



ISO 1043

ISO 11469

Crastin® 6129 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.

PBT

>PBT<

Crastin® 6129 is an unreinforced, high viscosity polybutylene terephthalate for extrusion and injection moulding.

Product information

Resin Identification

Part Marking Code

Rheological properties			
Melt volume-flow rate	9	cm ³ /10min	ISO 1133
Temperature	250	°C	
Load	2.16	kg	
Melt mass-flow rate	10	g/10min	ISO 1133
Melt mass-flow rate, Temperature	250	°C	
Melt mass-flow rate, Load	2.16	kg	
Viscosity number	150	cm ³ /g	ISO 307, 1628
Intrinsic viscosity	1.2		ISO 307, 1628
Moulding shrinkage, parallel	1.7	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.5	%	ISO 294-4, 2577
Postmoulding shrinkage, normal, 48h at 80°C	0.6	%	ISO 294-4
Postmoulding shrinkage, parallel, 48h at 80°C	0.3	%	ISO 294-4

Typical mechanical properties

Tensile modulus	2600	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	58	MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	5	%	ISO 527-1/-2
Nominal strain at break	>50	%	ISO 527-1/-2
Tensile strain at break, 50mm/min	200	%	ISO 527-1/-2
Flexural modulus	2400	MPa	ISO 178
Flexural strength	85	MPa	ISO 178
Tensile creep modulus, 1h	2500	MPa	ISO 899-1
Tensile creep modulus, 1000h	1800	MPa	ISO 899-1
Charpy impact strength, 23°C	N	kJ/m²	ISO 179/1eU
Charpy impact strength, -30°C	N	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	5.5	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	4	kJ/m²	ISO 179/1eA
Ball indentation hardness, H 961/30	139	MPa	ISO 2039-1

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Poisson's ratio	0.38		
Thermal properties			
Melting temperature, 10 ° C/min	225	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min		°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	50	°C	ISO 75-1/-2
Temperature of deflection under load, 1.8 MPa,	60	°C	ISO 75-1/-2
annealed			
Temperature of deflection under load, 0.45 MPa	115	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa,	180	°C	ISO 75-1/-2
annealed			
Vicat softening temperature, 50°C/h 50N	175		ISO 306
Vicat softening temperature, 50°C/h 10N	215		ISO 306
Coefficient of linear thermal expansion	130	E-6/K	ISO 11359-1/-2
(CLTE), parallel			
Coefficient of linear thermal expansion (CLTE),	130	E-6/K	ISO 11359-1/-2
normal			100
Thermal conductivity of melt		W/(m K)	ISO 22007-2
Specific heat capacity of melt		J/(kg K)	ISO 22007-4
RTI, electrical, 1.5mm		°C	UL 746B
RTI, electrical, 3.0mm		°C	UL 746B
RTI, impact, 1.5mm		°C	UL 746B
RTI, impact, 3.0mm		°C	UL 746B
RTI, strength, 1.5mm RTI, strength, 3.0mm		°C	UL 746B UL 746B
n i i, suengui, s.oniin	75	C	OL 740B
Flammability			
Burning Behav. at 1.5mm nom. thickn.		class	IEC 60695-11-10
Thickness tested	1.5	mm	IEC 60695-11-10
UL recognition	yes		UL 94
Burning Behav. at thickness h		class	IEC 60695-11-10
Thickness tested		mm	IEC 60695-11-10
UL recognition	yes		UL 94
Oxygen index	22		ISO 4589-1/-2
Glow Wire Flammability Index, 1.5mm	960		IEC 60695-2-12
Glow Wire Flammability Index, 3.0mm	850		IEC 60695-2-12
Glow Wire Ignition Temperature, 0.75mm	825	_	IEC 60695-2-13
Glow Wire Ignition Temperature, 0.4mm	825		IEC 60695-2-12
Glow Wire Ignition Temperature, 1.0mm	825		IEC 60695-2-13
Glow Wire Ignition Temperature, 1.5mm	825		IEC 60695-2-13
Glow Wire Ignition Temperature, 2.0mm Glow Wire Ignition Temperature, 3.0mm	825 825		IEC 60695-2-13
FMVSS Class			IEC 60695-2-13
Burning rate, Thickness 1 mm	B 21	mm/min	ISO 3795 (FMVSS 302) ISO 3795 (FMVSS 302)
Hot Wire Ignition, 1.5mm	15		UL 746A
Hot Wire Ignition, 3mm	30		UL 746A
Hot Wile Ightton, offin	30	3	OL /40A

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Electrical properties

Relative permittivity, 1MHz	3.2	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
Electric Strength, Short Time, 2mm	15 kV/mm	IEC 60243-1

Physical/Other properties

Humidity absorption, 2mm	0.2 %	Sim. to ISO 62
Water absorption, 2mm	0.4 %	Sim. to ISO 62
Density	1320 kg/m ³	ISO 1183
Density of melt	1120 kg/m³	

VDA Properties

Emission of organic compounds 150 μgC/g VDA 277

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
Min. melt temperature	240	°C
Max. melt temperature	260	°C
Mold Temperature Optimum	80	°C
Min. mould temperature	60	°C
Max. mould temperature	130	°C
Hold pressure range	≥60	MPa
Hold pressure time	4	s/mm
Back pressure	As low as	MPa
	possible	
Ejection temperature	170	°C

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

Processing Injection Moulding, Extrusion, Sheet Extrusion, Other Extrusion, Coatable

Delivery form Pellets

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THERMOPLASTIC POLYESTER RESIN

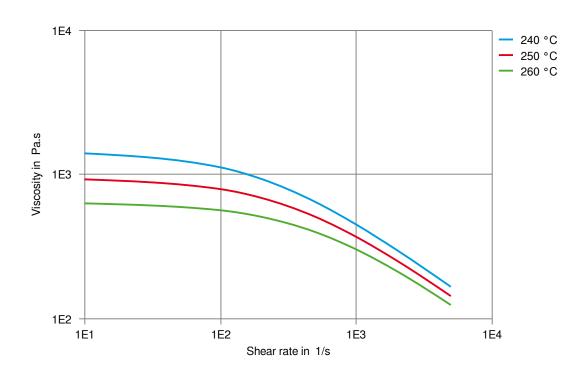
Additional information

Injection molding

To minimize the volatile content in the final product, dry the resin to ≤0.01% water content. In injection molding, use the lowest possible melt temperature (recommended 240 °C) and shortest feasible residence time (recommended 2-3 minutes). Store the parts in a ventilated, clean area before use. If assistance is needed please contact your Celanese account representative.

These recommendations are based on internal Celanese testing. For drying and injection molding conditions outside the above parameters, customer must test for and verify suitably low volatiles emissions on molded articles to confirm the final product is suitably pure for its intended use.

Viscosity-shear rate



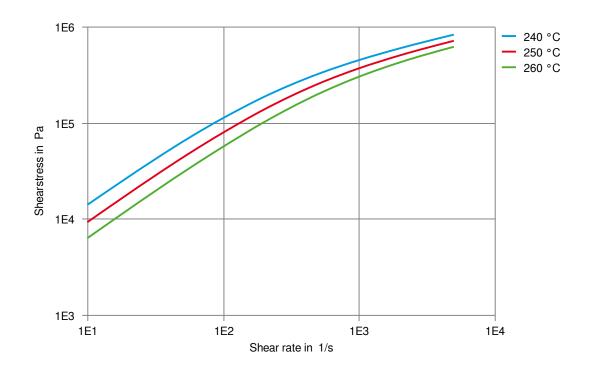
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Shearstress-shear rate



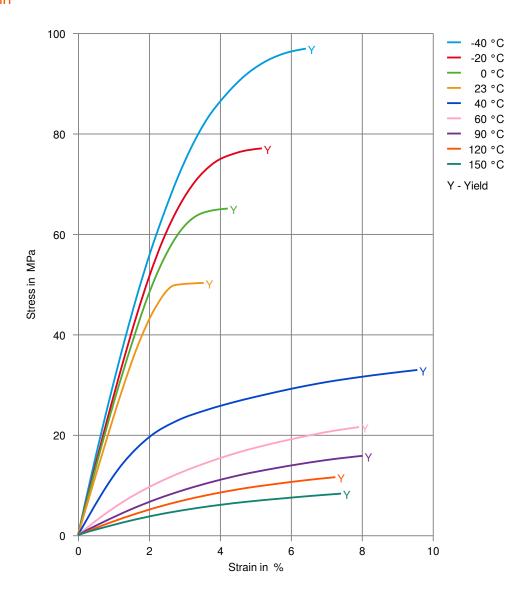
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Stress-strain



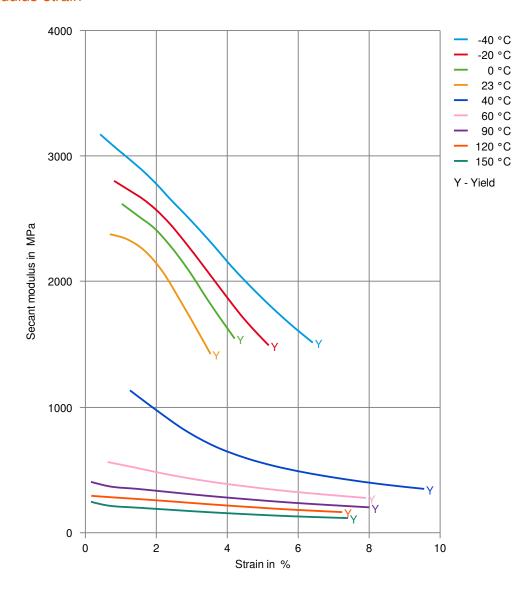
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Secant modulus-strain



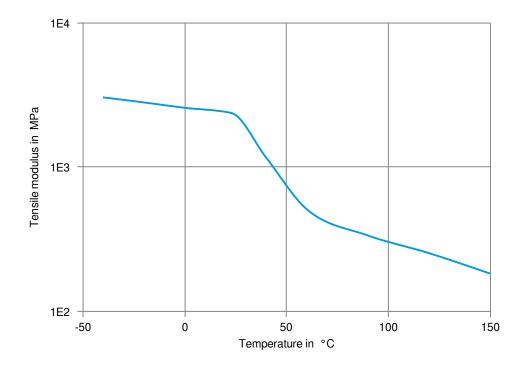
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Tensile modulus-temperature



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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
- X Hydrochloric Acid (36% by mass), 23°C
- X Nitric Acid (40% by mass), 23°C
- X Sulfuric Acid (38% by mass), 23°C
- X Sulfuric Acid (5% by mass), 23°C
- X Chromic Acid solution (40% by mass), 23°C

Bases

- X 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
- X SAE 10W40 multigrade motor oil, 130°C
- X SAE 80/90 hypoid-gear oil, 130°C
- ✓ Insulating Oil, 23°C

Standard Fuels

- X ISO 1817 Liquid 1 E5, 60°C
- ★ ISO 1817 Liquid 2 M15E4, 60°C
- X ISO 1817 Liquid 3 M3E7, 60°C
- X 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

Salt solutions

- ✓ Sodium Chloride solution (10% by mass), 23°C
- ✓ Sodium Hypochlorite solution (10% by mass), 23°C

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- ✓ 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
- X Hydrogen peroxide, 23°C
- X 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
- X 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).

x 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).

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Revised: 2025-04-21 Source: Celanese Materials Database

NOTICE TO USERS: Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colourants or other additives may processing conditions and environmental exposure. Other than those products expressly identified as medical grade (including by MT® product designation or otherwise), Celanese's products are not intended for use in medical or dental implants. Regardless of any such product designation, any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use. To the best of our knowledge, the information contained in this publication is accurate; however, we do not assume any liability whatsoever for the accuracy and completeness of such information. The information contained in this publication should not be construed as a promise or guarantee of specific properties of our products. It is the sole responsibility of the users to investigate whether any existing patents are infringed by the use of the materials mentioned in this publication. Moreover, there is a need to reduce human exposure to many materials to the lowest practical limits in view of possible adverse effects. To the extent that any hazards may have been mentioned in this publication, we neither suggest nor guarantee that such hazards are the only ones that exist. We recommend that persons intending to rely on any recommendation or to use any equipment, processing technique or material mentioned in this publication should satisfy themselves that they can meet all applicable safety and health standards. We strongly recommend that users

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