

Crastin® FGS600F40 NC010

THERMOPLASTIC POLYESTER RESIN

Crastin® FGS600F40 NC010 is an unreinforced lubricated, low viscosity polybutylene terephthalate resin for injection moulding. It has been developed for consideration into applications such as parts for the food industry.

FOOD CONTACT

This product is manufactured according to Good Manufacturing Practice (GMP) principles and generally accepted in food contact applications in Europe and the USA when meeting applicable use conditions. For details, individual compliance statements are available from our representative.

Product information

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

Rheological properties

Melt volume-flow rate	33 cm ³ /10min	ISO 1133
Temperature	250 °C	
Load	2.16 kg	
Moulding shrinkage, parallel	1.6 %	ISO 294-4, 2577
Moulding shrinkage, normal	1.6 %	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	2400 MPa	ISO 527-1/-2
Yield stress, 50mm/min	55 MPa	ISO 527-1/-2
Yield strain, 50mm/min	4 %	ISO 527-1/-2
Nominal strain at break	30 %	ISO 527-1/-2
Tensile creep modulus, 1h	2600 MPa	ISO 899-1
Tensile creep modulus, 1000h	1800 MPa	ISO 899-1
Charpy impact strength, 23°C	N kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	N kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	4 kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	4 kJ/m ²	ISO 179/1eA
Poisson's ratio	0.38	

Thermal properties

Melting temperature, 10°C/min	223 °C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	55 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	50 °C	ISO 75-1/-2
Temp. of deflection under load, 1.8 MPa, annealed	60 °C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	115 °C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa, annealed	180 °C	ISO 75-1/-2
Vicat softening temperature, 50°C/h, 50N	175 °C	ISO 306
Coeff. of linear therm. expansion, parallel	110 E-6/K	ISO 11359-1/-2



Crastin® FGS600F40 NC010

THERMOPLASTIC POLYESTER RESIN

Coeff. of linear therm. expansion, normal	120 E-6/K	ISO 11359-1/-2
Thermal conductivity of melt	0.21 W/(m K)	Internal
Spec. heat capacity of melt	2110 J/(kg K)	Internal
RTI, electrical, 0.75mm	130 °C	UL 746B
RTI, electrical, 1.5mm	130 °C	UL 746B
RTI, electrical, 3mm	130 °C	UL 746B
RTI, electrical, 6mm	130 °C	UL 746B
RTI, impact, 0.75mm	115 °C	UL 746B
RTI, impact, 1.5mm	115 °C	UL 746B
RTI, impact, 3mm	115 °C	UL 746B
RTI, impact, 6mm	115 °C	UL 746B
RTI, strength, 0.75mm	120 °C	UL 746B
RTI, strength, 1.5mm	120 °C	UL 746B
RTI, strength, 3mm	120 °C	UL 746B
RTI, strength, 6mm	120 °C	UL 746B

Flammability

Burning Behav. at 1.5mm nom. thickn.	HB class	UL 94
Thickness tested	1.5 mm	UL 94
UL recognition	yes	UL 94
Burning Behav. at thickness h	HB class	UL 94
Thickness tested	3 mm	UL 94
UL recognition	yes	UL 94
Oxygen index	22 %	ISO 4589-1/-2
FMVSS Class	B	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	28 mm/min	ISO 3795 (FMVSS 302)

Electrical properties

Relative permittivity, 1MHz	3.2	IEC 62631-2-1
Dissipation factor, 100Hz	20 E-4	IEC 62631-2-1
Dissipation factor, 1MHz	200 E-4	IEC 62631-2-1
Volume resistivity	>1E13 Ohm.m	IEC 62631-3-1
Surface resistivity	1E12 Ohm	IEC 62631-3-2
Electric strength	26 kV/mm	IEC 60243-1
Comparative tracking index	600	IEC 60112

Other properties

Humidity absorption, 2mm	0.2 %	Sim. to ISO 62
Water absorption, 2mm	0.4 %	Sim. to ISO 62
Density	1310 kg/m³	ISO 1183
Density of melt	1110 kg/m³	Internal



Crastin® FGS600F40 NC010

THERMOPLASTIC POLYESTER RESIN

VDA Properties

Odour	3 class	VDA 270
Fogging, F-value (refraction)	95 %	ISO 6452
Fogging, G-value (condensate)	0.2 mg	ISO 6452

Injection

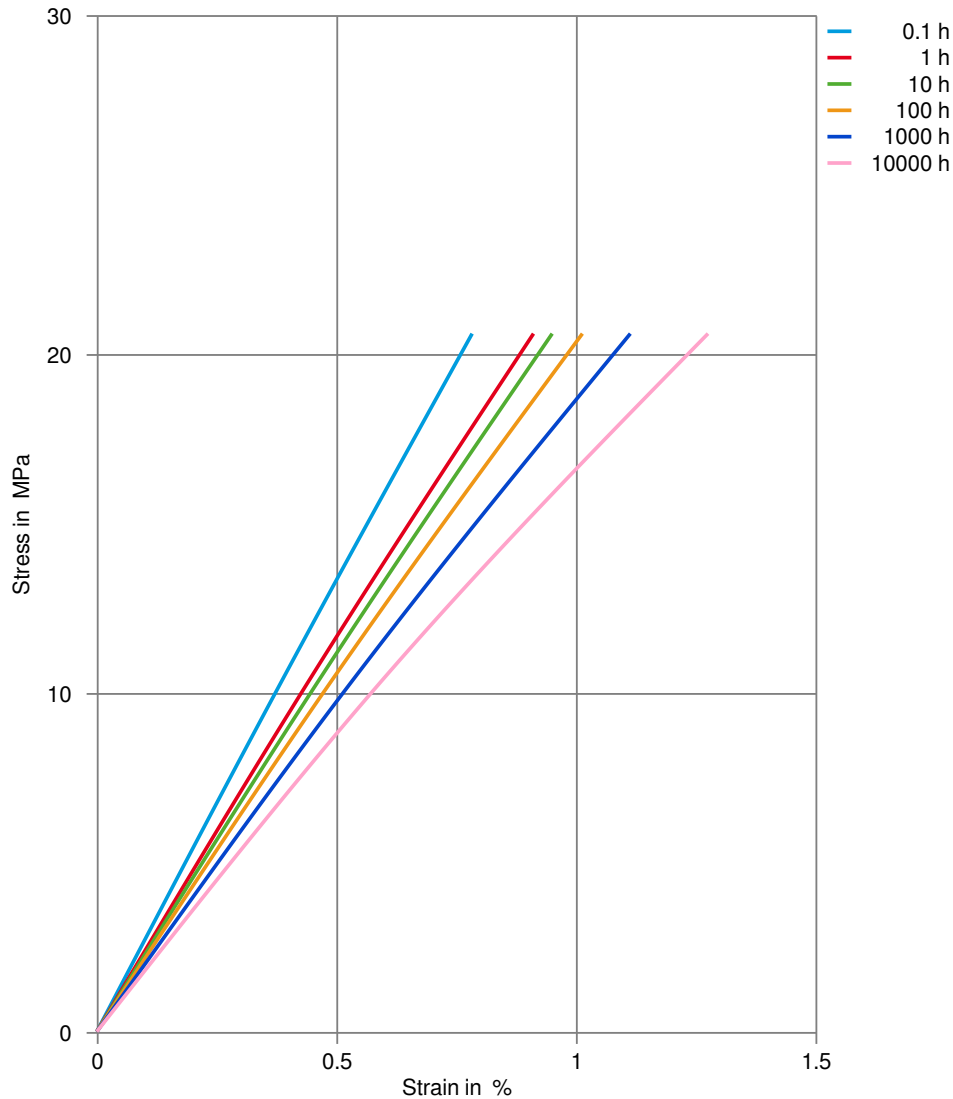
Drying Recommended	yes	
Drying Temperature	120 °C	
Drying Time, Dehumidified Dryer	2 - 4 h	
Processing Moisture Content	≤0.04 %	
Melt Temperature Optimum	250 °C	Internal
Min. melt temperature	240 °C	
Max. melt temperature	260 °C	
Mold Temperature Optimum	80 °C	
Min. mould temperature	30 °C	
Max. mould temperature	130 °C	
Hold pressure range	≥60 MPa	
Hold pressure time	4 s/mm	
Back pressure	As low as possible	
Ejection temperature	170 °C	Internal



Crastin® FGS600F40 NC010

THERMOPLASTIC POLYESTER RESIN

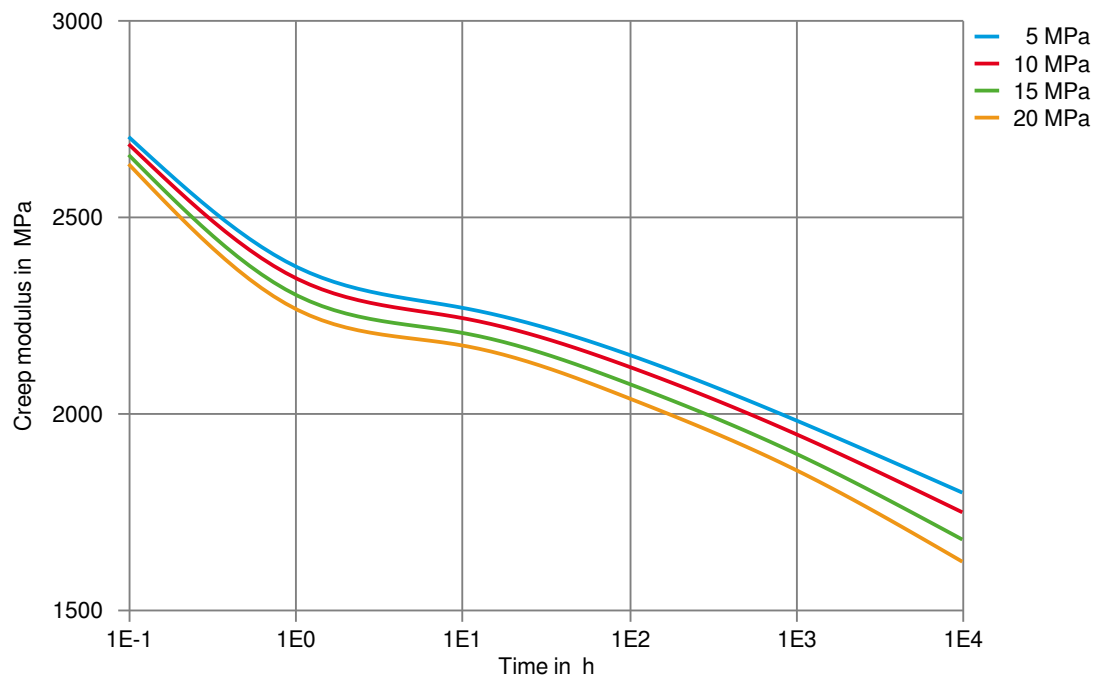
Stress-strain (isochronous) 23°C
(measured on Crastin® S600F40 NC010)



Crastin® FGS600F40 NC010

THERMOPLASTIC POLYESTER RESIN

Creep modulus-time 23°C
(measured on Crastin® S600F40 NC010)



Crastin® FGS600F40 NC010

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



Crastin® FGS600F40 NC010

THERMOPLASTIC POLYESTER RESIN

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).

