

# Crastin® SK602 BK851

## 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® SK602 BK851 is a 15% glass fiber reinforced, lubricated polybutylene terephthalate resin for injection moulding.

### Product information

Resin Identification	PBT-GF15	ISO 1043
Part Marking Code	>PBT-GF15<	ISO 11469

### Rheological properties

Moulding shrinkage, parallel	0.4 %	ISO 294-4, 2577
Moulding shrinkage, normal	1.1 %	ISO 294-4, 2577
Flow length	360 mm	
Flow length - pressure	80 MPa	
Flow length - width/thickness	2 mm	

### Typical mechanical properties

Tensile modulus	5800 MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	98 MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	3.5 %	ISO 527-1/-2
Charpy impact strength, 23°C	40 kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, 23°C	5.4 kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, 23°C	5 kJ/m <sup>2</sup>	ISO 180/1A
Poisson's ratio	0.35	

### 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	192 °C	ISO 75-1/-2
RTI, electrical, 0.75mm	130 °C	UL 746B
RTI, electrical, 1.5mm	130 °C	UL 746B
RTI, electrical, 3.0mm	130 °C	UL 746B
RTI, electrical, 6mm	130 °C	UL 746B
RTI, impact, 0.75mm	115 °C	UL 746B
RTI, impact, 1.5mm	115 °C	UL 746B
RTI, impact, 3.0mm	115 °C	UL 746B
RTI, impact, 6mm	115 °C	UL 746B

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RTI, strength, 0.75mm	120 °C	UL 746B
RTI, strength, 1.5mm	120 °C	UL 746B
RTI, strength, 3.0mm	120 °C	UL 746B
RTI, strength, 6mm	120 °C	UL 746B

### Flammability

Burning Behav. at 1.5mm nom. thickn.	HB class	IEC 60695-11-10
Thickness tested	1.5 mm	IEC 60695-11-10
UL recognition	yes	UL 94
Burning Behav. at thickness h	HB class	IEC 60695-11-10
Thickness tested	3 mm	IEC 60695-11-10
UL recognition	yes	UL 94
Glow Wire Flammability Index, 3.0mm	700 °C	IEC 60695-2-12
FMVSS Class	B	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	30 mm/min	ISO 3795 (FMVSS 302)

### Electrical properties

Relative permittivity, 100Hz	3.7	IEC 62631-2-1
Relative permittivity, 1MHz	3.6	IEC 62631-2-1
Dissipation factor, 100Hz	7 E-4	IEC 62631-2-1
Dissipation factor, 1MHz	172 E-4	IEC 62631-2-1
Volume resistivity	>1E13 Ohm.m	IEC 62631-3-1
Surface resistivity	1E14 Ohm	IEC 62631-3-2
Electric strength	35 kV/mm	IEC 60243-1
Comparative tracking index	225	IEC 60112

### Physical/Other properties

Density	1410 kg/m <sup>3</sup>	ISO 1183
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### VDA Properties

Odour	3 class	VDA 270
Fogging, G-value (condensate)	0.1 mg	ISO 6452

### 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

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Ejection temperature 170 °C

### Characteristics

Processing Injection Moulding

### Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
BMW	GS93016-PBT-GF15	
Bosch	N28 BN07-GF003	
Hyundai	MS941-03 Type F-3	
Renault	FRM, No Spec, Special Part Approval, See Your CE Account Manager.	
Renault-Nissan	UB22e, No Spec, Special Part Approval, See Your CE Account Manager.	
Stellantis - Chrysler	MS.50103 / CPN-2425	Black

### 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

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### 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
- ✓ 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).