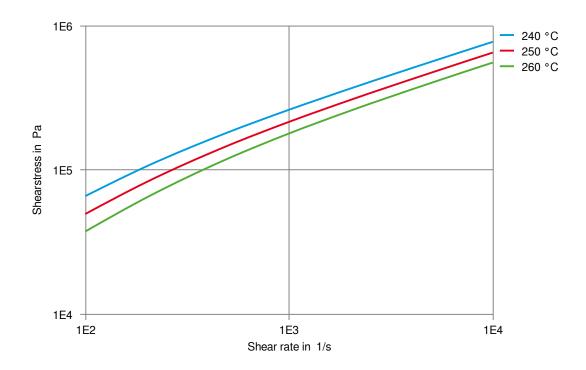
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## THERMOPLASTIC POLYESTER RESIN

Shearstress-shear rate (measured on Crastin® SK603 NC010)



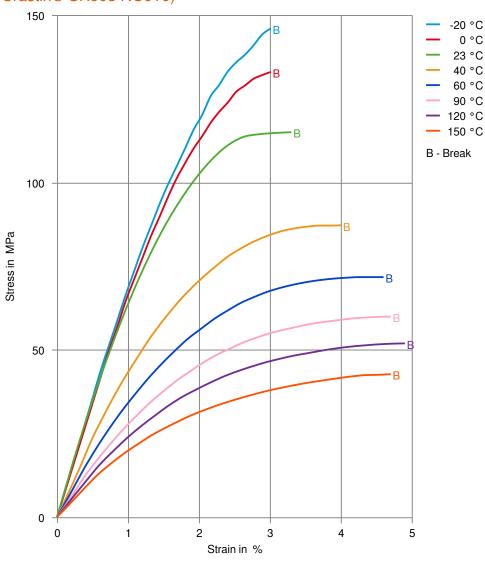
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## THERMOPLASTIC POLYESTER RESIN

Stress-strain (measured on Crastin® SK603 NC010)



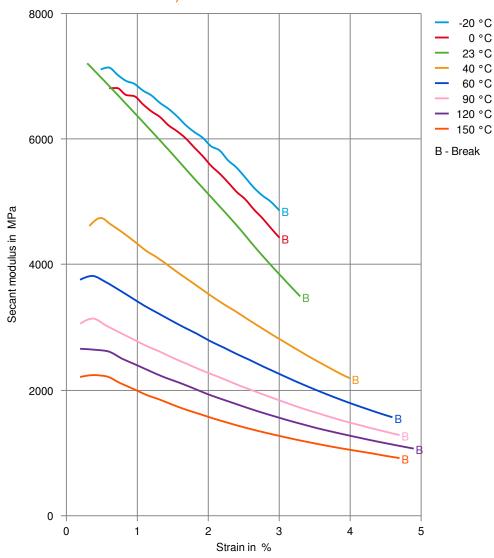
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## THERMOPLASTIC POLYESTER RESIN

Secant modulus-strain (measured on Crastin® SK603 NC010)



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# Crastin® SK603 BK851

### THERMOPLASTIC POLYESTER RESIN

### 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
- X 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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### THERMOPLASTIC POLYESTER RESIN

- ✓ 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 cause significant variations in data values. Properties of moulded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design 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, pr

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