

Crastin® SLW9230 BK218LT

Polybutylene Terephthalate

Celanese Corporation

Technical Data

Product Description

30% Glass Reinforced Polybutylene Terephthalate / Polyethylene Terephthalate Blend with Laser Transparency and Low Warp

General

Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight		
Features	• Hydrolysis Resistant	• Laser Weldable	• Low Warpage
Processing Method	• Extrusion	• Injection Molding	• Profile Extrusion
Part Marking Code (ISO 11469)	• >PBT+PET+SAN-(GF)30<		
Resin ID (ISO 1043)	• PBT+PET+SAN-(GF)30		

Physical	Nominal Value Unit	Test Method
Density	1.52 g/cm ³	ISO 1183
Molding Shrinkage		ISO 294-4
Across Flow	0.40 %	
Flow	0.20 %	

Mechanical	Nominal Value Unit	Test Method
Tensile Modulus	10700 MPa	ISO 527-1
Tensile Stress (Break)	160 MPa	ISO 527-2/5
Tensile Strain (Break)	2.5 %	ISO 527-2/5
Flexural Modulus	9600 MPa	ISO 178
Flexural Stress	230 MPa	ISO 178
Poisson's Ratio	0.34	

Impact	Nominal Value Unit	Test Method
Charpy Notched Impact Strength (23°C)	10 kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	63 kJ/m ²	ISO 179/1eU

Thermal	Nominal Value Unit	Test Method
Deflection Temperature Under Load		
0.45 MPa, Unannealed	219 °C	ISO 75-2/B
1.8 MPa, Unannealed	186 °C	ISO 75-2/A
Melting Temperature ²	255 °C	ISO 11357-3

Flammability	Nominal Value Unit	Test Method
Burning Rate ³		ISO 3795
1.00 mm	< 80 mm/min	
2.00 mm	< 80 mm/min	
FMVSS Flammability	B	FMVSS 302

Fill Analysis	Nominal Value Unit
Ejection Temperature	170 °C

Injection	Nominal Value Unit
Drying Temperature	120 °C
Drying Time - Desiccant Dryer	2.0 to 4.0 hr

+135-3858-6433 (GuangDong)
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+852-6957-5415 (HongKong)

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Injection	Nominal Value Unit
Suggested Max Moisture	< 0.040 %
Processing (Melt) Temp	255 to 275 °C
Melt Temperature, Optimum	265 °C
Mold Temperature	60 to 90 °C
Mold Temperature, Optimum	80 °C
Holding Pressure	> 60.0 MPa
Back Pressure	As low as possible
Drying Recommended	yes
Hold Pressure Time	3.00 s/mm