

Crastin® FGS600F10 NC010

THERMOPLASTIC POLYESTER RESIN

DuPont Performance Polymers

Message:

Unreinforced Polybutylene Terephthalate Developed for Food Contact Applications

General Information			
Additive	demoulding		
Uses	Profile		
Forms	Particle		
Processing Method	Extrusion		
	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/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	10	g/10 min	ISO 1133
Molding Shrinkage			ISO 294-4
Vertical flow direction	1.6	%	ISO 294-4
Flow direction	1.7	%	ISO 294-4
Water Absorption			ISO 62
23°C, 24 hr, 2.00 mm	0.50	%	ISO 62
Balance, 23°C, 2.00mm, 50% RH	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2600	MPa	ISO 527-2
Tensile Stress (Yield)	57.0	MPa	ISO 527-2
Tensile Strain (Yield)	4.0	%	ISO 527-2
Nominal Tensile Strain at Break	> 50	%	ISO 527-2
Tensile Creep Modulus			ISO 899-1
1 hr	2600	MPa	ISO 899-1
1000 hr	1800	MPa	ISO 899-1
Flexural Modulus	2300	MPa	ISO 178
Flexural Stress	85.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	4.0	kJ/m²	ISO 179/1eA

23°C	5.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	No Break		ISO 179/1eU
23°C	No Break		ISO 179/1eU
Notched Izod Impact			ISO 180/1A
-30°C	5.0	kJ/m ²	ISO 180/1A
23°C	5.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength			ISO 180/1U
-30°C	130	kJ/m ²	ISO 180/1U
23°C	No Break		ISO 180/1U
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
Glass Transition Temperature ¹	55.0	°C	ISO 11357-2
Vicat Softening Temperature	175	°C	ISO 306/B50
Melting Temperature ²	223	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow	1.1E-4	cm/cm/°C	ISO 11359-2
Lateral	1.2E-4	cm/cm/°C	ISO 11359-2
Fill Analysis	Nominal Value	Unit	
Melt Density	1.11	g/cm ³	
Specific Heat Capacity of Melt	2100	J/kg/°C	
Thermal Conductivity of Melt	0.21	W/m/K	
NOTE			
1.	10°C/min		
2.	10°C/min		

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