

# Crastin® HR5330HFS OR516

## THERMOPLASTIC POLYESTER RESIN

Common features of Crastin® thermoplastic polyester resin include mechanical and physical properties such as stiffness and toughness, heat resistance, friction and wear resistance, excellent surface finishes and good colourability. Crastin® thermoplastic polyester resin has excellent electrical insulation characteristics and high arc-resistant grades are available. Many flame retardant grades have UL recognition (class V-0). Crastin® thermoplastic polyester resin typically has high chemical and heat ageing resistance.

The good melt stability of Crastin® thermoplastic polyester resin normally enables the recycling of properly handled production waste.

If recycling is not possible, we recommend, as the preferred option, incineration with energy recovery (-24 kJ/g of base polymer) in appropriately equipped installations. For disposal, local regulations have to be observed.

Crastin® thermoplastic polyester resin typically is used in demanding applications in the electronics, electrical, automotive, mechanical engineering, chemical, domestic appliances and sporting goods industry.

**Crastin® HR5330HFS OR516 is a 30% glass reinforced PBT with high flow, moderately toughened, hydrolysis resistant (HR) polybutylene terephthalate for injection molding.**

### Product information

Resin Identification	PBT-IGF30	ISO 1043
Part Marking Code	>PBT-IGF30<	ISO 11469

### Rheological properties

Moulding shrinkage, parallel	0.2 %	ISO 294-4, 2577
Moulding shrinkage, normal	0.9 %	ISO 294-4, 2577

### Typical mechanical properties

Tensile modulus	8500 MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	120 MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	3.5 %	ISO 527-1/-2
Flexural modulus	7500 MPa	ISO 178
Charpy impact strength, 23°C	70 kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C	60 kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, 23°C	11 kJ/m <sup>2</sup>	ISO 179/1eA
Poisson's ratio	0.34	

### Thermal properties

Melting temperature, 10°C/min	225 °C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	65 °C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	205 °C	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	22 <sup>[DS]</sup> E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	190 <sup>[DS]</sup> E-6/K	ISO 11359-1/-2

[DS]: Derived from similar grade

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### Flammability

Burning Behav. at thickness h	HB class	IEC 60695-11-10
Thickness tested	0.75 mm	IEC 60695-11-10
UL recognition	yes	UL 94
Glow Wire Flammability Index, 0.4mm	775 °C	IEC 60695-2-12
Glow Wire Flammability Index, 0.75mm	775 °C	IEC 60695-2-12
Glow Wire Flammability Index, 1.0mm	775 °C	IEC 60695-2-12
Glow Wire Flammability Index, 1.5mm	775 °C	IEC 60695-2-12
Glow Wire Flammability Index, 3.0mm	800 °C	IEC 60695-2-12
FMVSS Class	B	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	34 mm/min	ISO 3795 (FMVSS 302)

### Electrical properties

Volume resistivity	>1E13 Ohm.m	IEC 62631-3-1
Surface resistivity	>1E15 Ohm	IEC 62631-3-2
Electric strength	36 kV/mm	IEC 60243-1
Comparative tracking index	600	IEC 60112

### Physical/Other properties

Humidity absorption, 2mm	0.15 <sup>[DS]</sup> %	Sim. to ISO 62
Water absorption, 2mm	0.35 <sup>[DS]</sup> %	Sim. to ISO 62
Density	1520 kg/m <sup>3</sup>	ISO 1183

[DS]: Derived from similar grade

### Injection

Drying Recommended	yes
Drying Temperature	120 °C
Drying Time, Dehumidified Dryer	2 - 4 h
Processing Moisture Content	≤0.04 %
Melt Temperature Optimum	250 °C
Min. melt temperature	240 °C
Max. melt temperature	260 °C
Mold Temperature Optimum	80 °C
Min. mould temperature	60 °C
Max. mould temperature	130 °C
Hold pressure range	≥60 MPa
Hold pressure time	3 s/mm
Back pressure	As low as possible MPa
Ejection temperature	170 °C

### Characteristics

Processing	Injection Moulding
Delivery form	Pellets
Additives	Release agent
Special characteristics	Hydrolysis resistant, High Flow

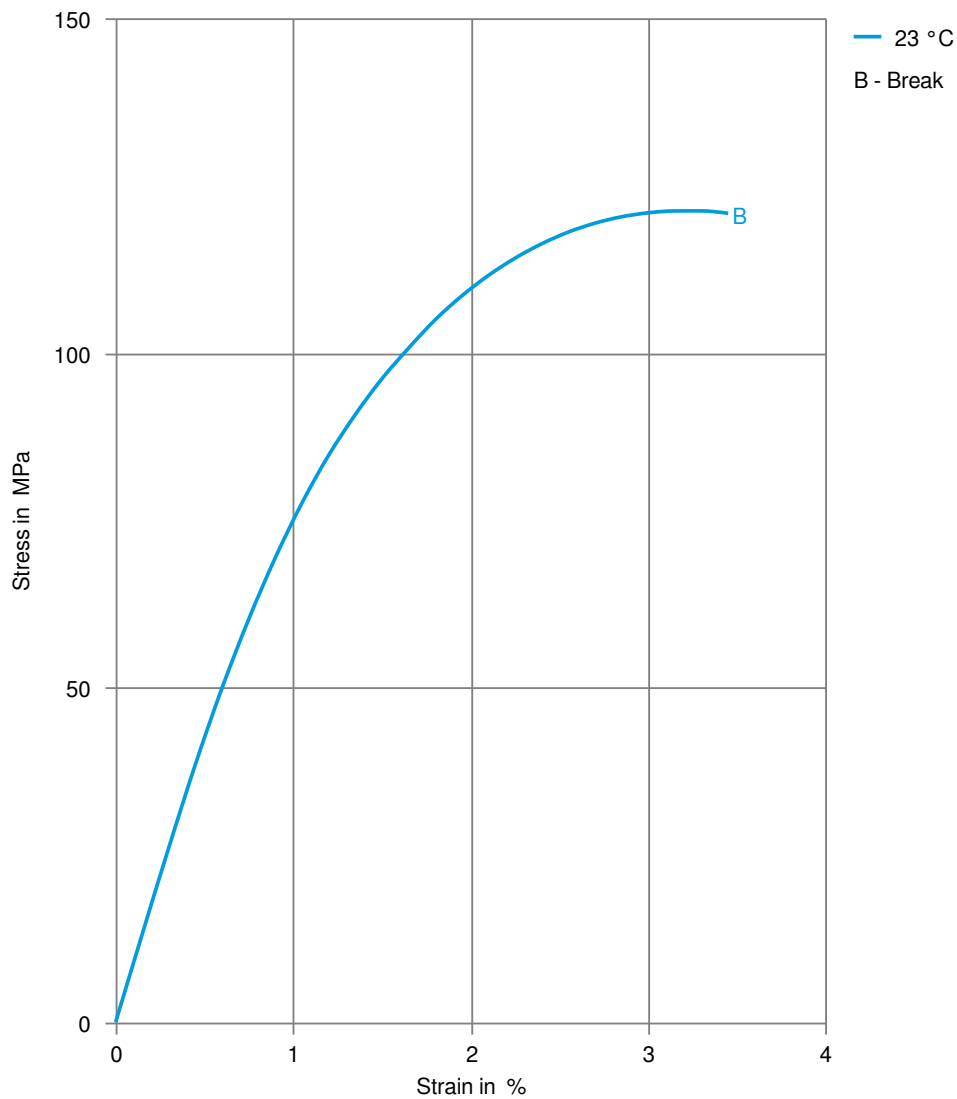
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### Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
General Motors	Orange/OR516; Special Parts Approval. See Your CE Account Representative for Further Details.	
Stellantis	B62 0300 / 61/U4/220E/218M/13/C1B/C5	01994_15_00092, OR516

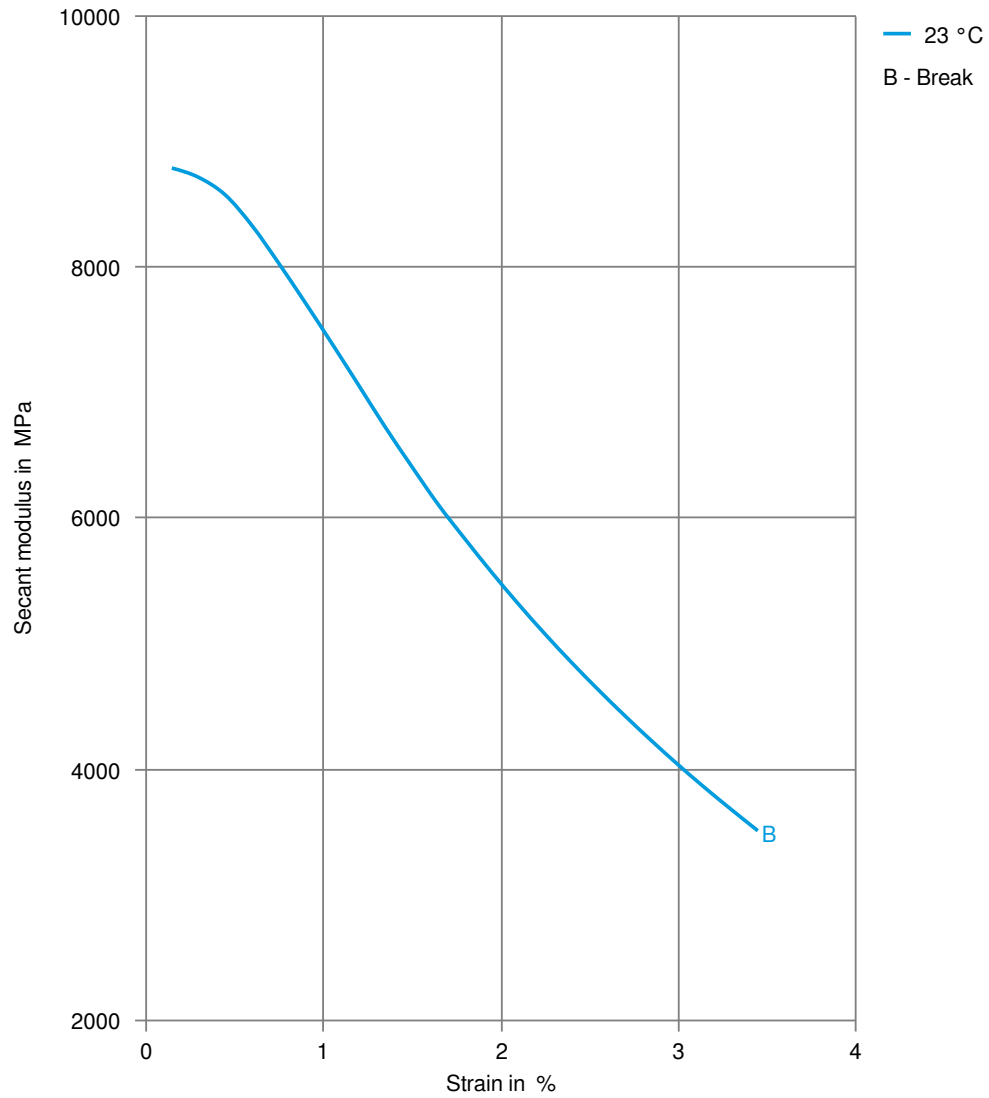
### Stress-strain



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## Secant modulus-strain



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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
- ✗ Chromic Acid solution (40% 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

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- ✓ Sodium Carbonate solution (20% by mass), 23 °C
- ✓ 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).