

Crastin® FR1300TC BK350

THERMOPLASTIC POLYESTER RESIN

DuPont Performance Polymers

Message:

Thermally Conductive, Flame Retardant, Polybutylene Terephthalate

General Information			
UL YellowCard	E41938-101879504		
Additive	Flame retardancy		
Features	Heat conduction		
	Flame retardancy		
RoHS Compliance	Contact manufacturer		
Forms	Particle		
Processing Method	Injection molding		
Part Marking Code (ISO 11469)	>PBT-I-CD35FR(17)		
Resin ID (ISO 1043)	PBT-I-CD35FR(17)		
Physical	Nominal Value	Unit	Test Method
Density	1.58	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Transverse flow	0.60	%	ISO 294-4
Flow	0.40	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	4800	MPa	ISO 527-2
Tensile Stress (Break)	34.0	MPa	ISO 527-2
Tensile Strain (Break)	1.0	%	ISO 527-2
Flexural Modulus	6600	MPa	ISO 178
Flexural Stress	51.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	2.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	6.8	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	195	°C	ISO 75-2/B
1.8 MPa, not annealed	119	°C	ISO 75-2/A
Linear thermal expansion coefficient			ISO 11359-2
Flow	4.6E-5	cm/cm/°C	ISO 11359-2
Lateral	5.3E-5	cm/cm/°C	ISO 11359-2
Thermal Conductivity			ASTM E1461
-- ¹	2.0	W/m/K	ASTM E1461

-- ²	14	W/m/K	ASTM E1461
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity ³	1.0E+5	ohms·cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94, IEC 60695-11-10, -20
0.75 mm	V-0		UL 94, IEC 60695-11-10, -20
1.5 mm	V-0		UL 94, IEC 60695-11-10, -20
FMVSS Flammability	DNI		FMVSS 302
Melt Temperature, Optimum	275	°C	
Mold Temperature, Optimum	110	°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	%	
Suggested Max Regrind	15	%	
Processing (Melt) Temp	260 - 290	°C	
Mold Temperature	100 - 120	°C	
Holding Pressure	60.0	MPa	
NOTE			
1.	through plane		
2.	in plane		
3.	Assessed (Min)		

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