

Crastin® SK641FR NC010

THERMOPLASTIC POLYESTER RESIN

Crastin® SK641FR is a flame retardant, 10% glass reinforced polybutylene terephthalate moulding resin. It is recognized as UL94 V-0 at 1.5mm.

General Information

Resin Identification ISO 1043

Density ISO 1183

PBT-GF10FR(17)

1540 kg/m³

Drying

Drying Recommended

Drying Temperature

Drying Time*

Processing Moisture Content

yes

120 °C

2 - 4 h

≤0.04 %

Temperature settings

Melt Temperature Optimum

Min. melt temperature***

Max. melt temperature

Mold Temperature Optimum

Min. mould temperature

Max. mould temperature

250 °C

240 °C

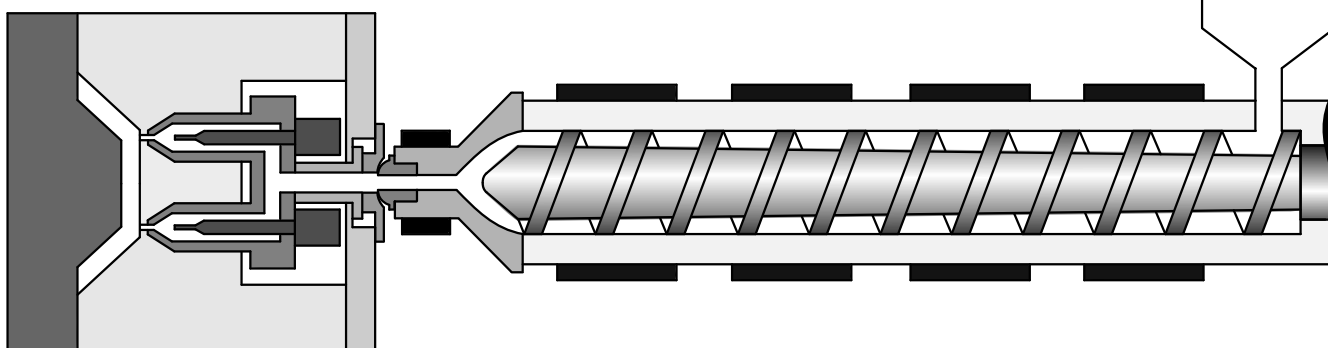
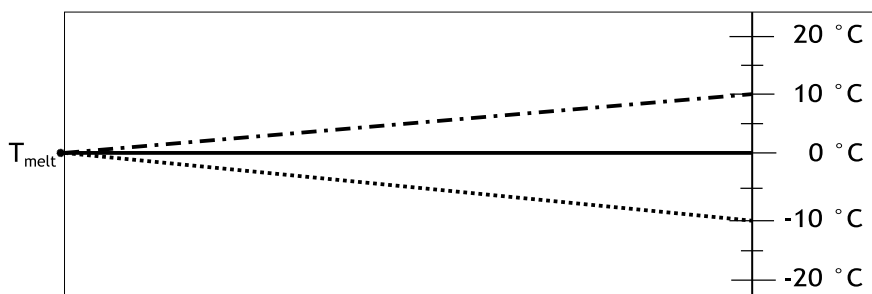
260 °C

80 °C

30 °C

130 °C

3 D (< 2 min) - - - - -
 2 D (2-4 min) —————
 1 D (4-6 min)



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Recommended general settings

Residence time - optimum range	2 - 4 min
Residence time - maximum	6 min
Hold pressure range	≥60 MPa
Hold Pressure Time	h ² +2 s
(h is the max. wall thickness of the part in mm)	
Back pressure	As low as possible

$$\text{Residence time} = \frac{8 \cdot \text{screw } \varnothing [\text{mm}] \cdot \text{cycle time [s]}}{60 \cdot \text{dosing stroke [mm]}}$$

Hot runner residence time not included in calculation

Special precautions

During molding, use proper protective equipment and adequate ventilation. Avoid fumes and limit the residence time and temperature of the resin in the machine.

Links for further information

Trouble Shooting Guide

For further information e.g. on Shrinkage, Hot runner systems, Venting, Gating, Drying and moisture measurement, Regrind, Purging, please refer to the detailed Molding Guide.

Footnotes:

- * Improper storage may lead to longer drying times
- *** Using melt temperature lower than recommended could create unmelt, leading to weak parts

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