

Crastin® FR684NH1 NC010

THERMOPLASTIC POLYESTER RESIN

Crastin® FR684NH1 is a 25% Glass Reinforced, Flame Retardant, Non-Halogenated, Polybutylene Terephthalate

Product information

Resin Identification	PBT- GF25FR(40)	ISO 1043
Part Marking Code	>PBT-GF25FR(40)<	ISO 11469

Rheological properties

Melt mass-flow rate	7 g/10min	ISO 1133
Melt mass-flow rate, Temperature	250 °C	
Melt mass-flow rate, Load	2.16 kg	
Moulding shrinkage, parallel	0.5 %	ISO 294-4, 2577
Moulding shrinkage, normal	1.2 %	ISO 294-4, 2577
Flow length	280 mm	
Flow length - pressure	110 MPa	
Flow length - width/thickness	2 mm	

Typical mechanical properties

Tensile Modulus	9400 MPa	ISO 527-1/-2
Stress at break, 5mm/min	95 MPa	ISO 527-1/-2
Strain at break, 5mm/min	2.5 %	ISO 527-1/-2
Charpy impact strength, 23°C	43 kJ/m²	ISO 179/1eU
Charpy impact strength, -30°C	46 kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	7.5 kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	6.8 kJ/m²	ISO 179/1eA
Poisson's ratio	0.34	

Thermal properties

Melting temperature, 10°C/min	223 °C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	60 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	205 °C	ISO 75-1/-2
Ball pressure test	220 °C	IEC 60695-10-2
Coeff. of linear therm. expansion, parallel, -40-23°C	23 E-6/K	ISO 11359-1/-2
CLTE, Parallel, 23-55°C(73-130°F)	29 E-6/K	ASTM E 831
Coeff. of linear therm. expansion, parallel, 55-160°C	20 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal, -40-23°C	66 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, Normal, 23-55°C (73-130°F)	122 E-6/K	ASTM E 831
Coeff. of linear therm. expansion, normal, 55-160°C	127 E-6/K	ISO 11359-1/-2
RTI, electrical, 0.75mm	130 °C	UL 746B
RTI, electrical, 1.5mm	130 °C	UL 746B



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RTI, electrical, 3mm	130 °C	UL 746B
RTI, impact, 0.75mm	125 °C	UL 746B
RTI, impact, 1.5mm	125 °C	UL 746B
RTI, impact, 3mm	125 °C	UL 746B
RTI, strength, 0.75mm	140 °C	UL 746B
RTI, strength, 1.5mm	140 °C	UL 746B
RTI, strength, 3mm	140 °C	UL 746B
TGA curve	available	ISO 11359-1/-2

Flammability

Burning Behav. at 1.5mm nom. thickn.	V-0 class	UL 94
Thickness tested	1.5 mm	UL 94
UL recognition	yes	UL 94
Burning Behav. at thickness h	V-0 class	UL 94
Thickness tested	0.4 mm	UL 94
UL recognition	yes	UL 94
Oxygen index	40 %	ISO 4589-1/-2
Glow Wire Flammability Index, 0.4mm	960 °C	IEC 60695-2-12
Glow Wire Flammability Index, 0.75mm	960 °C	IEC 60695-2-12
Glow Wire Flammability Index, 1mm	960 °C	IEC 60695-2-12
Glow Wire Flammability Index, 1.5mm	960 °C	IEC 60695-2-12
Glow Wire Flammability Index, 3mm	960 °C	IEC 60695-2-12
Glow Wire Ignition Temperature, 0.75mm	750 °C	IEC 60695-2-13
Glow Wire Ignition Temperature, 0.4mm	750 °C	IEC 60695-2-12
Glow Wire Ignition Temperature, 1mm	750 °C	IEC 60695-2-13
Glow Wire Ignition Temperature, 1.5mm	750 °C	IEC 60695-2-13
Glow Wire Ignition Temperature, 3mm	800 °C	IEC 60695-2-13
Railway classification	R22	EN 45545-2
Railway classification rating	HL1	EN 45545-2

Electrical properties

Volume resistivity	>1E13 Ohm.m	IEC 62631-3-1
Surface resistivity	>1E15 Ohm	IEC 62631-3-2
Electric strength	42 kV/mm	IEC 60243-1
Comparative tracking index	600	IEC 60112
Comparative tracking index	PLC	UL 746A

Other properties

Humidity absorption, 2mm	0.1 ^[DS] %	Sim. to ISO 62
Water absorption, 2mm	0.25 ^[DS] %	Sim. to ISO 62
Density	1520 kg/m³	ISO 1183

[DS]: Derived from similar grade



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VDA Properties

Emission of organic compounds	39 µgC/g	VDA 277
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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	Internal
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	
Ejection temperature	170 °C	Internal

Characteristics

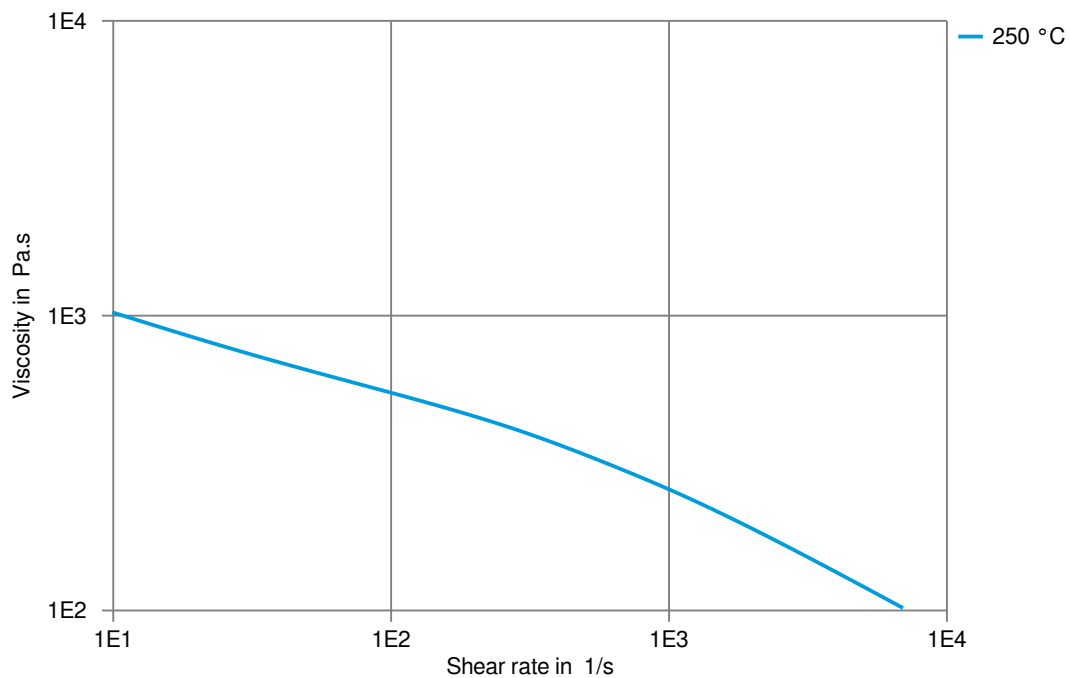
Additives	Flame retardant, Non-halogenated/Red phosphorous free flame retardant
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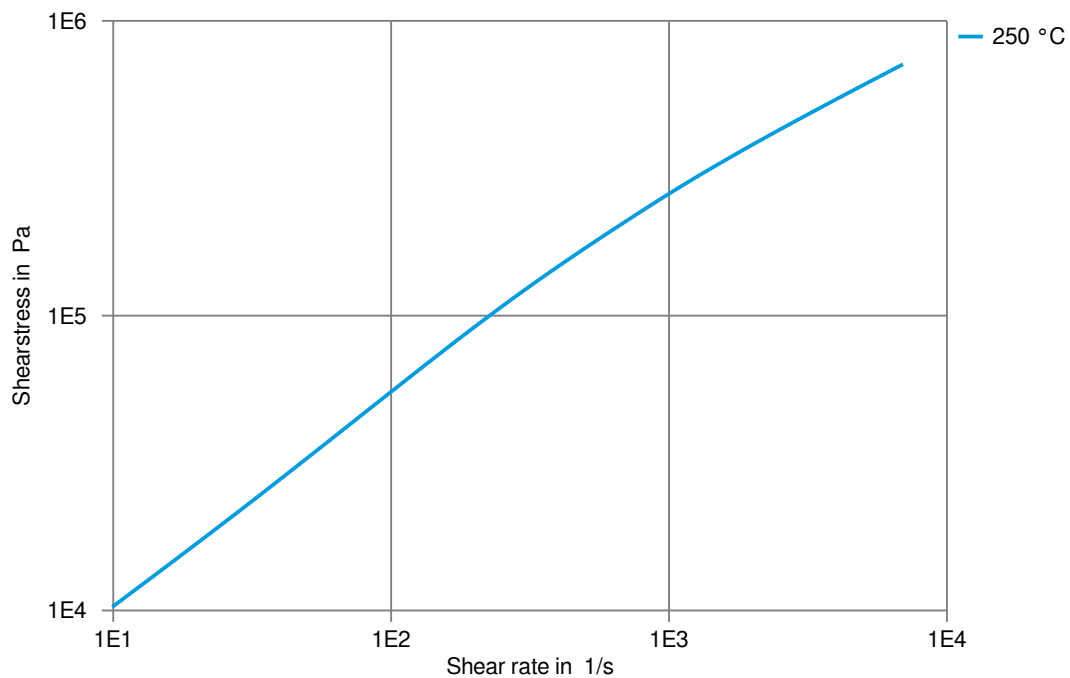
Viscosity-shear rate



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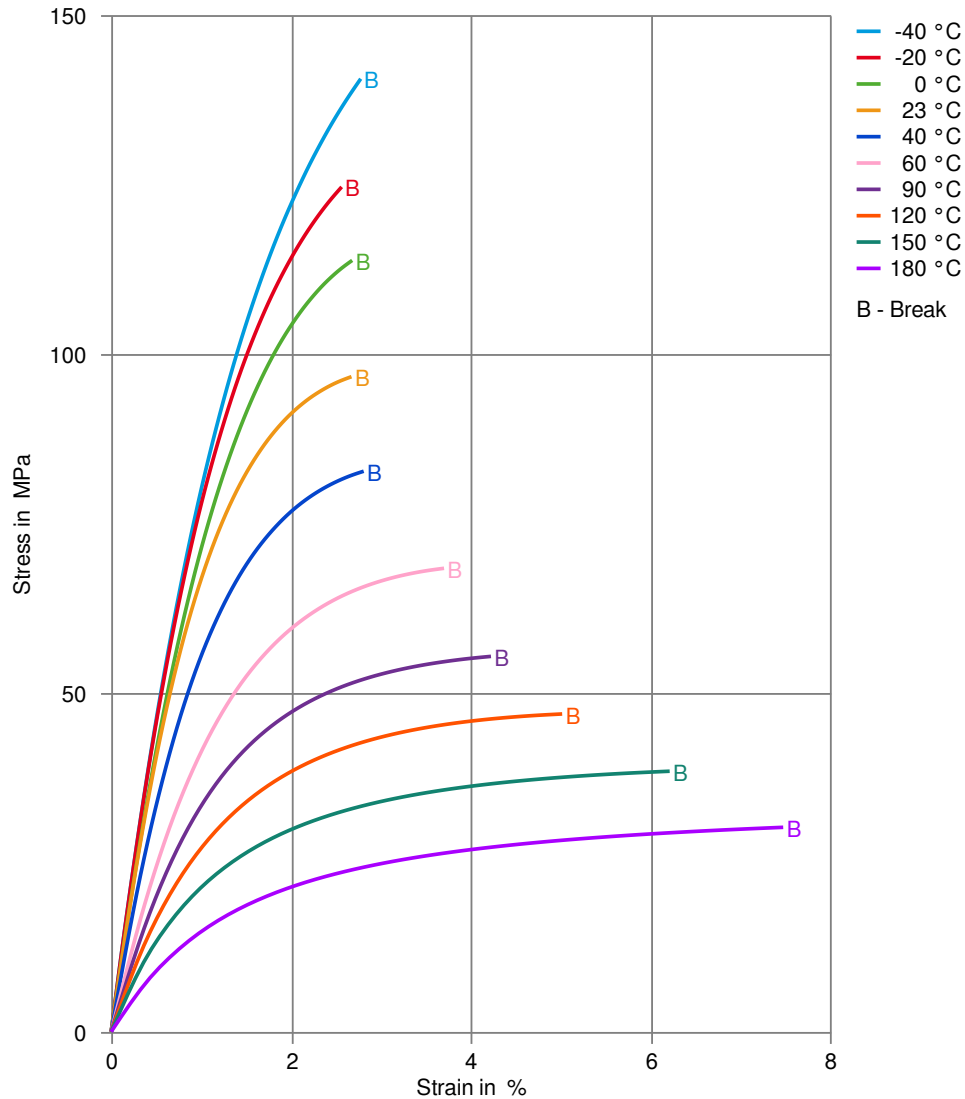
Shearstress-shear rate



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Stress-strain



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Secant modulus-strain

