

Crastin® FG6130 NC010

THERMOPLASTIC POLYESTER RESIN

DuPont Performance Polymers

Message:

Unreinforced High Viscosity Polybutylene Terephthalate Developed for Food Contact Applications and Extrusion and Injection Molding

General Information			
Uses	Film		
	Profiles		
	Sheet		
Agency Ratings	UL Unspecified Rating		
Forms	Pellets		
Processing Method	Coating		
	Extrusion		
	Film Extrusion		
	Injection Molding		
	Profile Extrusion		
	Sheet Extrusion		
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)	15	g/10 min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	1.5	%	
Flow	1.6	%	
Water Absorption			ISO 62
23°C, 24 hr, 2.00 mm	0.40	%	
Equilibrium, 23°C, 2.00 mm, 50% RH	0.20	%	
Viscosity Number	130	cm ³ /g	ISO 307
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)	8.0	%	ISO 527-2
Nominal Tensile Strain at Break	50	%	ISO 527-2
Tensile Creep Modulus			ISO 899-1
1 hr	2500	MPa	

1000 hr	1800	MPa	
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	4.5	kJ/m ²	
23°C	5.0	kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	No Break		
23°C	No Break		
Notched Izod Impact Strength (23°C)	4.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	115	°C	ISO 75-2/B
0.45 MPa, Annealed	180	°C	ISO 75-2/B
1.8 MPa, Unannealed	50.0	°C	ISO 75-2/A
1.8 MPa, Annealed	60.0	°C	ISO 75-2/A
Vicat Softening Temperature	175	°C	ISO 306/B50
Melting Temperature ¹	225	°C	ISO 11357-3
CLTE			ISO 11359-2
Flow	1.1E-4	cm/cm/°C	
Transverse	1.4E-4	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+12	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	ohms·cm	IEC 60093
Electric Strength	26	kV/mm	IEC 60243-1
Comparative Tracking Index	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flammability Classification			IEC 60695-11-10, -20
0.810 mm	HB		
1.50 mm	HB		
Oxygen Index	22	%	ISO 4589-2
Fill Analysis	Nominal Value	Unit	
Melt Density	1.12	g/cm ³	
Specific Heat Capacity of Melt	2050	J/kg/°C	
Thermal Conductivity of Melt	0.25	W/m/K	
NOTE			
1.	10°C/min		

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