

Crastin® LW9320LM BK591

THERMOPLASTIC POLYESTER RESIN

DuPont Performance Polymers

Message:

20% Glass Reinforced Laser Markable Polybutylene Terephthalate Blend with Low Warpage Characteristics

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Additive	demoulding		
Features	Low warpage		
	Laser marking		
RoHS Compliance	Contact manufacturer		
Forms	Particle		
Processing Method	Injection molding		
Part Marking Code (ISO 11469)	>PBT+SAN-GF20		
Resin ID (ISO 1043)	PBT+SAN-GF20		
Physical	Nominal Value	Unit	Test Method
Density	1.35	g/cm ³	ISO 1183
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	7500	MPa	ISO 527-2
Tensile Stress (Break)	120	MPa	ISO 527-2
Tensile Strain (Break)	2.3	%	ISO 527-2
Flexural Modulus	7000	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	7.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	40	kJ/m ²	ISO 179/1eU
23°C	45	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	165	°C	ISO 75-2/A
Melting Temperature ¹	220	°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	3.00	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, Derived from Similar Grade

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