

Crastin® FG6134 NC010

THERMOPLASTIC POLYESTER RESIN

DuPont Performance Polymers

Message:

Unreinforced Medium Viscosity Polybutylene Terephthalate Developed for Food Contact Applications

General Information			
Features	Compliance of Food Exposure		
	Medium viscosity		
Uses	Non-specific food applications		
RoHS Compliance	Contact manufacturer		
Forms	Particle		
Processing Method	Film extrusion		
	Extrusion		
	Casting		
	Sheet extrusion molding		
	Coating		
	Profile extrusion molding		
	Injection molding		
Part Marking Code (ISO 11469)	>PBT		
Resin ID (ISO 1043)	PBT		
Physical	Nominal Value	Unit	Test Method
Density	1.30	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	34	g/10 min	ISO 1133
Molding Shrinkage			ISO 294-4
Transverse flow	1.6	%	ISO 294-4
Flow	1.6	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2600	MPa	ISO 527-2
Tensile Stress (Yield)	59.0	MPa	ISO 527-2
Tensile Strain (Yield)	4.0	%	ISO 527-2
Nominal Tensile Strain at Break	45	%	ISO 527-2
Flexural Stress	85.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	4.0	kJ/m ²	ISO 179/1eA
Notched Izod Impact (23°C)	3.5	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method

Heat Deflection Temperature			
0.45 MPa, not annealed	115	°C	ISO 75-2/B
0.45 MPa, annealed	180	°C	ISO 75-2/B
1.8 MPa, not annealed	50.0	°C	ISO 75-2/A
1.8 MPa, annealed	60.0	°C	ISO 75-2/A
Melting Temperature ¹	225	°C	ISO 11357-3
Flammability	Nominal Value	Unit	Test Method
Burning Rate ² (1.00 mm)	< 100	mm/min	ISO 3795
Flammability Classification (1.5 mm)	HB		IEC 60695-11-10, -20
Oxygen Index	22	%	ISO 4589-2
FMVSS Flammability	B		FMVSS 302
Melt Temperature, Optimum	250	°C	
Mold Temperature, Optimum	80	°C	
Back Pressure	As low as possible		
Drying Recommended	yes		
Hold Pressure Time	4.00	s/mm	
Extrusion Melt Temperature, Optimum	250	°C	
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	%	
Processing (Melt) Temp	240 - 260	°C	
Mold Temperature	30 - 130	°C	
Holding Pressure	60.0	MPa	
Extrusion	Nominal Value	Unit	
Drying Temperature	110 - 130	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.040	%	
Melt Temperature	240 - 260	°C	
NOTE			
1.	10°C/min		
2.	FMVSS 302		

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

