

Crastin® SK603 NC010

THERMOPLASTIC POLYESTER RESIN

Rheological properties

Moulding shrinkage, parallel	0.3 %	ISO 294-4, 2577
Moulding shrinkage, normal	1.1 %	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	7000 MPa	ISO 527-1/-2
Stress at break, 5mm/min	120 MPa	ISO 527-1/-2
Strain at break, 5mm/min	3.2 %	ISO 527-1/-2
Charpy impact strength, 23°C	60 kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	55 kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	9 kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	8 kJ/m ²	ISO 179/1eA
Poisson's ratio	0.35	

Thermal properties

Melting temperature, 10°C/min	224 °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
Temp. of deflection under load, 0.45 MPa	220 °C	ISO 75-1/-2

Flammability

FMVSS Class	B	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	28 mm/min	ISO 3795 (FMVSS 302)

Other properties

Humidity absorption, 2mm	0.15 %	Sim. to ISO 62
Water absorption, 2mm	0.4 %	Sim. to ISO 62
Density	1450 kg/m ³	ISO 1183

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	



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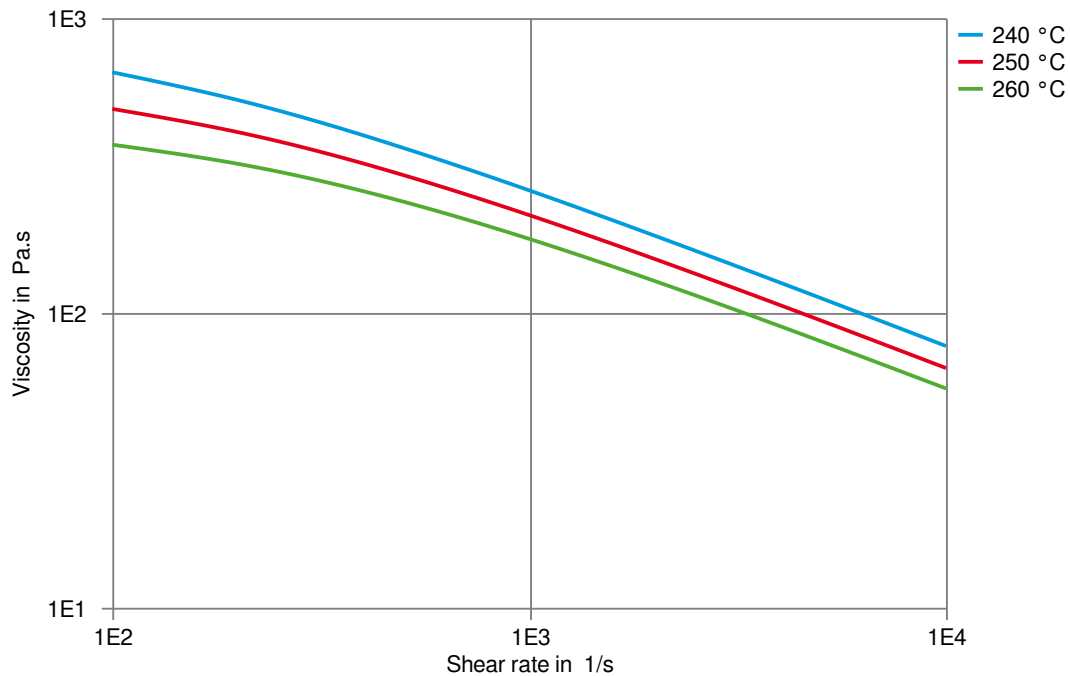
Back pressure

As low as MPa
possible
170 °C

Ejection temperature

Internal

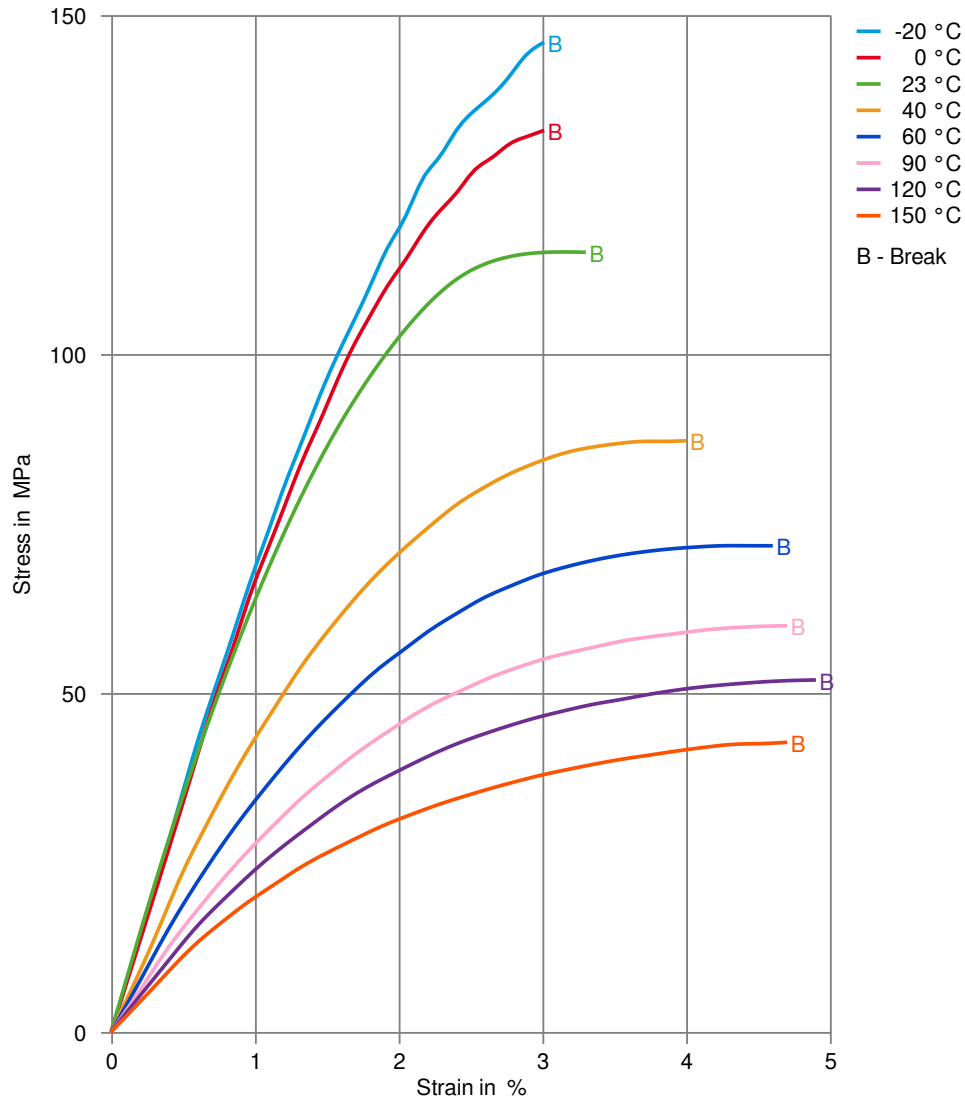
Viscosity-shear rate



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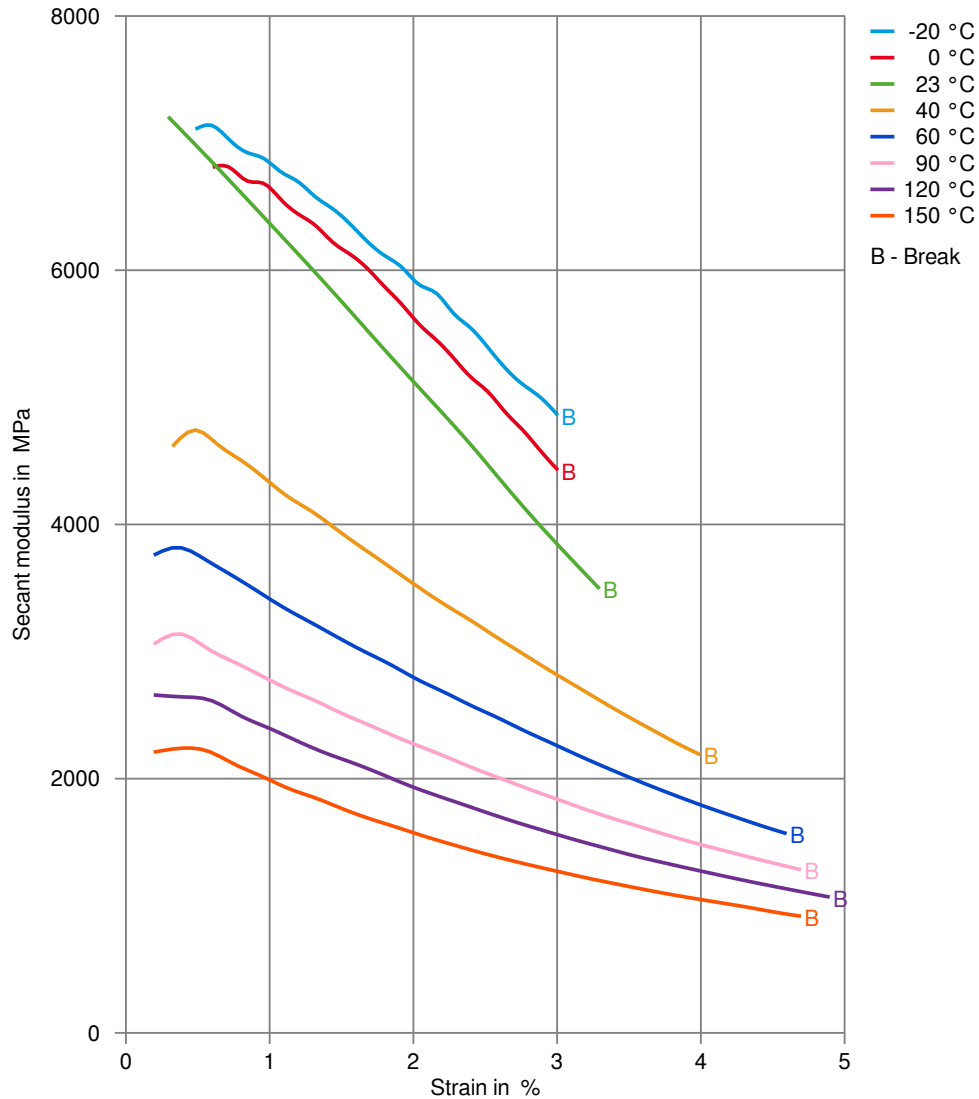
Stress-strain



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Secant modulus-strain



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Tensile modulus-temperature

