

Crastin® BM6450XD BK560

THERMOPLASTIC POLYESTER RESIN

DuPont Performance Polymers

Message:

Unreinforced Polybutylene Terephthalate Developed for Blow Molding

General Information			
Additive	Mold Release		
Uses	Blow Molding Applications		
	Film		
	Profiles		
	Sheet		
Forms	Pellets		
Processing Method	Blow Molding		
	Casting		
	Coating		
	Extrusion		
	Film Extrusion		
	Profile Extrusion		
Multi-Point Data	Isothermal Stress vs. Strain (ISO 11403-1)		
	Secant Modulus vs. Strain (ISO 11403-1)		
	Shear Stress vs. Shear Rate (ISO 11403-1)		
	Specific Volume vs Temperature (ISO 11403-2)		
	Tensile Modulus vs. Temperature (ISO 11403-1)		
	Viscosity vs. Shear Rate (ISO 11403-2)		
Part Marking Code (ISO 11469)	>PBT-F<		
Resin ID (ISO 1043)	PBT-F		
Physical	Nominal Value	Unit	Test Method
Density	1.21	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow	1.7	%	
Flow	1.5	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1600	MPa	ISO 527-2
Tensile Stress (Yield)	34.0	MPa	ISO 527-2
Tensile Strain (Yield)	9.0	%	ISO 527-2

Nominal Tensile Strain at Break	> 50	%	ISO 527-2
Flexural Modulus	1600	MPa	ISO 178
Flexural Stress	50.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	10	kJ/m ²	
23°C	120	kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	No Break		
23°C	No Break		
Notched Izod Impact Strength (23°C)	90	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	80.0	°C	ISO 75-2/B
0.45 MPa, Annealed	130	°C	ISO 75-2/B
1.8 MPa, Unannealed	50.0	°C	ISO 75-2/A
Melting Temperature ¹	220	°C	ISO 11357-3
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	ohms·cm	IEC 60093
Electric Strength	31	kV/mm	IEC 60243-1
Dissipation Factor			IEC 60250
100 Hz	7.0E-3		
1 MHz	0.020		
Flammability	Nominal Value	Unit	Test Method
Burning Rate (1.00 mm)	40	mm/min	ISO 3795
Fill Analysis	Nominal Value	Unit	
Melt Density	1.03	g/cm ³	
Specific Heat Capacity of Melt	2210	J/kg/°C	
Thermal Conductivity of Melt	0.15	W/m/K	
NOTE			
1.	10°C/min		

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