

Crastin® T843FR BK851

THERMOPLASTIC POLYESTER RESIN

DuPont Performance Polymers

Message:

20% Glass Reinforced, Flame Retardant, Toughened, Polybutylene Terephthalate

General Information			
UL YellowCard	E41938-257844		
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Additive	Lubricant		
	Flame retardancy		
Features	Flame retardancy		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Part Marking Code (ISO 11469)	>PBTC-GF20FR(17)		
Resin ID (ISO 1043)	PBTC-GF20FR(17)		
Physical	Nominal Value	Unit	Test Method
Density	1.59	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Transverse flow	1.1	%	ISO 294-4
Flow	0.50	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	5800	MPa	ISO 527-2
Tensile Stress (Break)	87.0	MPa	ISO 527-2
Tensile Strain (Break)	4.0	%	ISO 527-2
Flexural Stress	142	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	9.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	55	kJ/m ²	ISO 179/1eU
Notched Izod Impact (23°C)	8.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	180	°C	ISO 75-2/A
Melting Temperature ¹	205	°C	ISO 11357-3
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	ohms · cm	IEC 60093
Relative Permittivity			IEC 60250
100 Hz	5.20		IEC 60250

1 MHz	4.70		IEC 60250
Dissipation Factor			IEC 60250
100 Hz	0.020		IEC 60250
1 MHz	0.028		IEC 60250
Comparative Tracking Index	225	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94, IEC 60695-11-10, -20
1.5 mm	V-0		UL 94, IEC 60695-11-10, -20
3.0 mm	V-0		UL 94, IEC 60695-11-10, -20
Oxygen Index	31	%	ISO 4589-2
FMVSS Flammability	DNI		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	150	°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		

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