



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® SK608 BK509 is a 45% glass fiber reinforced, lubricated, black polybutylene terephthalate resin for injection moulding.

Product information

Resin Identification	PBT-GF45	ISO 1043
Part Marking Code	>PBT-GF45<	ISO 11469

Rheological properties

Melt volume-flow rate	4 cm ³ /10min	ISO 1133
Temperature	250 °C	
Load	5 kg	
Melt mass-flow rate	6 g/10min	ISO 1133
Melt mass-flow rate, Temperature	250 °C	
Melt mass-flow rate, Load	5 kg	
Moulding shrinkage, parallel	0.3 %	ISO 294-4, 2577
Moulding shrinkage, normal	1.1 %	ISO 294-4, 2577
Postmoulding shrinkage, normal, 48h at 80°C	0.2 %	ISO 294-4
Postmoulding shrinkage, parallel, 48h at 80°C	0.1 %	ISO 294-4

Typical mechanical properties

Tensile modulus	14200	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	140	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	2	%	ISO 527-1/-2
Flexural modulus	13300	MPa	ISO 178
Flexural strength	210	MPa	ISO 178
Charpy impact strength, 23°C	55	kJ/m²	ISO 179/1eU
Charpy impact strength, -30°C	65	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	10	kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23°C	10	kJ/m ²	ISO 180/1A
Izod notched impact strength, -30°C	10.0	kJ/m ²	ISO 180/1A
Izod impact strength, -30°C	50	kJ/m ²	ISO 180/1U
Poisson's ratio	0.33		

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Trik	oolo	ogic	al pı	roper	ties
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modegical properties			
Coefficient of sliding friction, 1h against steel	0.2		ASTM 1894
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	207		ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	222		ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	215	°C	ISO 306
Ball pressure test	210	°C	IEC 60695-10-2
Coefficient of linear thermal expansion	20	E-6/K	ISO 11359-1/-2
(CLTE), parallel			
Coefficient of linear thermal expansion (CLTE),	80	E-6/K	ISO 11359-1/-2
normal			
RTI, electrical, 0.75mm	130		UL 746B
RTI, electrical, 1.5mm	130		UL 746B
RTI, electrical, 3.0mm	130		UL 746B
RTI, impact, 0.75mm	125		UL 746B
RTI, impact, 1.5mm	125		UL 746B
RTI, impact, 3.0mm	125		UL 746B
RTI, strength, 0.75mm	130		UL 746B
RTI, strength, 1.5mm	130		UL 746B
RTI, strength, 3.0mm	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
Oxygen index	20		ISO 4589-1/-2
Glow Wire Flammability Index, 3.0mm	750	°C	IEC 60695-2-12
FMVSS Class	В		ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	<80	mm/min	ISO 3795 (FMVSS 302)
Electrical properties			
Relative permittivity, 100Hz	4.1		IEC 62631-2-1
Relative permittivity, 1MHz	3.9		IEC 62631-2-1
Dissipation factor, 100Hz		E-4	IEC 62631-2-1
Dissipation factor, 1MHz	130	E-4	IEC 62631-2-1
Volume resistivity	>1E13	Ohm.m	IEC 62631-3-1
Electric strength	32	kV/mm	IEC 60243-1
Comparative tracking index	475		IEC 60112
Electric Strength, Short Time, 2mm	15	kV/mm	IEC 60243-1

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Physical/Other properties

Humidity absorption, 2mm	0.1 %	Sim. to ISO 62
Water absorption, 2mm	0.3 %	Sim. to ISO 62
Density	1660 kg/m³	ISO 1183
Density of melt	1470 kg/m³	

VDA Properties

Emission of organic compounds	70 μgC/g	VDA 277
Odour	3 class	VDA 270

Injection

Drying Recommended	yes	
Drying Temperature	120	$^{\circ}\mathrm{C}$
Drying Time, Dehumidified Dryer	2 - 4	h
Processing Moisture Content	≤0.04	%
Melt Temperature Optimum	260	°C
Min. melt temperature	250	°C
Max. melt temperature	270	°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	170	°C

Characteristics

Processing Injection Moulding, Extrusion, Other Extrusion

Delivery form Pellets

Additives Release agent

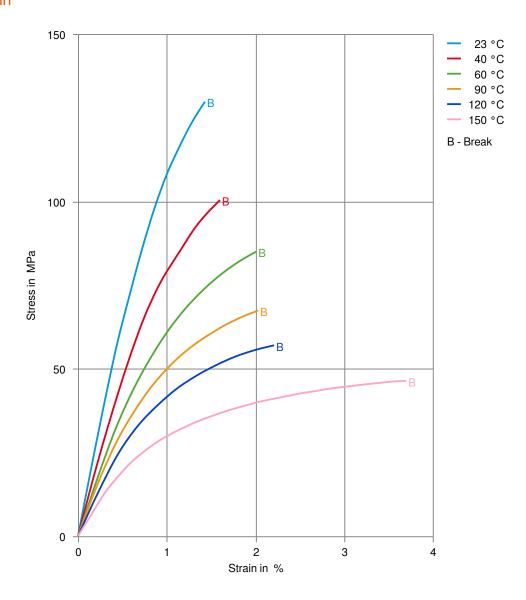
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Stress-strain



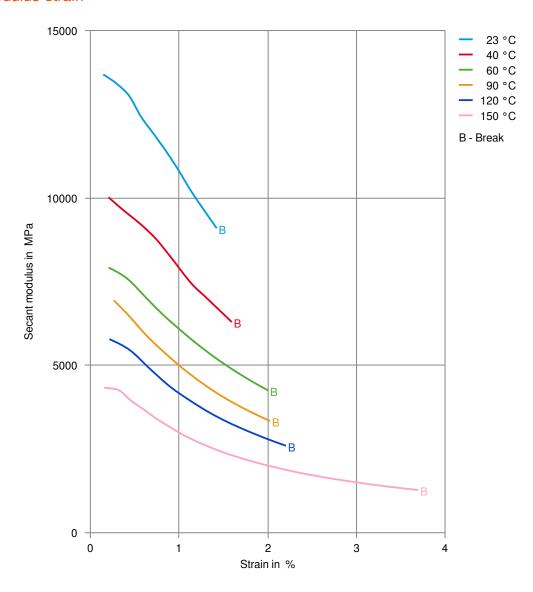
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Secant modulus-strain



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Crastin® SK608 BK509

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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
- 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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- ✓ 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, 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 e

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