

THERMOPLASTIC POLYESTER RESIN

Crastin® SK605LM BK591 is a 30% Glass Reinforced, Laser Markable, Polybutylene Terephthalate

Product information Resin Identification Part Marking Code	PBT-GF30 >PBT-GF30<		ISO 1043 ISO 11469
Rheological properties Melt volume-flow rate Temperature	250		ISO 1133
Load Moulding shrinkage, parallel Moulding shrinkage, normal	2.16 0.3 1.1	%	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 Flexural strength Charpy impact strength, 23°C Charpy notched impact strength, 23°C Poisson's ratio	2.5 200 70	MPa	ISO 527-1/-2 ISO 527-1/-2 ISO 527-1/-2 ISO 178 ISO 179/1eU ISO 179/1eA
Thermal properties			
Melting temperature, 10°C/min Glass transition temperature, 10°C/min Temperature of deflection under load, 1.8 MPa Temperature of deflection under load, 0.45 MPa [DS]: Derived from similar grade	225 55 205 220 ^[DS]	°C °C	ISO 11357-1/-3 ISO 11357-1/-3 ISO 75-1/-2 ISO 75-1/-2
Flammability			
Burning Behav. at 1.5mm nom. thickn. Thickness tested Burning Behav. at thickness h Thickness tested Oxygen index Glow Wire Flammability Index, 0.75mm Glow Wire Flammability Index, 1.5mm Glow Wire Flammability Index, 3.0mm Glow Wire Ignition Temperature, 0.75mm Glow Wire Ignition Temperature, 1.5mm Glow Wire Ignition Temperature, 3.0mm FMVSS Class Burning rate, Thickness 1 mm	1.5 HB 0.75 20 725 725 825 750 750 800 B	% °C °C °C °C °C	IEC 60695-11-10 IEC 60695-11-10 IEC 60695-11-10 IEC 60695-11-10 IEC 60695-2-12 IEC 60695-2-12 IEC 60695-2-12 IEC 60695-2-13 IEC 60695-2-13

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Physical/Other properties

Density	1520	kg/m ³	ISO 1183
VDA Properties			
Odour	3	class	VDA 270
Fogging, F-value (refraction)	99		ISO 6452
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	MPa	
	possible		
Ejection temperature	170	°C	

Characteristics

Additives

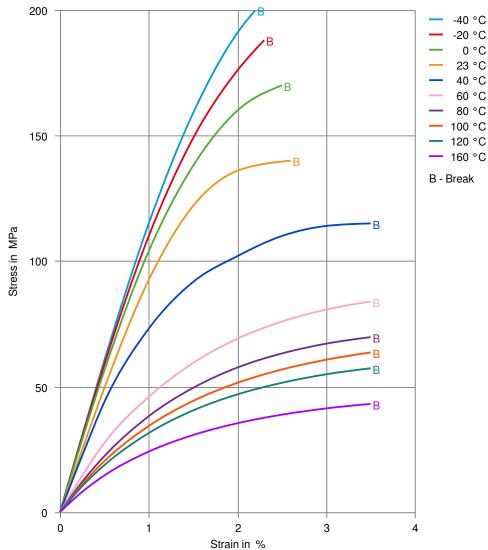
Release agent



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Stress-strain

(measured on Crastin® SK605 NC010)

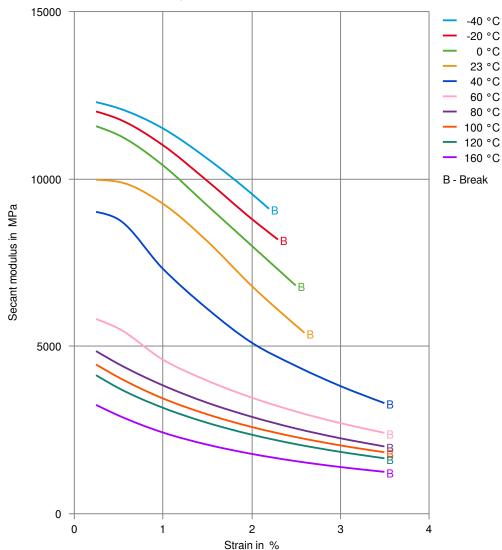




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Secant modulus-strain

(measured on Crastin® SK605 NC010)





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Chemical Media Resistance

Other

✓ Water, 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).

X 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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Revised: 2024-07-10 Source: Celanese Materials Database

NOTICE TO USERS: Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colourants or other additives may cause significant variations in data values. Properties of moulded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design not intended for use in medical or dental implants. Regardless of any such product expressly identified as medical grade (including by MT® product designation or otherwise), Celanese's products are not intended for use in medical or dental implants. Regardless of any such product designation, any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use. To the best of our knowledge, the information contained in this publication is accurate; however, we do not assume any liability whatsoever for the accuracy and completeness of such information. The information contained in this publication as a promise or guarantee of specific properties of our products. It is the sole responsibility of the users to investigate whether any existing patents are infringed by the use of the materials mentioned in this publication. Moreover, there is a need to reduce human exposure to many materials the lowest that texist. We recommend that persons intending to rely on any recommendation or to use any equipment, processing technique or material mentioned in this publication should satisfy themselves that they can meet all applicable safety and health standards. We strongly recommend that users seek and adhere to the m

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