



# Crastin® HR5315HF BK503

## 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® HR5315HF is a 15% glass reinforced PBT with high flow (HF), moderately toughened, hydrolysis resistant (HR) resin. Excellent balance of properties between terminal pullout and impact resistance. Developed for USCAR Class 3 and 4 environments.

### Product information

Resin Identification	PBT-IGF15	ISO 1043
Part Marking Code	>PBT-IGF15<	ISO 11469

### Rheological properties

Melt mass-flow rate	23 g/10min	ISO 1133
Melt mass-flow rate, Temperature	250 °C	ISO 1133
Melt mass-flow rate, Load	2.16 kg	ISO 1133
Moulding shrinkage, parallel	0.5 %	ISO 294-4, 2577
Moulding shrinkage, normal	1.1 %	ISO 294-4, 2577

### Typical mechanical properties

Tensile Modulus	5200 MPa	ISO 527-1/-2
Stress at break	92 MPa	ISO 527-1/-2
Strain at break	3.4 %	ISO 527-1/-2
Flexural Modulus	4700 MPa	ISO 178
Charpy impact strength, 23°C	50 kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, 23°C	10 kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	6 kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, 23°C	10 kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength, -40°C	6 kJ/m <sup>2</sup>	ISO 180/1A
Izod impact strength, 23°C	40 kJ/m <sup>2</sup>	ISO 180/1U
Hardness, Rockwell, R-scale	117 -	ISO 2039-2



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Poisson's ratio 0.35 -

### Thermal properties

Melting temperature, 10°C/min	225 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	200 °C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	220 °C	ISO 75-1/-2

### Flammability

Burning Behav. at thickness h	HB class	IEC 60695-11-10
Thickness tested	0.75 mm	IEC 60695-11-10
Oxygen index	20 %	ISO 4589-1/-2
Glow Wire Flammability Index, 3mm	700 °C	IEC 60695-2-12
FMVSS Class	B -	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	32 mm/min	ISO 3795 (FMVSS 302)

### Electrical properties

Relative permittivity, 100Hz	3.8 -	IEC 62631-2-1
Relative permittivity, 1MHz	3.7 -	IEC 62631-2-1
Dissipation factor, 100Hz	23 E-4	IEC 62631-2-1
Dissipation factor, 1MHz	178 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	36 kV/mm	IEC 60243-1
Comparative tracking index	300 -	IEC 60112

### Other properties

Density	1370 kg/m <sup>3</sup>	ISO 1183
Density of melt	1140 kg/m <sup>3</sup>	
Water Absorption, Immersion 24h	0.08 %	Sim. to ISO 62

### 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



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Back pressure

As low as MPa  
possible

Ejection temperature

170 °C

## Additional Information

Injection molding

Use of hot-runners is possible with Crastin® HR resins.

However we do not recommend temperature settings above 270°C and residence times at 265°C should be below 10 minutes.

In case of longer residence times using hot-runners, for example after a shut-down,

the complete system must be purged with glass reinforced Crastin® (type SK602/605) before starting up again.

For successful processing of Crastin® HR with hot-runners, care should be taken

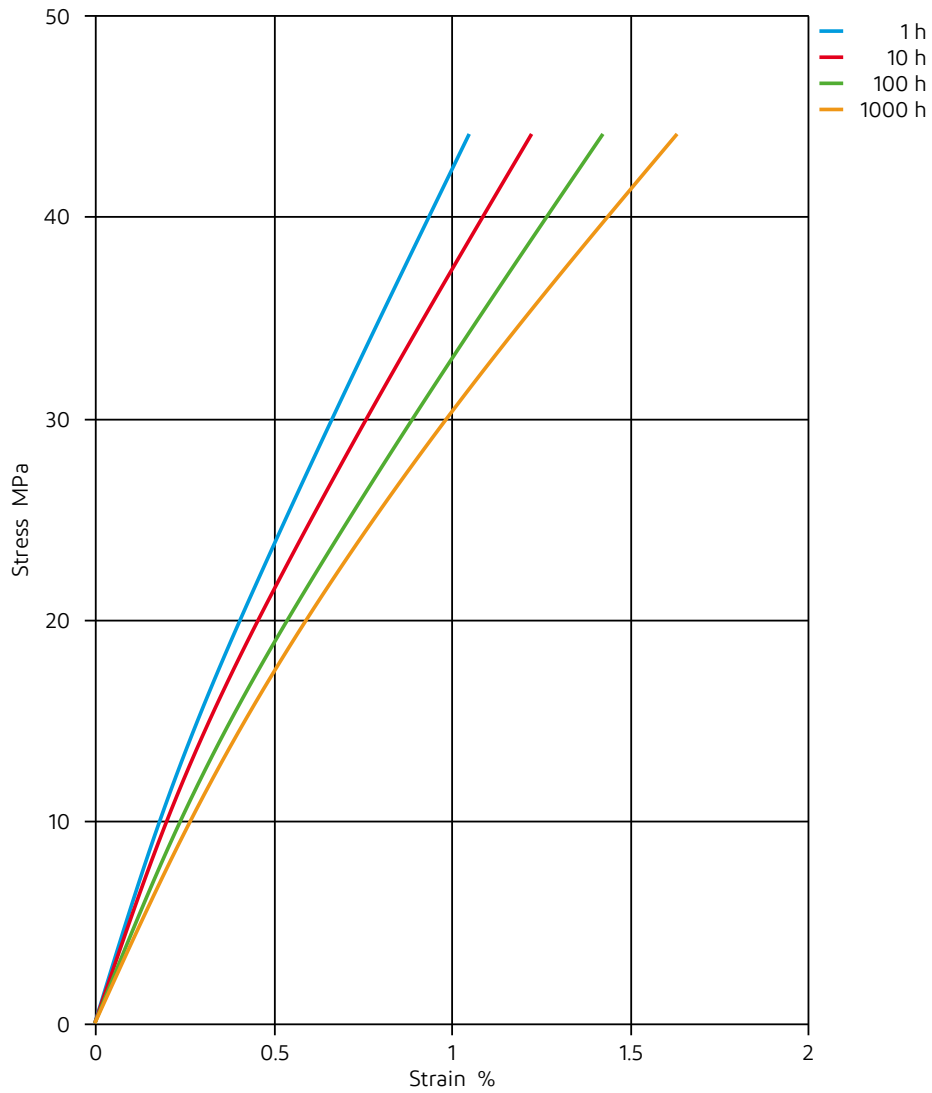
to maintain a uniform temperature, avoid hot-spots and long residence times.



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THERMOPLASTIC POLYESTER RESIN

Stress-strain (isochronous) 23°C

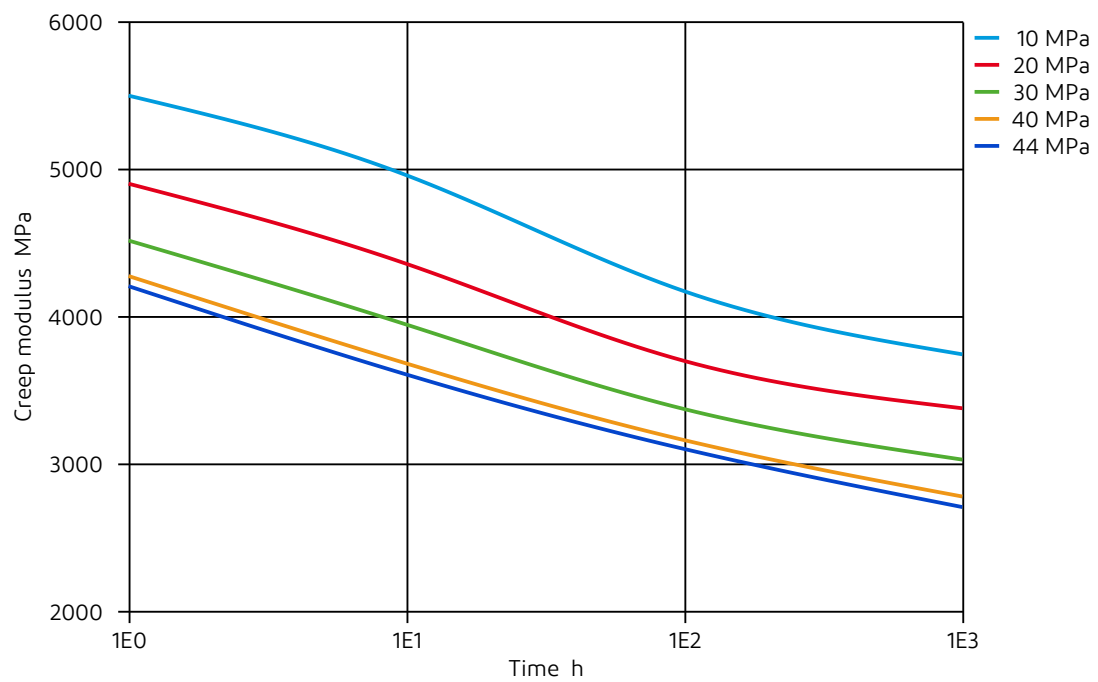




# Crastin<sup>®</sup> HR5315HF BK503

THERMOPLASTIC POLYESTER RESIN

Creep modulus-time 23°C

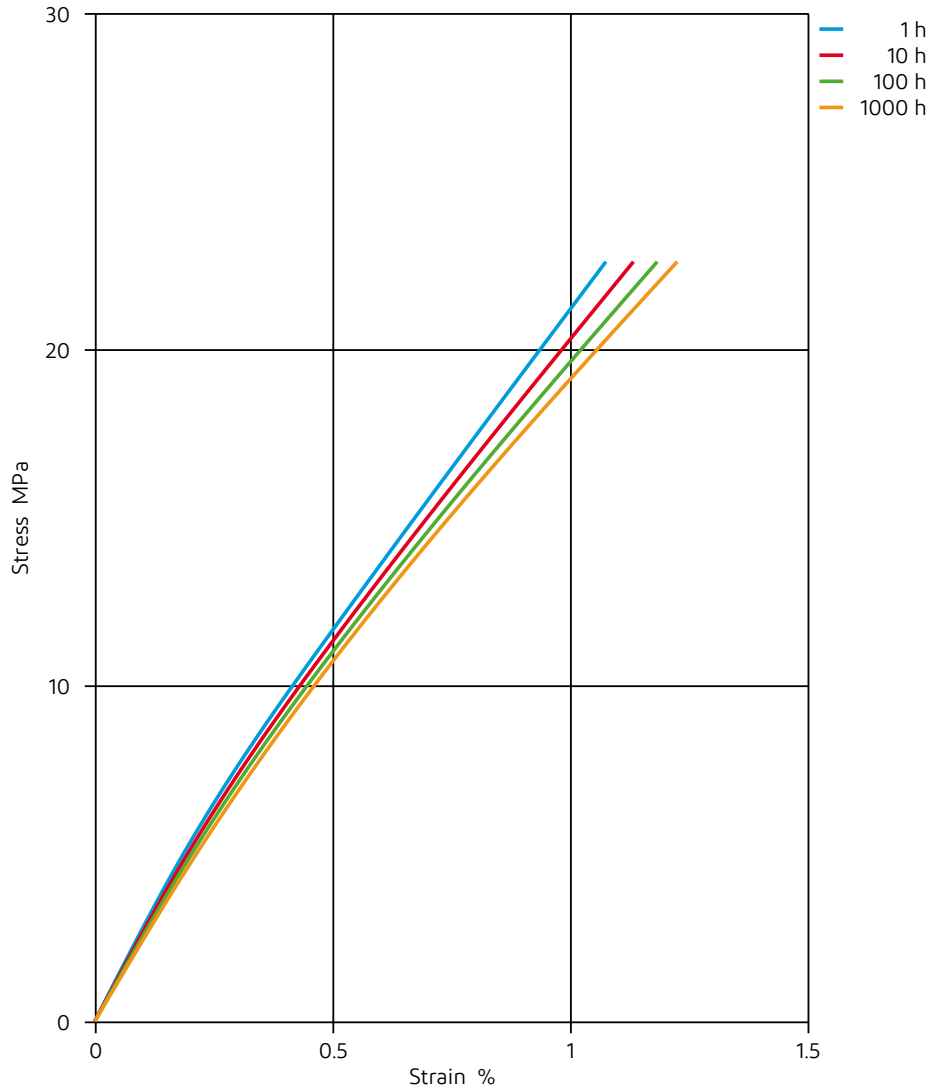




# Crastin<sup>®</sup> HR5315HF BK503

THERMOPLASTIC POLYESTER RESIN

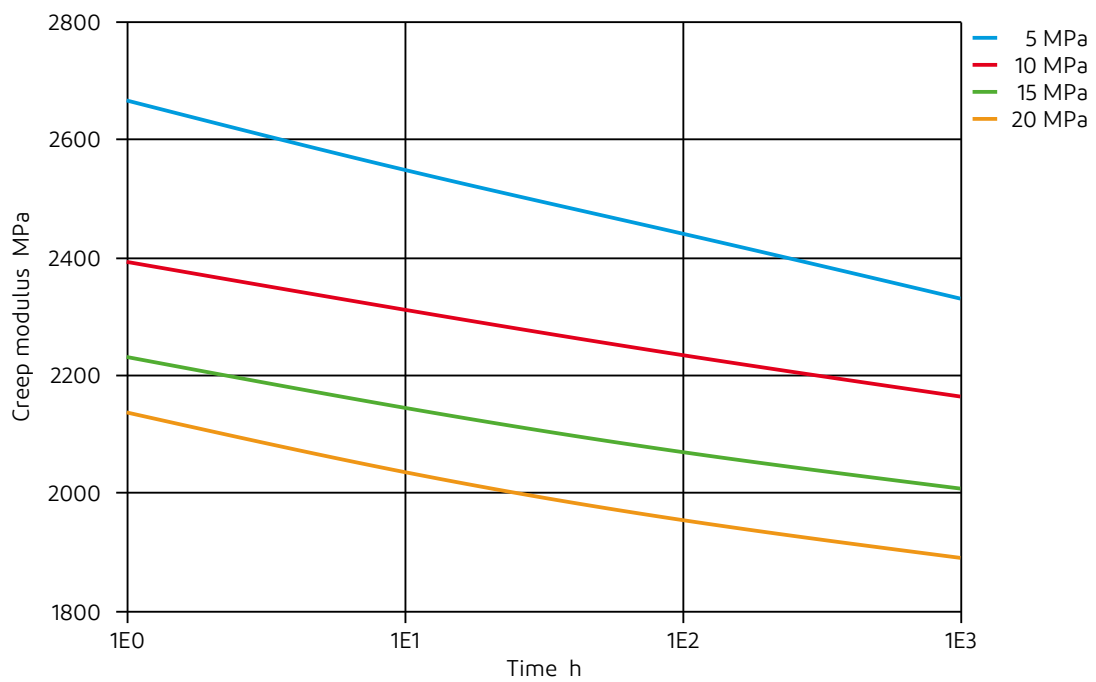
Stress-strain (isochronous) 90°C



# Crastin<sup>®</sup> HR5315HF BK503

THERMOPLASTIC POLYESTER RESIN

Creep modulus-time 90°C

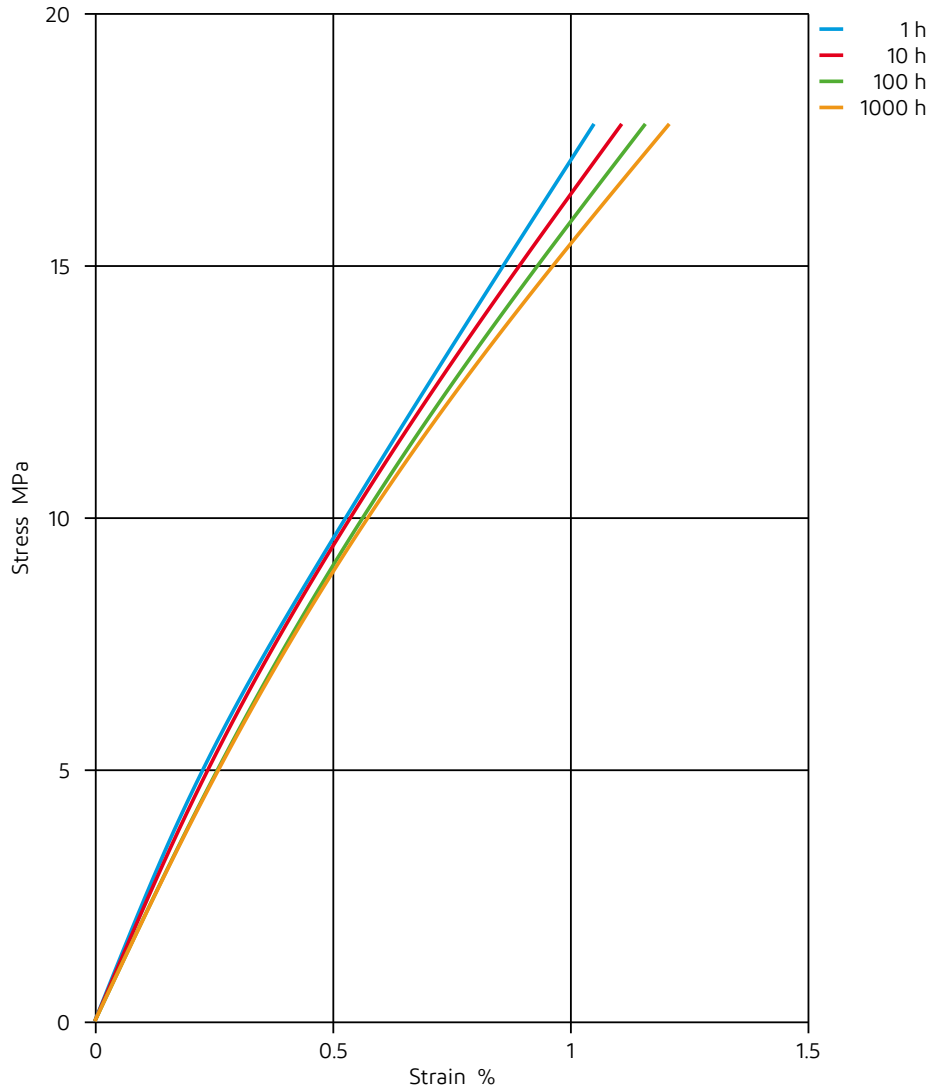




# Crastin<sup>®</sup> HR5315HF BK503

THERMOPLASTIC POLYESTER RESIN

Stress-strain (isochronous) 120°C



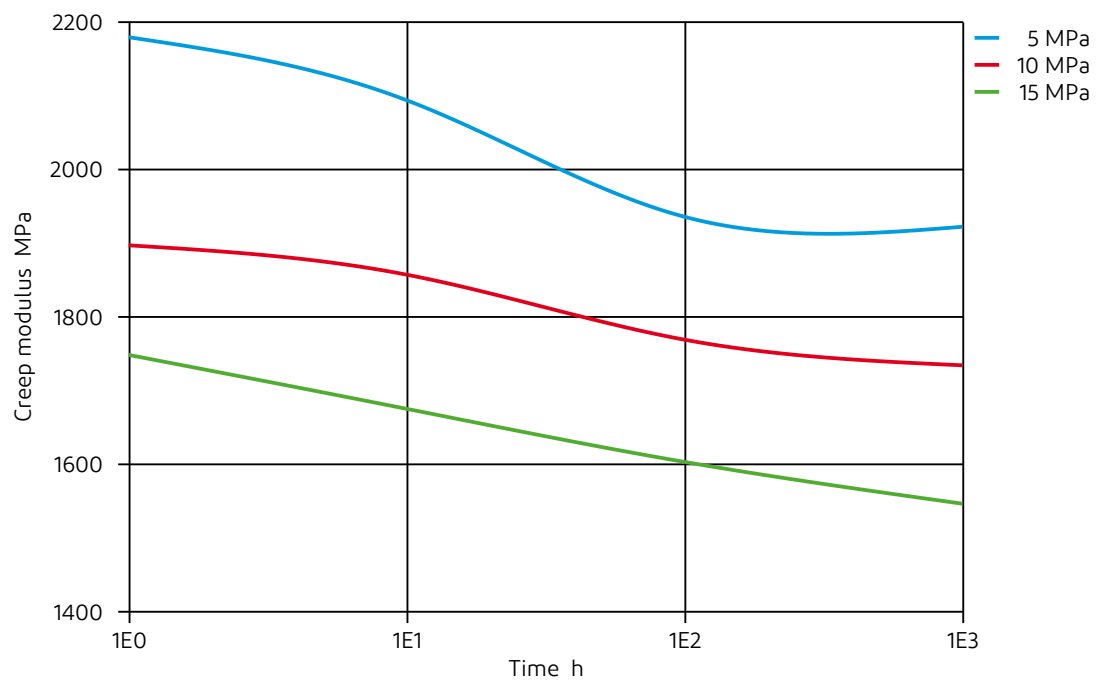




# Crastin® HR5315HF BK503

THERMOPLASTIC POLYESTER RESIN

Creep modulus-time 120°C



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## THERMOPLASTIC POLYESTER RESIN

### 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
- ✓ 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

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### 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).

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