

# Crastin® SK605LM BK591

## THERMOPLASTIC POLYESTER RESIN

Crastin® SK605LM BK591 is a 30% Glass Reinforced, Laser Markable, Polybutylene Terephthalate

### Product information

Resin Identification	PBT-GF30	ISO 1043
Part Marking Code	>PBT-GF30<	ISO 11469

### Rheological properties

Melt volume-flow rate	5 cm <sup>3</sup> /10min	ISO 1133
Temperature	250 °C	
Load	2.16 kg	
Moulding shrinkage, parallel	0.3 %	ISO 294-4, 2577
Moulding shrinkage, normal	1.1 %	ISO 294-4, 2577

### Typical mechanical properties

Tensile modulus	9500 MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	130 MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.5 %	ISO 527-1/-2
Flexural strength	200 MPa	ISO 178
Charpy impact strength, 23°C	70 kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, 23°C	10 kJ/m <sup>2</sup>	ISO 179/1eA
Poisson's ratio	0.34	

### Thermal properties

Melting temperature, 10°C/min	225 °C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	55 °C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	205 °C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	220 <sup>[DS]</sup> °C	ISO 75-1/-2

[DS]: Derived from similar grade

### Flammability

Burning Behav. at 1.5mm nom. thickn.	HB class	IEC 60695-11-10
Thickness tested	1.5 mm	IEC 60695-11-10
Burning Behav. at thickness h	HB class	IEC 60695-11-10
Thickness tested	0.75 mm	IEC 60695-11-10
Oxygen index	20 %	ISO 4589-1/-2
Glow Wire Flammability Index, 0.75mm	725 °C	IEC 60695-2-12
Glow Wire Flammability Index, 1.5mm	725 °C	IEC 60695-2-12
Glow Wire Flammability Index, 3.0mm	825 °C	IEC 60695-2-12
Glow Wire Ignition Temperature, 0.75mm	750 °C	IEC 60695-2-13
Glow Wire Ignition Temperature, 1.5mm	750 °C	IEC 60695-2-13
Glow Wire Ignition Temperature, 3.0mm	800 °C	IEC 60695-2-13
FMVSS Class	B	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	54 mm/min	ISO 3795 (FMVSS 302)

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### Physical/Other properties

Density	1520 kg/m <sup>3</sup>	ISO 1183
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### VDA Properties

Odour	3 class	VDA 270
Fogging, F-value (refraction)	99 %	ISO 6452

### 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 possible MPa
Ejection temperature	170 °C

### Characteristics

Processing	Injection Moulding
Delivery form	Pellets
Additives	Release agent

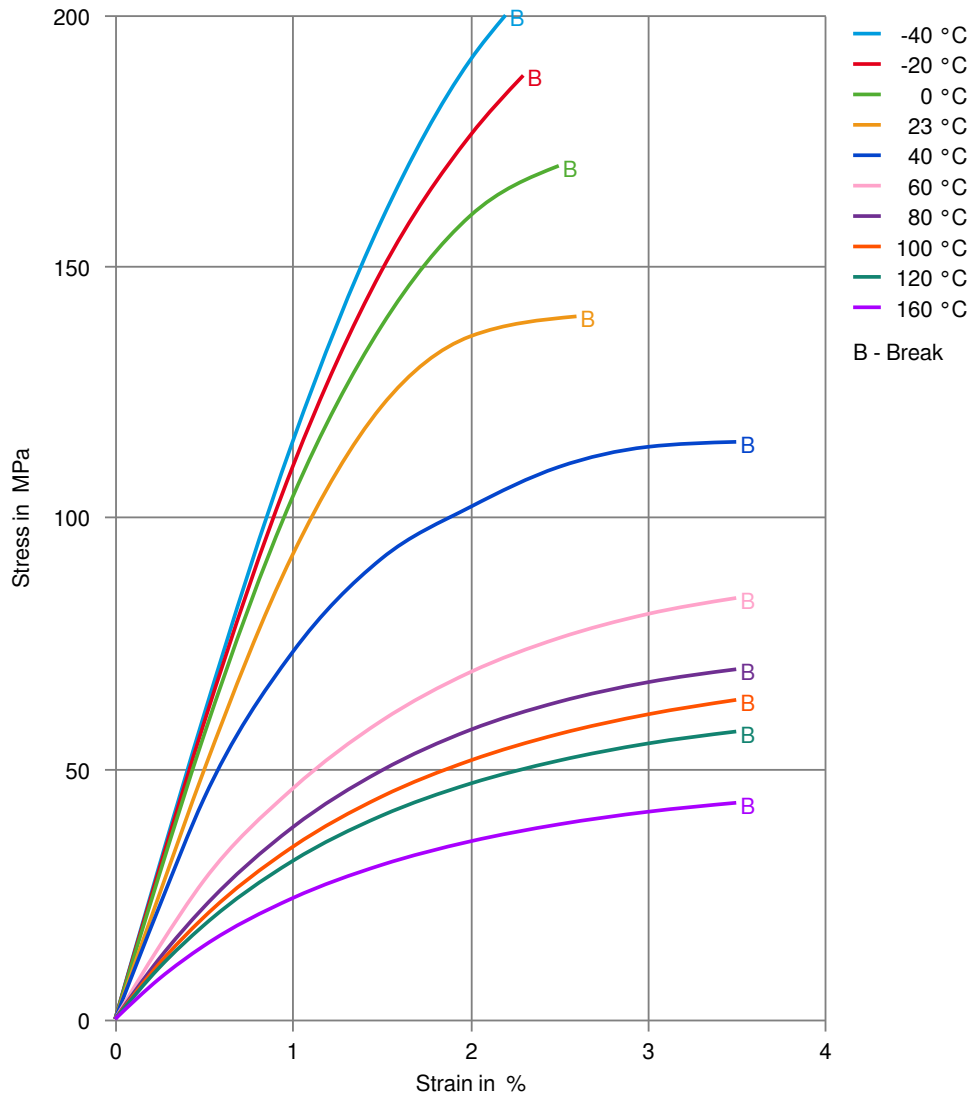
### Automotive

OEM	STANDARD
Bosch	N28 BN07-GF051

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## THERMOPLASTIC POLYESTER RESIN

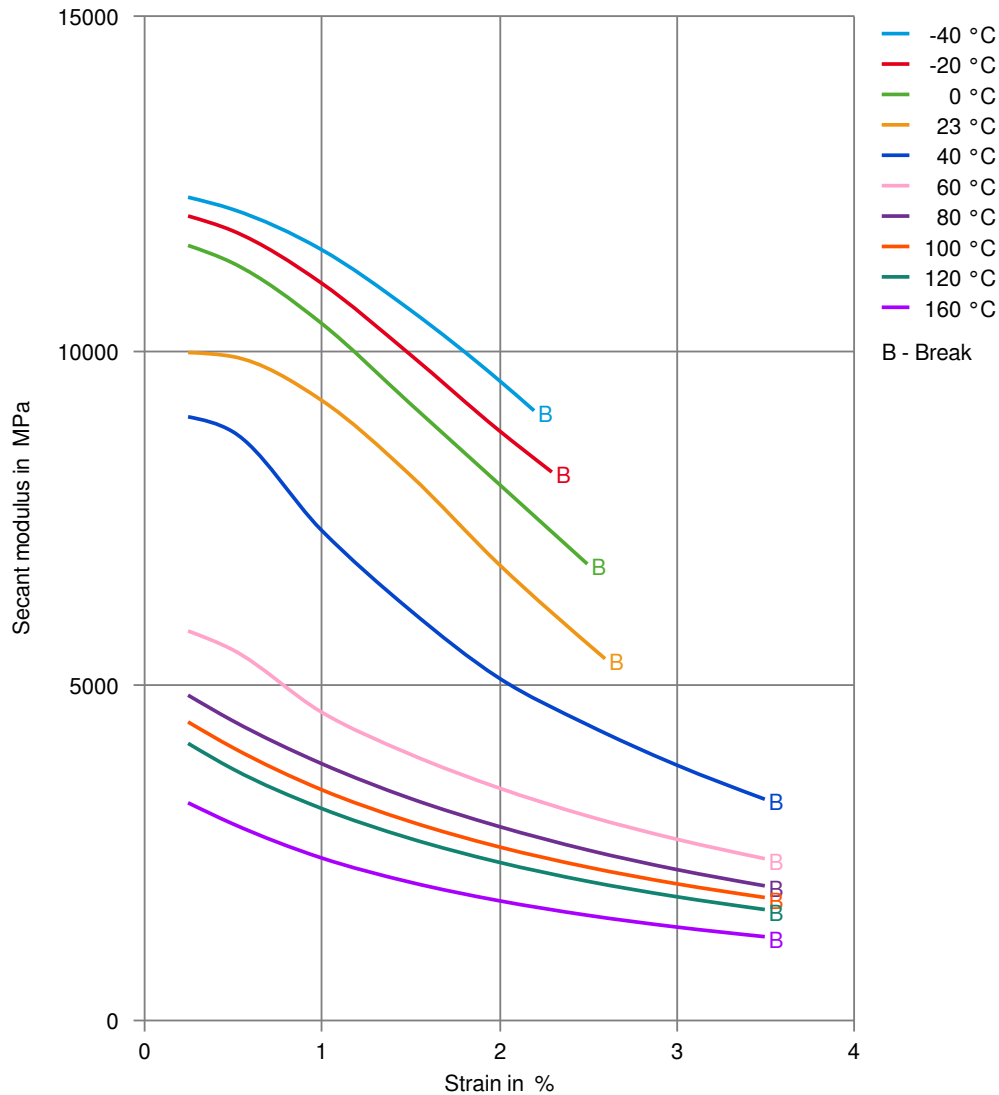
Stress-strain  
(measured on Crastin® SK605 NC010)



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## THERMOPLASTIC POLYESTER RESIN

Secant modulus-strain  
(measured on Crastin® SK605 NC010)



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### Chemical Media Resistance

#### Other

- ✓ Water, 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).
- ✗ 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).