

Crastin® SK643FR BK851

THERMOPLASTIC POLYESTER RESIN

DuPont Performance Polymers

Message:

20% Glass Reinforced, Flame Retardant, Polybutylene Terephthalate

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Additive	Flame retardancy		
Features	Flame retardancy		
RoHS Compliance	Contact manufacturer		
Part Marking Code (ISO 11469)	>PBT-GF20FR(17)		
Resin ID (ISO 1043)	PBT-GF20FR(17)		
Physical	Nominal Value	Unit	Test Method
Density	1.63	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Transverse flow	1.2	%	ISO 294-4
Transverse flow ¹	1.5	%	ISO 294-4
Flow	0.50	%	ISO 294-4
Flow ²	0.60	%	ISO 294-4
Water Absorption			ISO 62
Saturated, 23°C, 2.00mm	0.32	%	ISO 62
Balance, 23°C, 2.00mm, 50% RH	0.13	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8300	MPa	ISO 527-2
Tensile Stress (Break)	110	MPa	ISO 527-2
Tensile Strain (Break)	2.8	%	ISO 527-2
Flexural Stress	165	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	7.6	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	50	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	200	°C	ISO 75-2/A
Melting Temperature ³	225	°C	ISO 11357-3
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index	225	V	IEC 60112
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
Oxygen Index	32	%	ISO 4589-2
FMVSS Flammability	DNI		FMVSS 302
Melt Temperature, Optimum	250	°C	
Mold Temperature, Optimum	80	°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	%	
Processing (Melt) Temp	240 - 260	°C	
Mold Temperature	30 - 130	°C	
Holding Pressure	60.0	MPa	
NOTE			
1.	Annealed		
2.	Annealed		
3.	10°C/min		

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