

Crastin® CE2054 BK580

THERMOPLASTIC POLYESTER RESIN

DuPont Performance Polymers

Message:

Unreinforced Polybutylene Terephthalate

General Information			
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Part Marking Code (ISO 11469)	>PBT		
Resin ID (ISO 1043)	PBT		
Physical	Nominal Value	Unit	Test Method
Density	1.31	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Transverse flow	1.9	%	ISO 294-4
Flow	1.9	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2750	MPa	ISO 527-2
Tensile Stress (Yield)	58.0	MPa	ISO 527-2
Tensile Strain (Yield)	11	%	ISO 527-2
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	3.4	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	150	°C	ISO 75-2/B
0.45 MPa, annealed	183	°C	ISO 75-2/B
1.8 MPa, not annealed	55.0	°C	ISO 75-2/A
1.8 MPa, annealed	65.0	°C	ISO 75-2/A
Melting Temperature ¹	225	°C	ISO 11357-3
Flammability	Nominal Value	Unit	Test Method
Burning Rate ² (1.00 mm)	< 100	mm/min	ISO 3795
FMVSS Flammability	B		FMVSS 302
Melt Temperature, Optimum	250	°C	
Mold Temperature, Optimum	80	°C	
Back Pressure	As low as possible		
Drying Recommended	yes		
Hold Pressure Time	4.00	s/mm	
Fill Analysis	Nominal Value	Unit	
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

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