

# Crastin® SK605LM BK591

THERMOPLASTIC POLYESTER RESIN

DuPont Performance Polymers

## Message:

30% Glass Reinforced, Laser Markable, Polybutylene Terephthalate

| General Information                               |                                                       |                        |                      |
|---------------------------------------------------|-------------------------------------------------------|------------------------|----------------------|
| Filler / Reinforcement                            | Glass fiber reinforced material, 30% filler by weight |                        |                      |
| Additive                                          | demoulding                                            |                        |                      |
| Features                                          | Laser marking                                         |                        |                      |
| RoHS Compliance                                   | Contact manufacturer                                  |                        |                      |
| Forms                                             | Particle                                              |                        |                      |
| Processing Method                                 | Injection molding                                     |                        |                      |
| Part Marking Code (ISO 11469)                     | >PBT-GF30                                             |                        |                      |
| Resin ID (ISO 1043)                               | PBT-GF30                                              |                        |                      |
| Physical                                          | Nominal Value                                         | Unit                   | Test Method          |
| Density                                           | 1.52                                                  | g/cm <sup>3</sup>      | ISO 1183             |
| Melt Volume-Flow Rate (MVR) (250°C/2.16 kg)       | 5.00                                                  | cm <sup>3</sup> /10min | ISO 1133             |
| Molding Shrinkage                                 |                                                       |                        | ISO 294-4            |
| Transverse flow                                   | 1.1                                                   | %                      | ISO 294-4            |
| Flow                                              | 0.30                                                  | %                      | ISO 294-4            |
| Mechanical                                        | Nominal Value                                         | Unit                   | Test Method          |
| Tensile Modulus                                   | 9500                                                  | MPa                    | ISO 527-2            |
| Tensile Stress (Break)                            | 130                                                   | MPa                    | ISO 527-2            |
| Tensile Strain (Break)                            | 2.5                                                   | %                      | ISO 527-2            |
| Flexural Stress                                   | 200                                                   | MPa                    | ISO 178              |
| Impact                                            | Nominal Value                                         | Unit                   | Test Method          |
| Charpy Notched Impact Strength (23°C)             | 10                                                    | kJ/m <sup>2</sup>      | ISO 179/1eA          |
| Charpy Unnotched Impact Strength (23°C)           | 70                                                    | kJ/m <sup>2</sup>      | ISO 179/1eU          |
| Thermal                                           | Nominal Value                                         | Unit                   | Test Method          |
| Heat Deflection Temperature (1.8 MPa, Unannealed) | 205                                                   | °C                     | ISO 75-2/A           |
| Melting Temperature <sup>1</sup>                  | 225                                                   | °C                     | ISO 11357-3          |
| Flammability                                      | Nominal Value                                         | Unit                   | Test Method          |
| Burning Rate <sup>2</sup> (1.00 mm)               | 54                                                    | mm/min                 | ISO 3795             |
| Flammability Classification                       |                                                       |                        | IEC 60695-11-10, -20 |
| 0.75 mm                                           | HB                                                    |                        | IEC 60695-11-10, -20 |
| 1.5 mm                                            | HB                                                    |                        | IEC 60695-11-10, -20 |
| Oxygen Index                                      | 20                                                    | %                      | ISO 4589-2           |
| FMVSS Flammability                                | B                                                     |                        | FMVSS 302            |

|                                  |                    |       |             |
|----------------------------------|--------------------|-------|-------------|
| Atomization-F-value (refraction) | 99                 | %     | ISO 6452    |
| Emission of Organic Compounds    | 91.4               | µgC/g | VDA 277     |
| Odor                             | 3.00               |       | VDA 270     |
| Melt Temperature, Optimum        | 250                | °C    |             |
| Mold Temperature, Optimum        | 80                 | °C    |             |
| Back Pressure                    | As low as possible |       |             |
| Drying Recommended               | yes                |       |             |
| Hold Pressure Time               | 3.00               | s/mm  |             |
| Fill Analysis                    | Nominal Value      | Unit  | Test Method |
| Ejection Temperature             | 170                | °C    |             |
| Injection                        | Nominal Value      | Unit  |             |
| Drying Temperature               | 120                | °C    |             |
| Drying Time - Desiccant Dryer    | 2.0 - 4.0          | hr    |             |
| Suggested Max Moisture           | 0.040              | %     |             |
| Processing (Melt) Temp           | 240 - 260          | °C    |             |
| Mold Temperature                 | 30 - 130           | °C    |             |
| Holding Pressure                 | 60.0               | MPa   |             |
| NOTE                             |                    |       |             |
| 1.                               | 10°C/min           |       |             |
| 2.                               | FMVSS 302          |       |             |

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

#### Recommended distributors for this material

### Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

