

Crastin[®] 6140 NC010 THERMOPLASTIC POLYESTER RESIN

Crastin® 6140 NC010 is an Unreinforced Low Viscosity Polybutylene Terephthalate

Product information Resin Identification Part Marking Code	PBT >PBT<	ISO 1043 ISO 11469
Rheological properties		
Melt mass-flow rate Melt mass-flow rate, Temperature Melt mass-flow rate, Load Intrinsic viscosity	250 g/10min 250 °C 2.16 kg 0.63	ISO 1133 ISO 307, 1628
Moulding shrinkage, parallel Moulding shrinkage, normal	1.5 % 1.5 %	ISO 294-4, 2577 ISO 294-4, 2577
Typical mechanical properties		
Tensile modulus Tensile stress at break, 5mm/min Tensile strain at break, 5mm/min Charpy impact strength, 23°C Charpy notched impact strength, 23°C Poisson's ratio	2500 MPa 55 MPa 2.8 % 66 kJ/m ² 1.8 kJ/m ² 0.38	ISO 527-1/-2 ISO 527-1/-2 ISO 527-1/-2 ISO 179/1eU ISO 179/1eA
Thermal properties		
Melting temperature, 10°C/min Glass transition temperature, 10°C/min	225 °C 55 °C	ISO 11357-1/-3 ISO 11357-1/-3
Flammability		
FMVSS Class Burning rate, Thickness 1 mm	B <80 mm/min	ISO 3795 (FMVSS 302) ISO 3795 (FMVSS 302)
Physical/Other properties		
Density	1310 kg/m ³	ISO 1183
Injection		
Drying Recommended Drying Temperature Drying Time, Dehumidified Dryer Processing Moisture Content Melt Temperature Optimum Min. melt temperature Max. melt temperature Mold Temperature Optimum Min. mould temperature	yes 120 °C 2 - 4 h ≤0.04 % 250 °C 240 °C 260 °C 80 °C 30 °C	
Max. mould temperature	130 °C	

Printed: 2024-09-02



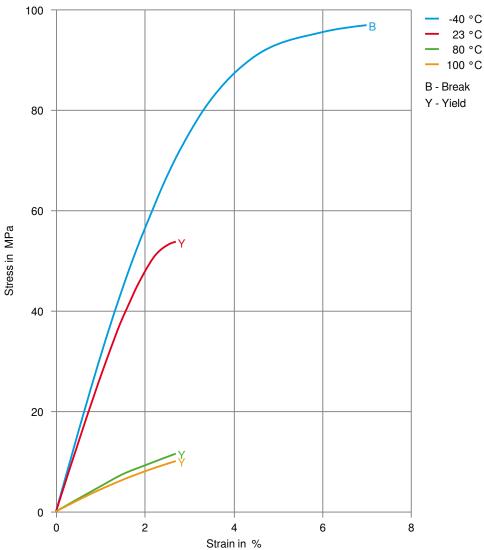
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Hold pressure range Hold pressure time Back pressure

Ejection temperature

Stress-strain (measured on Crastin® S600F40 NC010)



≥60 MPa

As low as MPa possible

170 °C

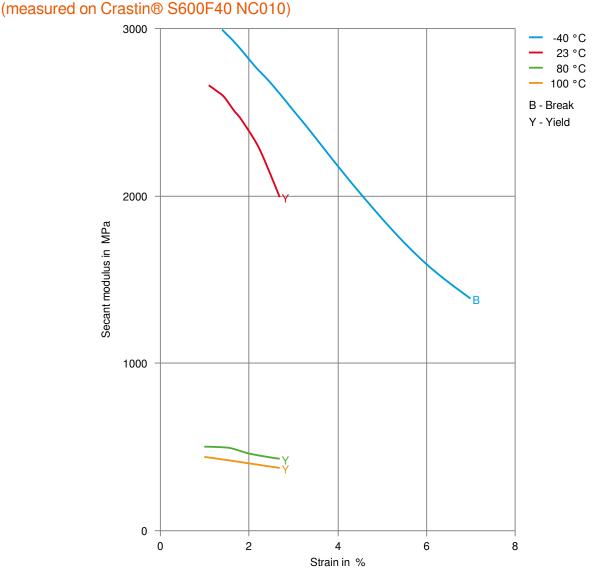
4 s/mm



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Secant modulus-strain



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