



# Crastin® LW9020FR 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, DuPont recommends, 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® LW9020FR BK851 is a 20% glass fiber reinforced, flame retardant polybutylene terephthalate blend for injection moulding. It has improved surface aesthetics, excellent dimensional stability and low warpage characteristics.

### Product information

Resin Identification	PBT+ASA-GF20FR(17)	ISO 1043
Part Marking Code	>PBT+ASA-GF20FR(17)<	ISO 11469

### Rheological properties

Melt mass-flow rate	16 g/10min	ISO 1133
Melt mass-flow rate, Temperature	250 °C	ISO 1133
Melt mass-flow rate, Load	5 kg	ISO 1133
Moulding shrinkage, parallel	0.4 <sup>[DS]</sup> %	ISO 294-4, 2577
Moulding shrinkage, normal	0.8 <sup>[DS]</sup> %	ISO 294-4, 2577

[DS]: Derived from similar grade

### Typical mechanical properties

Tensile Modulus	7800 MPa	ISO 527-1/-2
Stress at break	100 MPa	ISO 527-1/-2
Strain at break	2 %	ISO 527-1/-2
Flexural Strength	140 MPa	ISO 178
Charpy impact strength, 23°C	35 kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C	35 <sup>[DS]</sup> kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, 23°C	6.5 kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	6.5 <sup>[DS]</sup> kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, 23°C	5.5 kJ/m <sup>2</sup>	ISO 180/1A
Poisson's ratio	0.34 -	



# Crastin® LW9020FR BK851

## THERMOPLASTIC POLYESTER RESIN

[DS]: Derived from similar grade

### Thermal properties

Melting temperature, 10°C/min	225 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	170 °C	ISO 75-1/-2
RTI, electrical, 0.75mm	140 °C	UL 746B
RTI, electrical, 1.5mm	140 °C	UL 746B
RTI, electrical, 3mm	140 °C	UL 746B
RTI, impact, 0.75mm	115 °C	UL 746B
RTI, impact, 1.5mm	115 °C	UL 746B
RTI, impact, 3mm	120 °C	UL 746B
RTI, strength, 0.75mm	130 °C	UL 746B
RTI, strength, 1.5mm	130 °C	UL 746B
RTI, strength, 3mm	130 °C	UL 746B

### Flammability

Burning Behav. at 1.5mm nom. thickn.	V-0 class	IEC 60695-11-10
Thickness tested	1.5 mm	IEC 60695-11-10
UL recognition	yes -	UL 94
Burning Behav. at thickness h	V-0 class	IEC 60695-11-10
Thickness tested	3 mm	IEC 60695-11-10
UL recognition	yes -	UL 94
Oxygen index	27 %	ISO 4589-1/-2
Glow Wire Flammability Index, 3mm	960 °C	IEC 60695-2-12
FMVSS Class	DNI -	ISO 3795 (FMVSS 302)

### Electrical properties

Relative permittivity, 100Hz	4.3 -	IEC 62631-2-1
Relative permittivity, 1MHz	4 -	IEC 62631-2-1
Dissipation factor, 100Hz	54 E-4	IEC 62631-2-1
Dissipation factor, 1MHz	196 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	31 kV/mm	IEC 60243-1
Comparative tracking index	250 -	IEC 60112

### Other properties

Humidity absorption, 2mm	0.23 <sup>[DS]</sup> %	Sim. to ISO 62
Water absorption, 2mm	0.78 <sup>[DS]</sup> %	Sim. to ISO 62
Density	1500 kg/m <sup>3</sup>	ISO 1183
Density of melt	1360 kg/m <sup>3</sup>	

[DS]: Derived from similar grade

# Crastin® LW9020FR BK851

## THERMOPLASTIC POLYESTER RESIN

### 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	30 °C
Max. mould temperature	130 °C
Hold pressure range	≥60 MPa
Hold pressure time	3 s/mm
Back pressure	As low as possible MPa
Ejection temperature	170 °C

### Characteristics

Additives	Flame retardant
-----------	-----------------

### 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

# Crastin® LW9020FR BK851

## THERMOPLASTIC POLYESTER RESIN

- ✓ iso-Octane, 23°C

### Ketones

- ✓ Acetone, 23°C

### Ethers

- ✓ Diethyl ether, 23°C

### 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).



# Crastin® LW9020FR BK851

THERMOPLASTIC POLYESTER RESIN

Revised: 2021-03-26

Page: 5 of 5

[dupont.com](http://dupont.com)

The information set forth herein is furnished free of charge, is based on technical data that DuPont believes to be reliable, and represents typical values that fall within the normal range of properties. This information relates only to the specific material designated and may not be valid for such material used in combination with other materials or in other processes. It is intended for use by persons having technical skill, at their own discretion and risk. This information should not be used to establish specification limits nor used alone as the basis of design. Handling precaution information is given with the understanding that those using it will satisfy themselves that their particular conditions of use present no health or safety hazards and comply with applicable law. Since conditions of product use and disposal are outside our control, we make no warranties, express or implied, and assume no liability in connection with any use of this information. As with any product, evaluation under end-use conditions prior to specification is essential. Nothing herein is to be taken as a license to operate or a recommendation to infringe on patents.

**CAUTION:** Do not use DuPont materials in medical applications involving implantation in the human body or contact with internal body fluids or tissues unless the material has been provided from DuPont under a written contract or other acknowledgement that is consistent with the DuPont policy regarding medical applications and expressly acknowledges the contemplated use. For further information, please contact your DuPont representative.

DuPont's sole warranty is that our products will meet our standard sales specifications in effect at the time of shipment. Your exclusive remedy for breach of such warranty is limited to refund of purchase price or replacement of any product shown to be other than as warranted. TO THE FULLEST EXTENT PERMITTED BY APPLICABLE LAW, DUPONT SPECIFICALLY DISCLAIMS ANY OTHER EXPRESS OR IMPLIED WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE, MERCHANTABILITY, OR NON-INFRINGEMENT. DUPONT DISCLAIMS LIABILITY FOR ANY SPECIAL, INCIDENTAL, OR CONSEQUENTIAL DAMAGES.

DuPont™, the DuPont Oval Logo, and all trademarks and service marks denoted with ™, SM or ® are owned by affiliates of DuPont de Nemours, Inc. unless otherwise noted.

© 2021 DuPont. All rights reserved.