

Crastin® FGS621F50 NC010

THERMOPLASTIC POLYESTER RESIN

Crastin® FGS621F50 NC010 is an unreinforced, nucleated, low viscosity polybutylene terephthalate resin for injection molding. It has been developed for fast cycles and high productivity

into applications such as parts for the food and cosmetics industry.

Product information

Resin Identification	PBT	ISO 1043
Part Marking Code	>PBT<	ISO 11469

Rheological properties

Melt mass-flow rate	50 g/10min	ISO 1133
Melt mass-flow rate, Temperature	250 °C	
Melt mass-flow rate, Load	2.16 kg	
Moulding shrinkage, parallel	1.8 %	ISO 294-4, 2577
Moulding shrinkage, normal	1.8 %	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	2700 MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	60 MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	4 %	ISO 527-1/-2
Tensile strain at break, 50mm/min	15 %	ISO 527-1/-2
Charpy impact strength, 23°C	150 kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	4 kJ/m ²	ISO 179/1eA
Poisson's ratio	0.38	

Thermal properties

Melting temperature, 10°C/min	225 °C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	55 °C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	60 °C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	160 °C	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), normal	110 E-6/K	ISO 11359-1/-2
Thermal conductivity, flow	0.27 W/(m K)	ISO 22007-2
Specific heat capacity of melt	2290 J/(kg K)	ISO 22007-4
Specific heat capacity solid	1320 J/(kg K)	ISO 22007-4

Flammability

Burning Behav. at 1.5mm nom. thickn.	HB ^[A] class	IEC 60695-11-10
FMVSS Class	B	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	<80 mm/min	ISO 3795 (FMVSS 302)

[A]: Assessed

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Physical/Other properties

Density	1320 kg/m ³	ISO 1183
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Injection

Drying Recommended	yes
Drying Temperature	140 °C
Drying Time, Dehumidified Dryer	4 - 6 h
Processing Moisture Content	≤0.01 %
Melt Temperature Optimum	240 °C
Min. melt temperature	240 °C
Max. melt temperature	250 °C
Mold Temperature Optimum	80 °C
Min. mould temperature	60 °C
Max. mould temperature	120 °C
Hold pressure range	≥60 MPa
Hold pressure time	4 s/mm
Back pressure	As low as possible MPa
Ejection temperature	170 °C

Characteristics

Processing	Injection Moulding
Delivery form	Pellets

Additional information

Injection molding

To minimize the volatile content in the final product, dry the resin to ≤0.01% water content. In injection molding, use the lowest possible melt temperature (recommended 240 °C) and shortest feasible residence time (recommended 2-3 minutes). Store the parts in a ventilated, clean area before use. If assistance is needed please contact your Celanese account representative.

These recommendations are based on internal Celanese testing. For drying and injection molding conditions outside the above parameters, customer must test for and verify suitably low volatiles emissions on molded articles to confirm the final product is suitably pure for its intended use.

Processing Notes

Pre-Drying

To avoid hydrolytic degradation during processing, CRAFTIN resins have to be dried to a moisture level equal to or less than 0.01%. Drying should be done in a dehumidifying hopper dryer capable of dewpoints <-40 °C (-40 °F) at 140 °C (284 °F) for 4-6 hours.

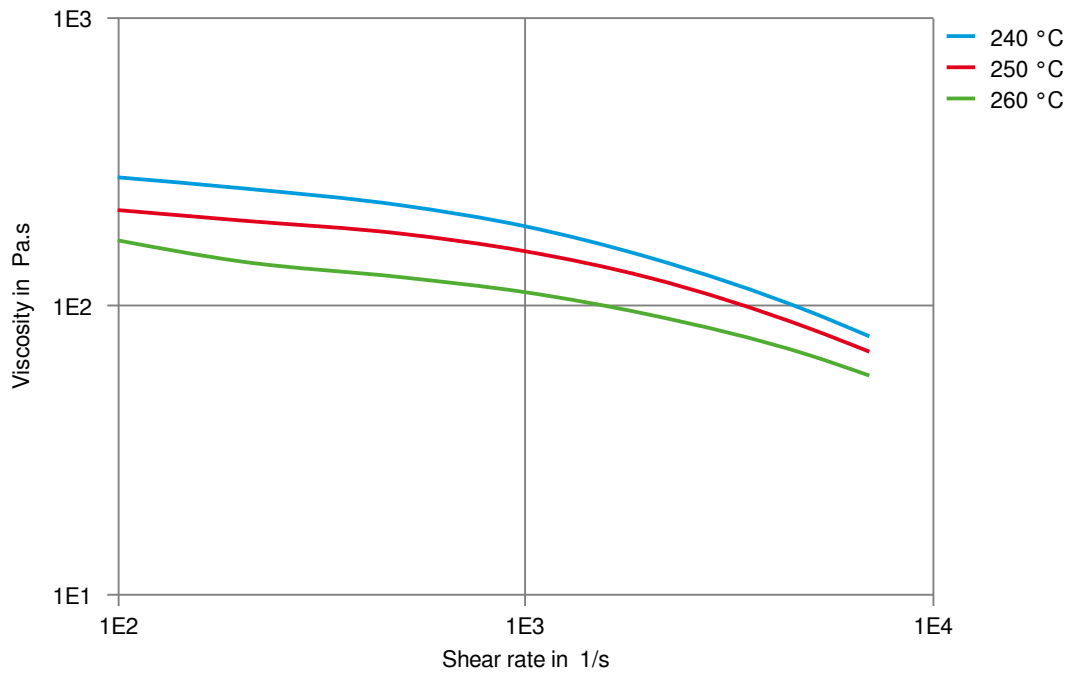
Storage

For subsequent storage of the material in the dryer until processed (≤ 60 h) it is necessary to lower the temperature to 100° C.

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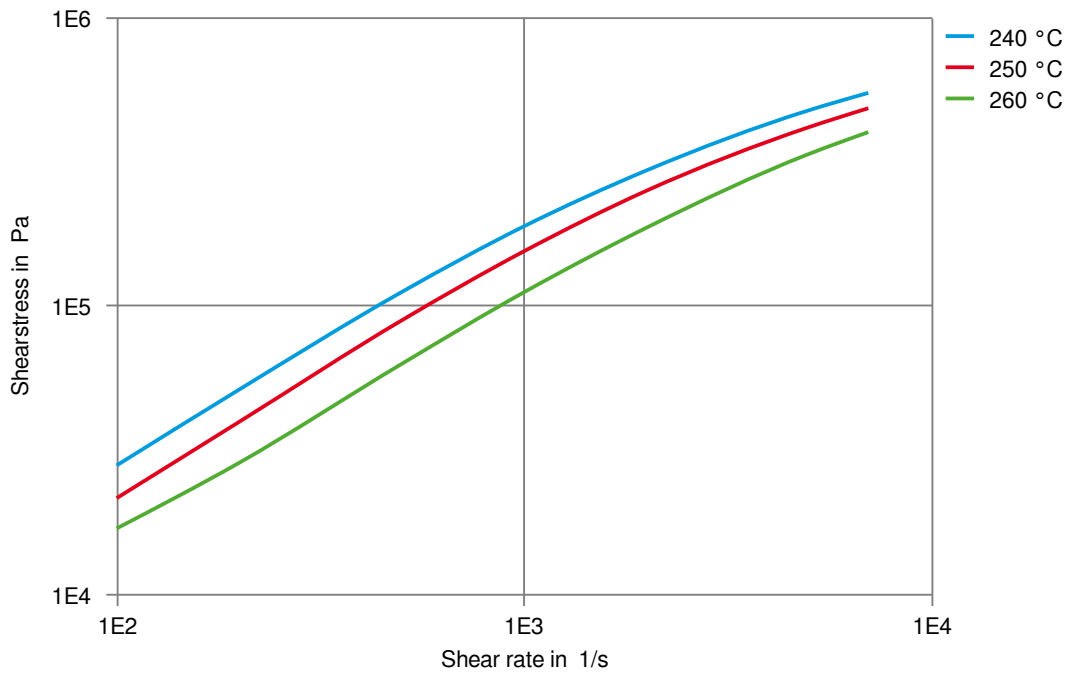
Viscosity-shear rate



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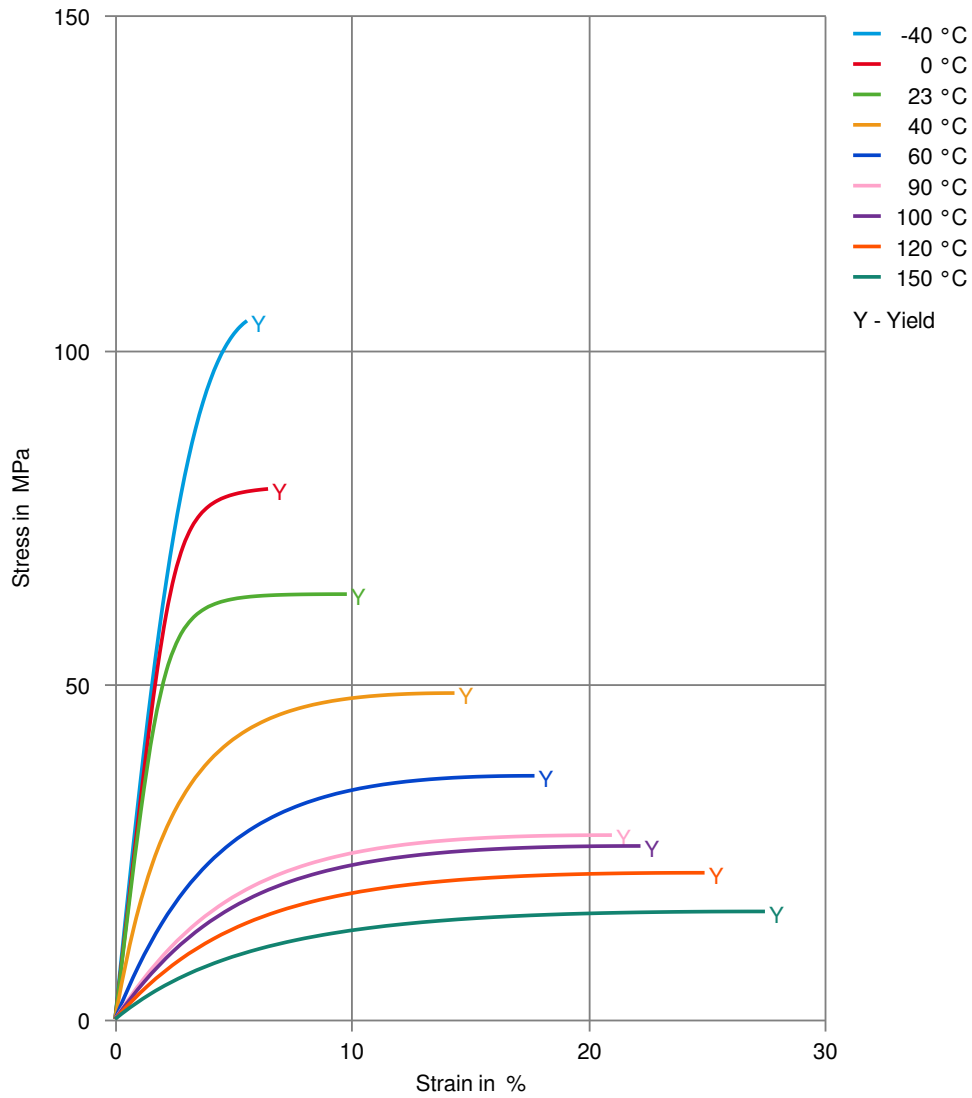
Shearstress-shear rate



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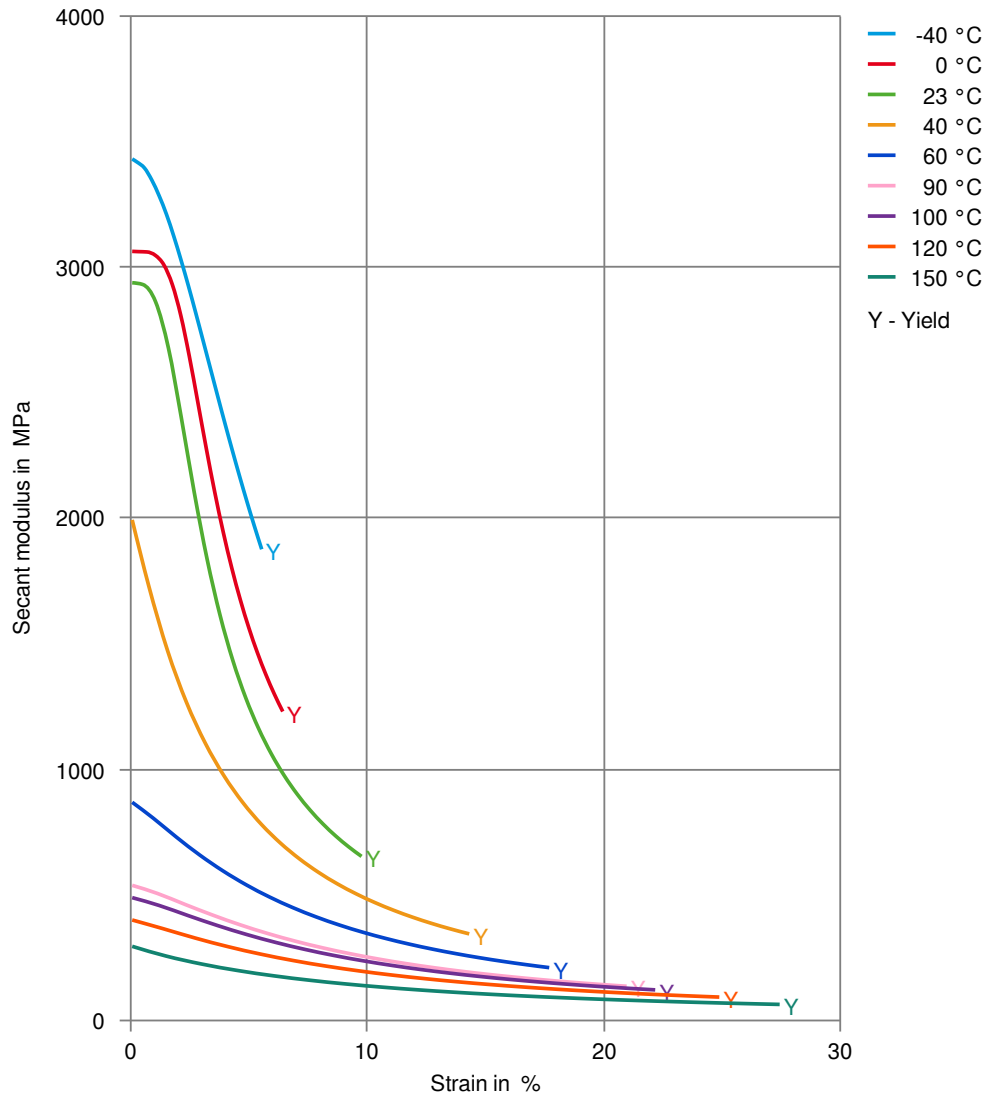
Stress-strain



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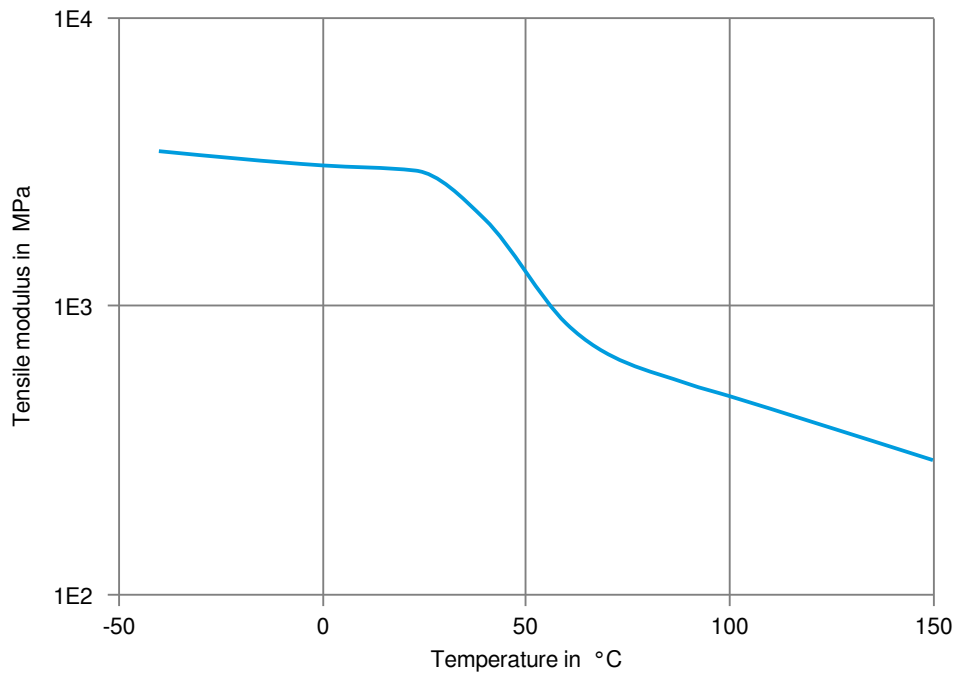
Secant modulus-strain



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Tensile modulus-temperature



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Chemical Media Resistance

Acids

- ✓ Acetic Acid (5% by mass), 23°C
- ✓ Citric Acid solution (10% by mass), 23°C
- ✓ Lactic Acid (10% by mass), 23°C
- ✗ Hydrochloric Acid (36% by mass), 23°C
- ✗ Nitric Acid (40% by mass), 23°C
- ✗ Sulfuric Acid (38% by mass), 23°C
- ✗ Sulfuric Acid (5% by mass), 23°C

Bases

- ✗ Sodium Hydroxide solution (35% by mass), 23°C
- ✓ Sodium Hydroxide solution (1% by mass), 23°C
- ✓ Ammonium Hydroxide solution (10% by mass), 23°C

Alcohols

- ✓ Isopropyl alcohol, 23°C
- ✓ Methanol, 23°C
- ✓ Ethanol, 23°C

Hydrocarbons

- ✓ n-Hexane, 23°C
- ✓ Toluene, 23°C
- ✓ iso-Octane, 23°C

Ketones

- ✓ Acetone, 23°C

Ethers

- ✓ Diethyl ether, 23°C

Mineral oils

- ✓ SAE 10W40 multigrade motor oil, 23°C
- ✗ SAE 10W40 multigrade motor oil, 130°C
- ✗ SAE 80/90 hypoid-gear oil, 130°C
- ✓ Insulating Oil, 23°C

Standard Fuels

- ✗ ISO 1817 Liquid 1 - E5, 60°C
- ✗ ISO 1817 Liquid 2 - M15E4, 60°C
- ✗ ISO 1817 Liquid 3 - M3E7, 60°C
- ✗ ISO 1817 Liquid 4 - M15, 60°C
- ✓ Standard fuel without alcohol (pref. ISO 1817 Liquid C), 23°C
- ✓ Standard fuel with alcohol (pref. ISO 1817 Liquid 4), 23°C
- ✓ Diesel fuel (pref. ISO 1817 Liquid F), 23°C
- ✓ Diesel fuel (pref. ISO 1817 Liquid F), 90°C
- ✗ Diesel fuel (pref. ISO 1817 Liquid F), >90°C

Salt solutions

- ✓ Sodium Chloride solution (10% by mass), 23°C
- ✓ Sodium Hypochlorite solution (10% by mass), 23°C
- ✓ Sodium Carbonate solution (20% by mass), 23°C

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- ✓ Sodium Carbonate solution (2% by mass), 23°C
- ✓ Zinc Chloride solution (50% by mass), 23°C

Other

- ✓ Ethyl Acetate, 23°C
- ✗ Hydrogen peroxide, 23°C
- ✗ DOT No. 4 Brake fluid, 130°C
- ✗ Ethylene Glycol (50% by mass) in water, 108°C
- ✓ 1% nonylphenoxy-polyethyleneoxy ethanol in water, 23°C
- ✓ 50% Oleic acid + 50% Olive Oil, 23°C
- ✓ Water, 23°C
- ✗ Water, 90°C
- ✓ Phenol solution (5% by mass), 23°C

Symbols used:

- ✓ possibly resistant
Defined as: Supplier has sufficient indication that contact with chemical can be potentially accepted under the intended use conditions and expected service life. Criteria for assessment have to be indicated (e.g. surface aspect, volume change, property change).
- ✗ not recommended - see explanation
Defined as: Not recommended for general use. However, short-term exposure under certain restricted conditions could be acceptable (e.g. fast cleaning with thorough rinsing, spills, wiping, vapor exposure).