

Crastin® S600F10 NC010

THERMOPLASTIC POLYESTER RESIN

Common features of Crastin® thermoplastic polyester resin include mechanical and physical properties such as stiffness and toughness, heat resistance, friction and wear resistance, excellent surface finishes and good colourability. Crastin® thermoplastic polyester resin has excellent electrical insulation characteristics and high arc-resistant grades are available. Many flame retardant grades have UL recognition (class V-0). Crastin® thermoplastic polyester resin typically has high chemical and heat ageing resistance.

The good melt stability of Crastin® thermoplastic polyester resin normally enables the recycling of properly handled production waste.

If recycling is not possible, we recommend, as the preferred option, incineration with energy recovery (-24 kJ/g of base polymer) in appropriately equipped installations. For disposal, local regulations have to be observed.

Crastin® thermoplastic polyester resin typically is used in demanding applications in the electronics, electrical, automotive, mechanical engineering, chemical, domestic appliances and sporting goods industry.

Crastin® S600F10 NC010 is an unreinforced, lubricated, medium high viscosity polybutylene terephthalate resin for injection moulding.

Product information

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

Rheological properties

Melt volume-flow rate	10 cm ³ /10min	ISO 1133
Melt mass-flow rate	11 g/10min	ISO 1133
Temperature	250 °C	
Load	2.16 kg	
Melt mass-flow rate, Temperature	250 °C	
Melt mass-flow rate, Load	2.16 kg	
Intrinsic viscosity	1.17	ISO 307, 1157, 1628
Moulding shrinkage, parallel	1.7 %	ISO 294-4, 2577
Moulding shrinkage, normal	1.7 %	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	2600 MPa	ISO 527-1/-2
Yield stress, 50mm/min	57 MPa	ISO 527-1/-2
Yield strain, 50mm/min	4 %	ISO 527-1/-2
Nominal strain at break	>50 %	ISO 527-1/-2
Flexural Modulus	2400 MPa	ISO 178
Flexural Strength	84 MPa	ISO 178
Tensile creep modulus, 1h	2300 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	5 kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30 °C	4 kJ/m ²	ISO 179/1eA



Crastin® S600F10 NC010

THERMOPLASTIC POLYESTER RESIN

Izod notched impact strength, 23°C	5 kJ/m ²	ISO 180/1A
Izod notched impact strength, -30°C	5 kJ/m ²	ISO 180/1A
Izod impact strength, 23°C	N kJ/m ²	ISO 180/1U
Izod impact strength, -30°C	130 kJ/m ²	ISO 180/1U
Ball indentation hardness, H 358/30	139 MPa	ISO 2039-1
Poisson's ratio	0.38	

Thermal properties

Melting temperature, 10°C/min	224 °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
Ball pressure test	190 °C	IEC 60695-10-2
Coeff. of linear therm. expansion, parallel, -40-23°C	80 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, parallel	110 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, parallel, 55-160°C	190 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal, -40-23°C	90 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	120 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal, 55-160°C	200 E-6/K	ISO 11359-1/-2
Thermal conductivity of melt	0.21 W/(m K)	Internal
Spec. heat capacity of melt	2100 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



Crastin® S600F10 NC010

THERMOPLASTIC POLYESTER RESIN

Oxygen index	22 %	ISO 4589-1/-2
Glow Wire Flammability Index, 3mm	750 °C	IEC 60695-2-12
Glow Wire Ignition Temperature, 0.75mm	750 °C	IEC 60695-2-13
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, 2mm	750 °C	IEC 60695-2-13
Glow Wire Ignition Temperature, 3mm	725 °C	IEC 60695-2-13
FMVSS Class	SE	ISO 3795 (FMVSS 302)

Electrical properties

Relative permittivity, 100Hz	3.6	IEC 62631-2-1
Relative permittivity, 1MHz	3.2	IEC 62631-2-1
Dissipation factor, 100Hz	10.4 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	1E15 Ohm	IEC 62631-3-2
Electric strength	26 kV/mm	IEC 60243-1
Comparative tracking index	575	IEC 60112
Electric Strength, Short Time, 1mm	26 kV/mm	IEC 60243-1
Electric Strength, Short Time, 2mm	15 kV/mm	IEC 60243-1

Other properties

Humidity absorption, 2mm	0.2 %	Sim. to ISO 62
Water absorption, 2mm	0.5 %	Sim. to ISO 62
Density	1300 kg/m³	ISO 1183
Density of melt	1110 kg/m³	Internal

VDA Properties

Emission of organic compounds	145 µgC/g	VDA 277
Odour	3 class	VDA 270

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	



Crastin® S600F10 NC010

THERMOPLASTIC POLYESTER RESIN

Back pressure

As low as MPa
possible

Ejection temperature

170 °C

Internal

Extrusion

Drying Temperature

110 - 130 °C

Drying Time, Dehumidified Dryer

2 - 4 h

Processing Moisture Content

≤0.04 %

Melt Temperature Optimum

250 °C

Melt Temperature Range

240 - 260 °C

Characteristics

Additives

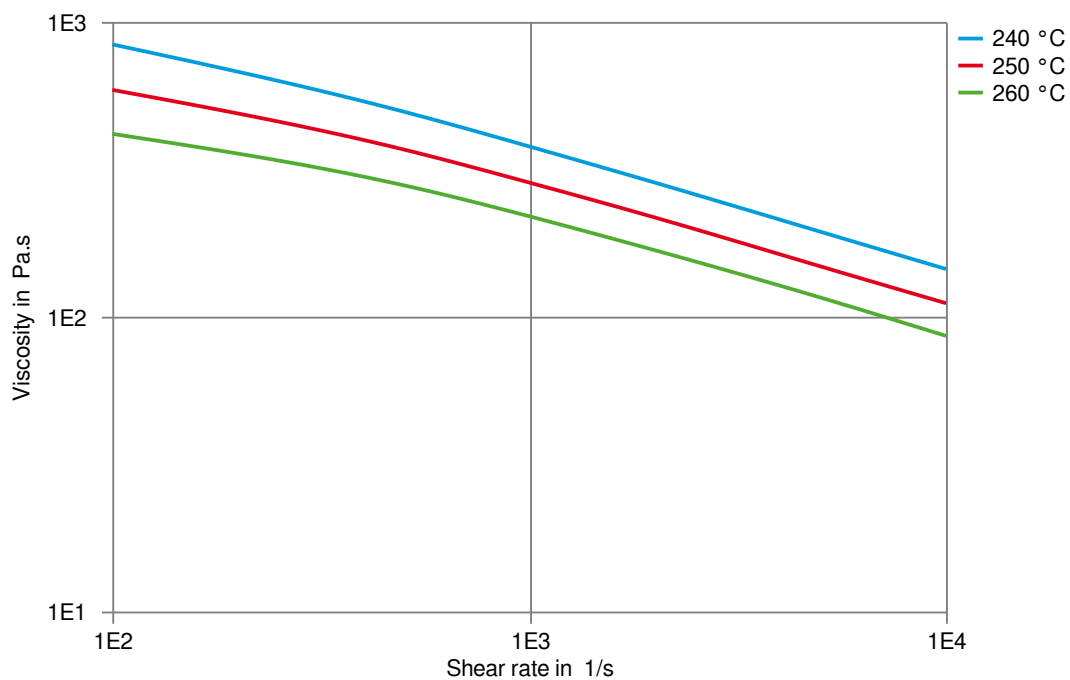
Release agent



Crastin® S600F10 NC010

THERMOPLASTIC POLYESTER RESIN

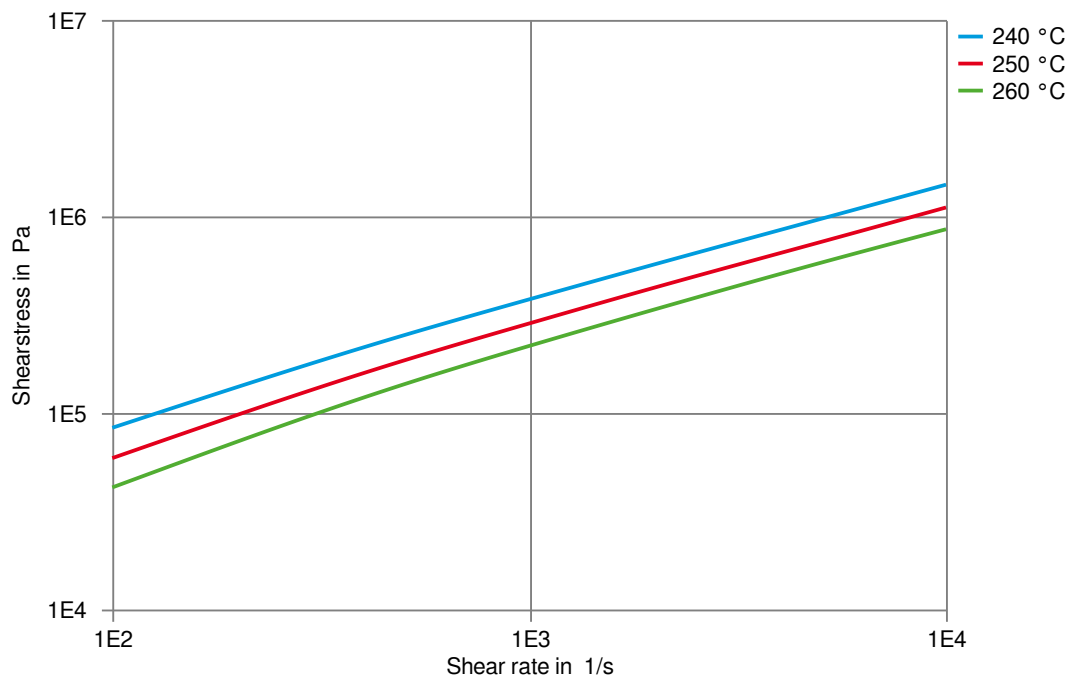
Viscosity-shear rate



Crastin® S600F10 NC010

THERMOPLASTIC POLYESTER RESIN

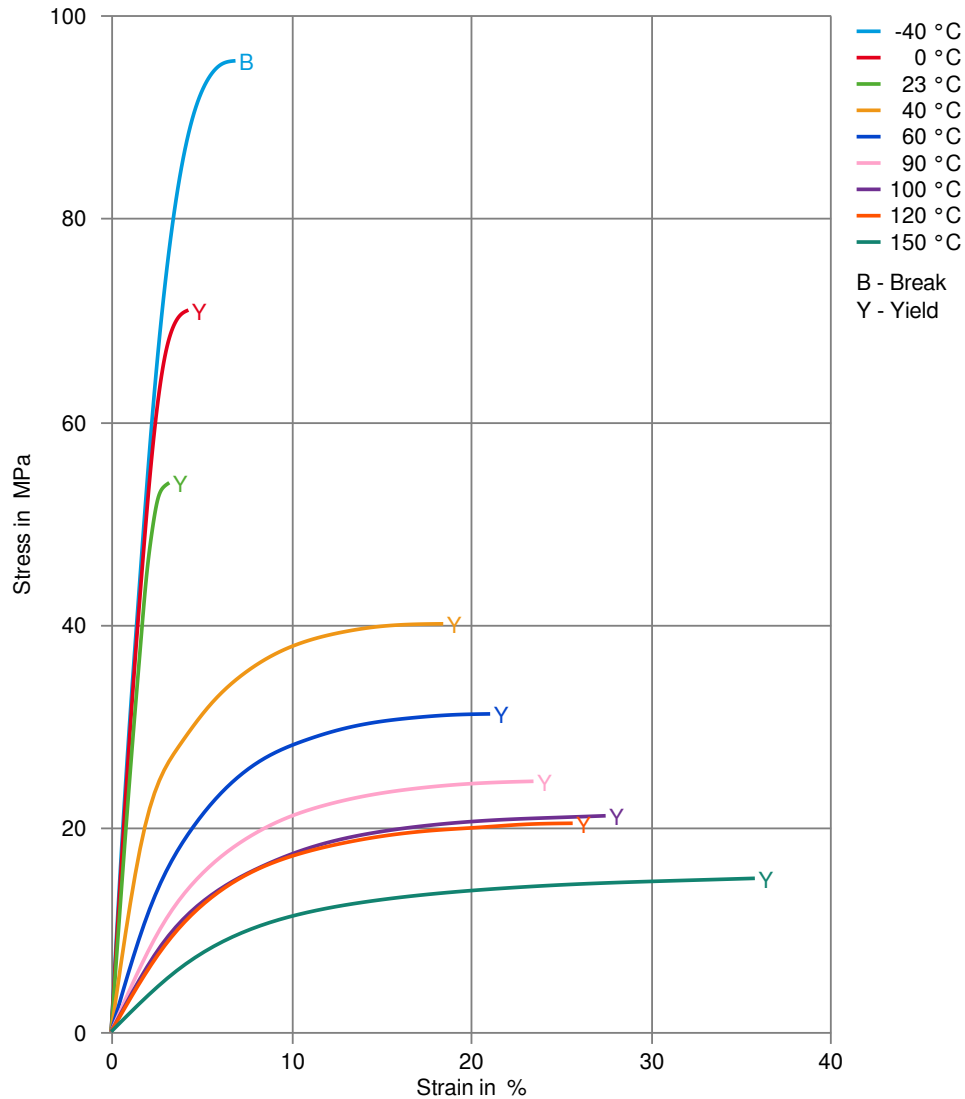
Shearstress-shear rate



Crastin® S600F10 NC010

THERMOPLASTIC POLYESTER RESIN

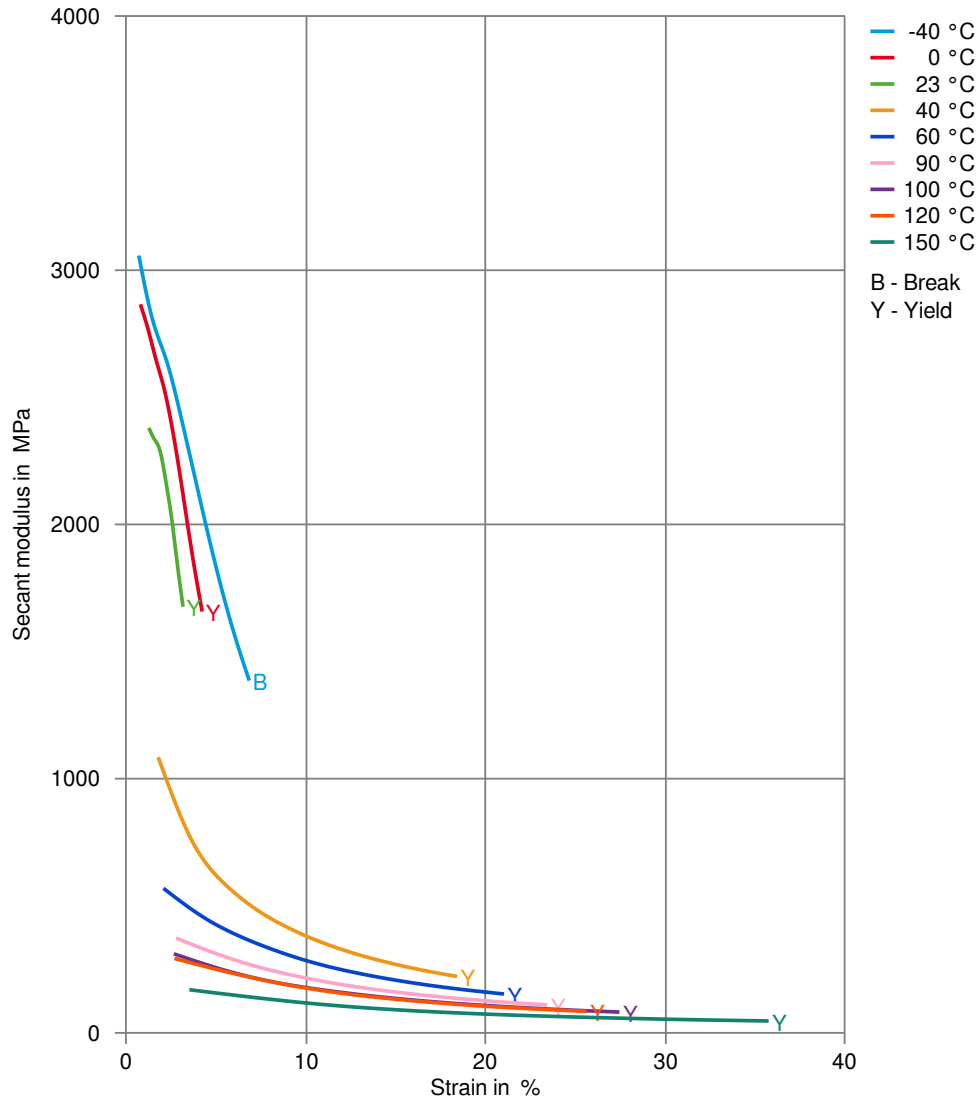
Stress-strain



Crastin® S600F10 NC010

THERMOPLASTIC POLYESTER RESIN

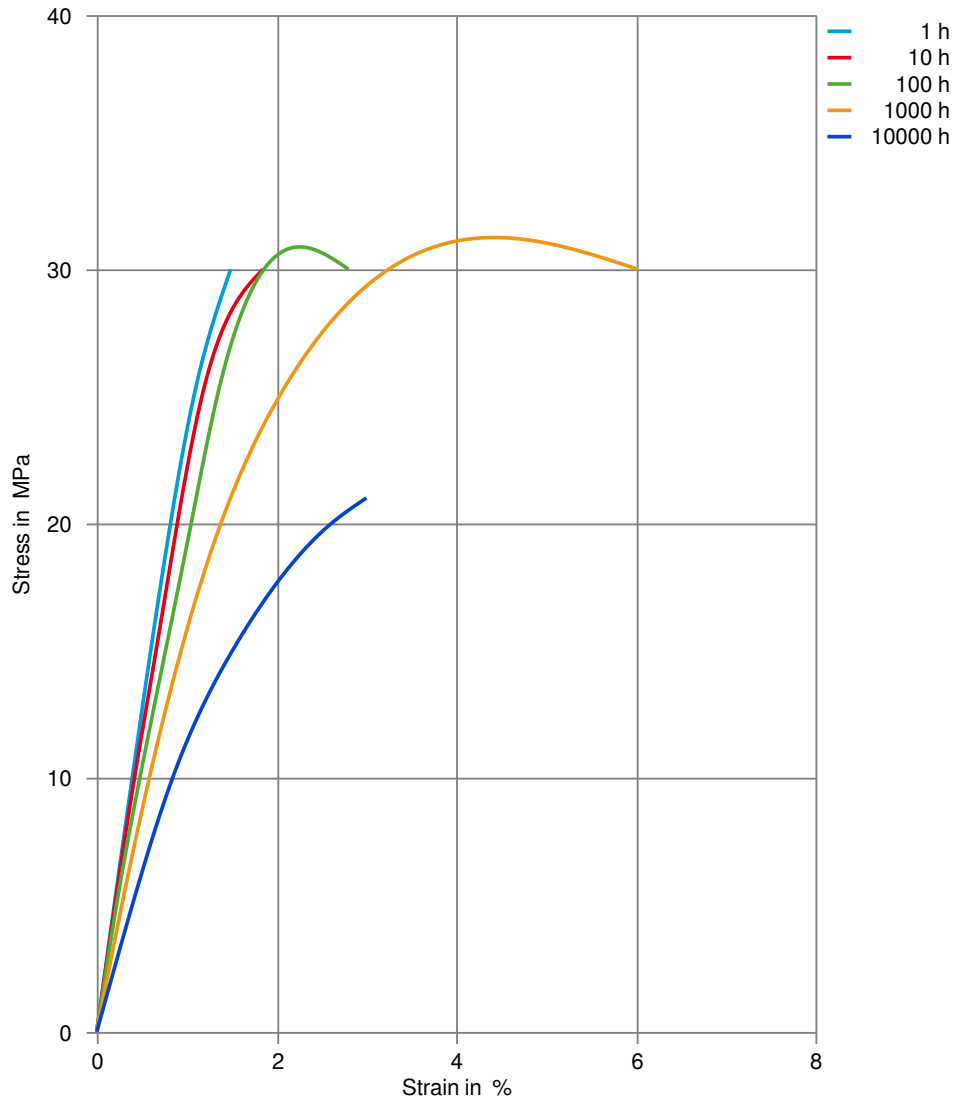
Secant modulus-strain



Crastin® S600F10 NC010

THERMOPLASTIC POLYESTER RESIN

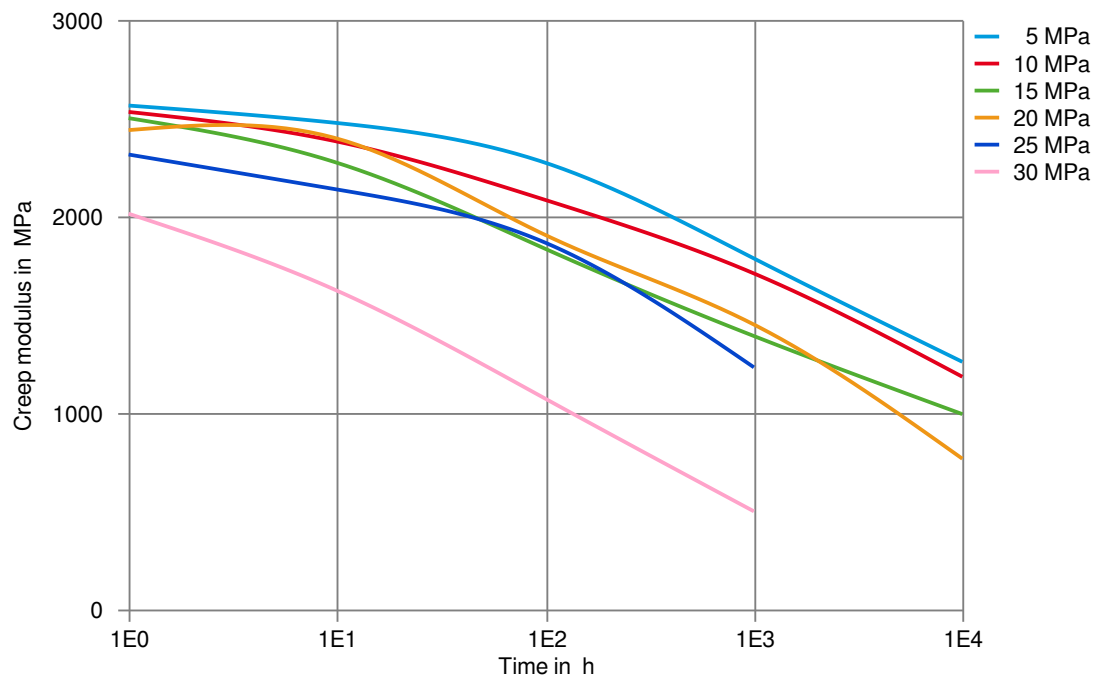
Stress-strain (isochronous) 23°C



Crastin® S600F10 NC010

THERMOPLASTIC POLYESTER RESIN

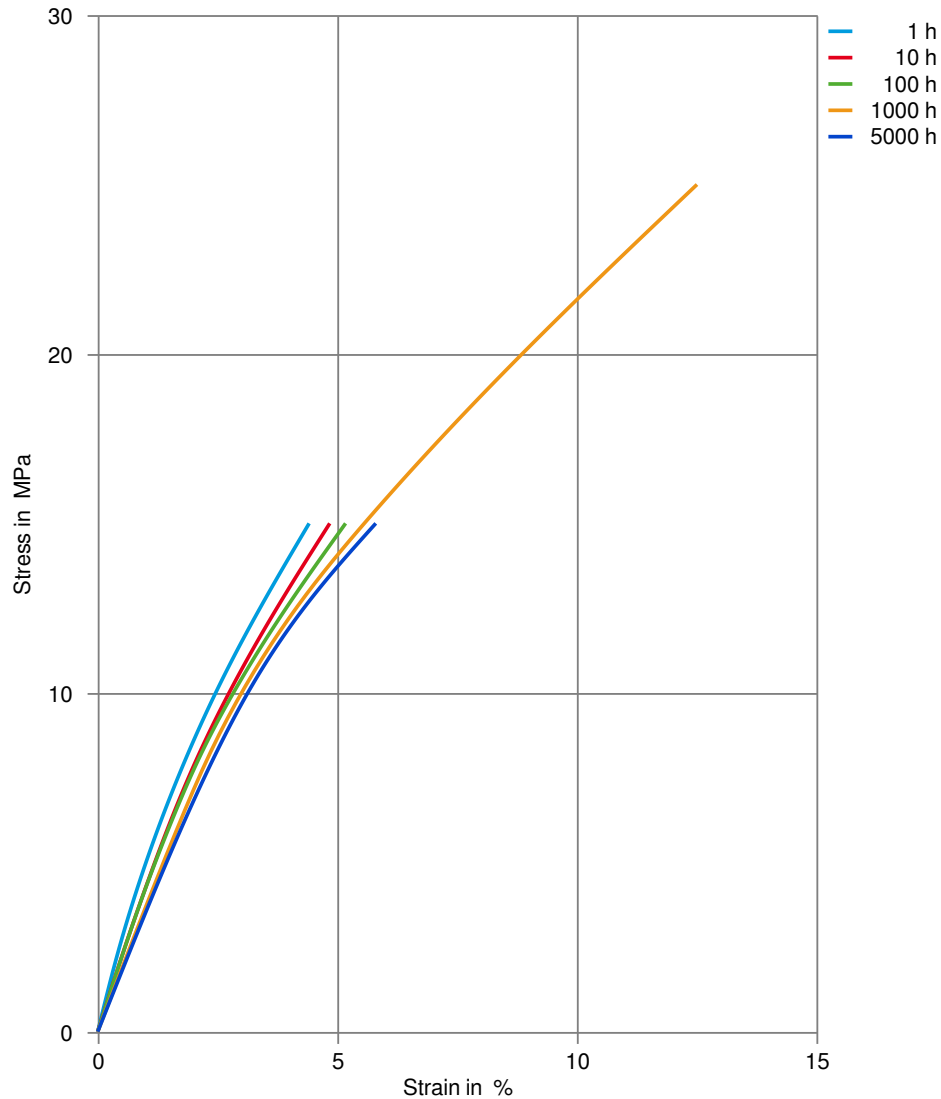
Creep modulus-time 23°C



Crastin® S600F10 NC010

THERMOPLASTIC POLYESTER RESIN

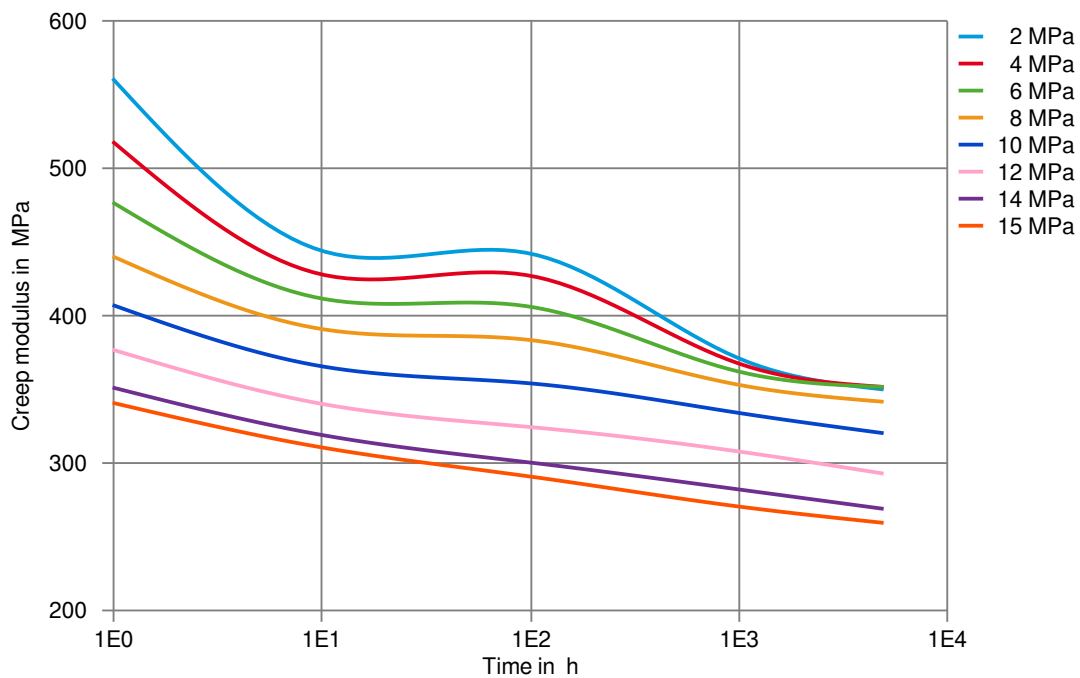
Stress-strain (isochronous) 60°C



Crastin® S600F10 NC010

THERMOPLASTIC POLYESTER RESIN

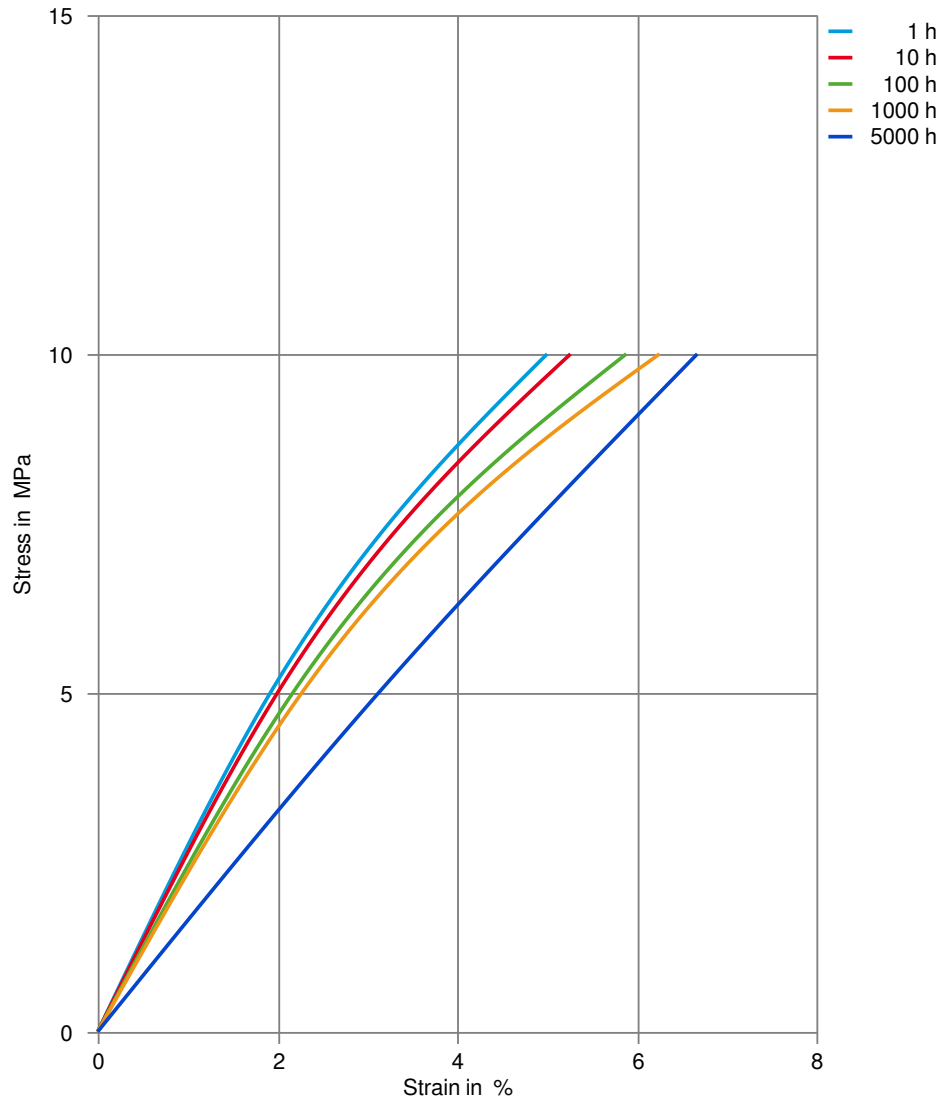
Creep modulus-time 60°C



Crastin® S600F10 NC010

THERMOPLASTIC POLYESTER RESIN

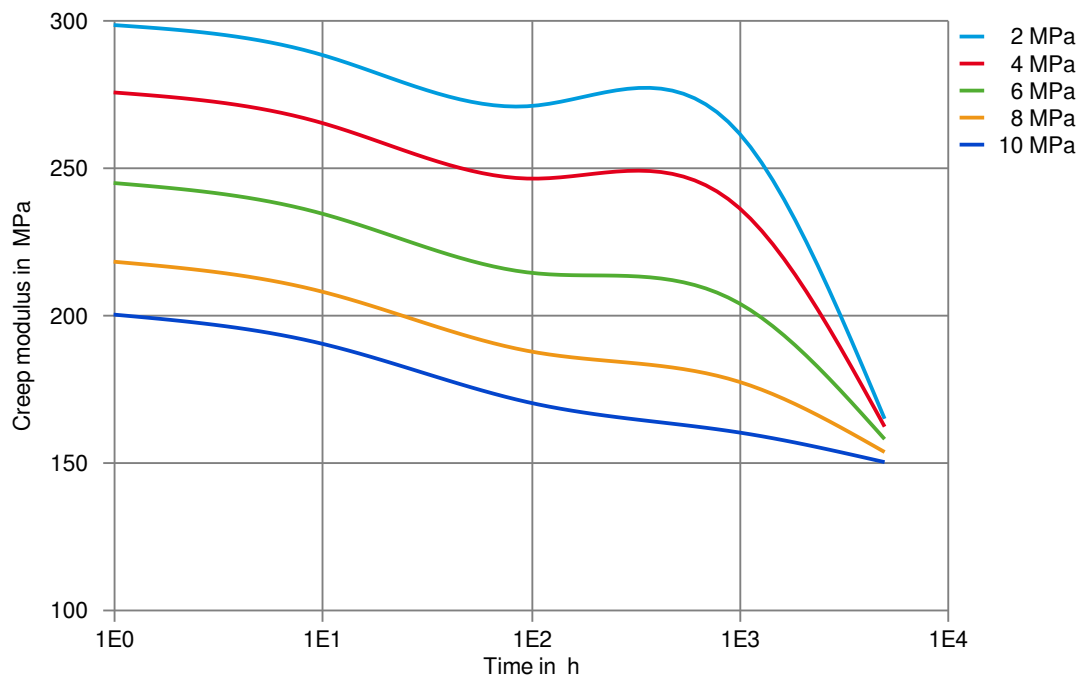
Stress-strain (isochronous) 110°C



Crastin® S600F10 NC010

THERMOPLASTIC POLYESTER RESIN

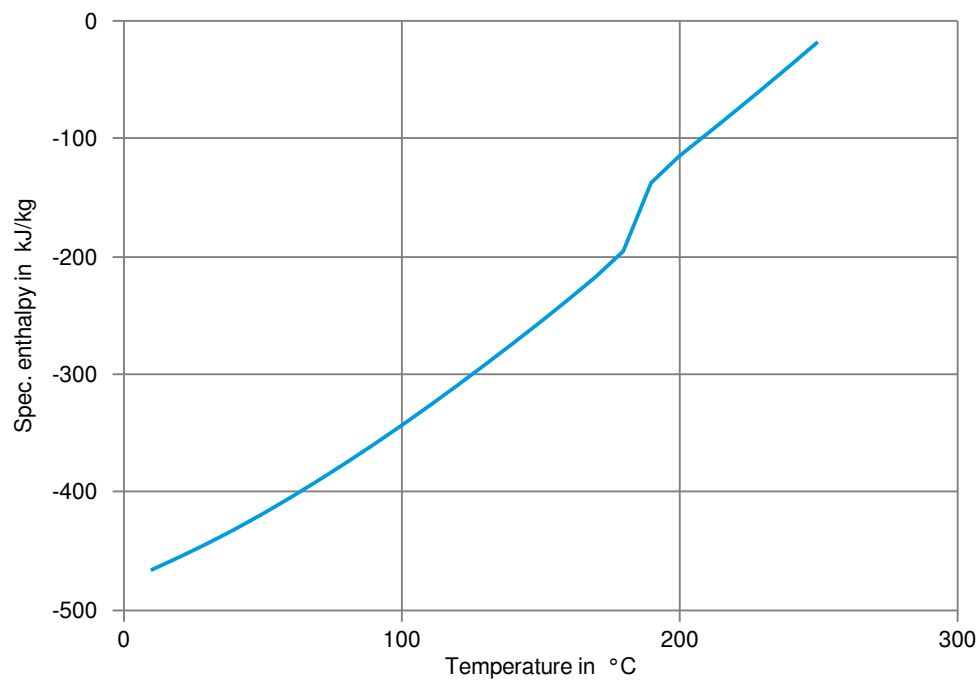
Creep modulus-time 110°C



Crastin® S600F10 NC010

THERMOPLASTIC POLYESTER RESIN

Spec. enthalpy/mass-temp. (DSC)



Crastin® S600F10 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® S600F10 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).

