

Crastin® 6231 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® 6231 NC010 is an unreinforced, low viscosity polybutylene terephthalate resin for extrusion and injection moulding.

Product information

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

Rheological properties

Melt volume-flow rate	43 ^[DS] cm ³ /10min	ISO 1133
Temperature	250 °C	
Load	2.16 kg	
Melt mass-flow rate	48 g/10min	ISO 1133
Melt mass-flow rate, Temperature	250 °C	
Melt mass-flow rate, Load	2.16 kg	
Viscosity number	110 ^[DS] cm ³ /g	ISO 307, 1628
Intrinsic viscosity	0.9 ^[DS]	ISO 307, 1628
Moulding shrinkage, parallel	1.6 ^[DS] %	ISO 294-4, 2577
Moulding shrinkage, normal	1.6 ^[DS] %	ISO 294-4, 2577

[DS]: Derived from similar grade

Typical mechanical properties

Tensile modulus	2500 MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	58 MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	4 %	ISO 527-1/-2
Tensile strain at break, 50mm/min	65 %	ISO 527-1/-2
Charpy notched impact strength, 23 °C	3 kJ/m ²	ISO 179/1eA
Poisson's ratio	0.38	

Thermal properties

Melting temperature, 10 °C/min	225 °C	ISO 11357-1/-3
Glass transition temperature, 10 °C/min	55 °C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	50 °C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	115 °C	ISO 75-1/-2

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Physical/Other properties

Humidity absorption, 2mm	0.2 ^[DS] %	Sim. to ISO 62
Water absorption, 2mm	0.4 ^[DS] %	Sim. to ISO 62
Density	1300 kg/m ³	ISO 1183
Density of melt	1110 ^[DS] kg/m ³	

[DS]: Derived from similar grade

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 possible MPa
Ejection temperature	170 °C

Extrusion

Drying Temperature	110 - 130 °C
Drying Time, Dehumidified Dryer	2 - 4 h
Processing Moisture Content	≤0.04 %
Melt Temperature Range	240 - 260 °C

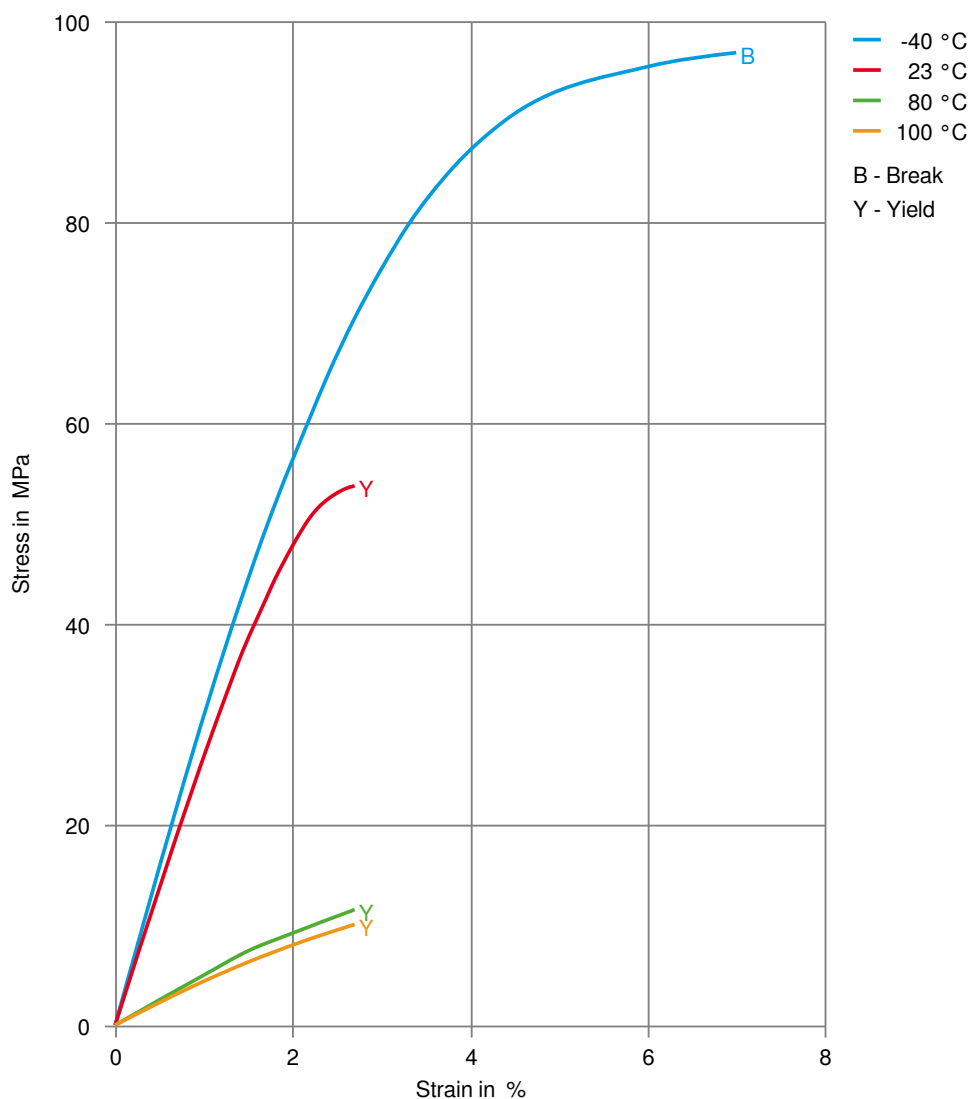
Characteristics

Processing	Injection Moulding, Film Extrusion, Extrusion, Sheet Extrusion, Other Extrusion, Coatable, Casting
Delivery form	Pellets

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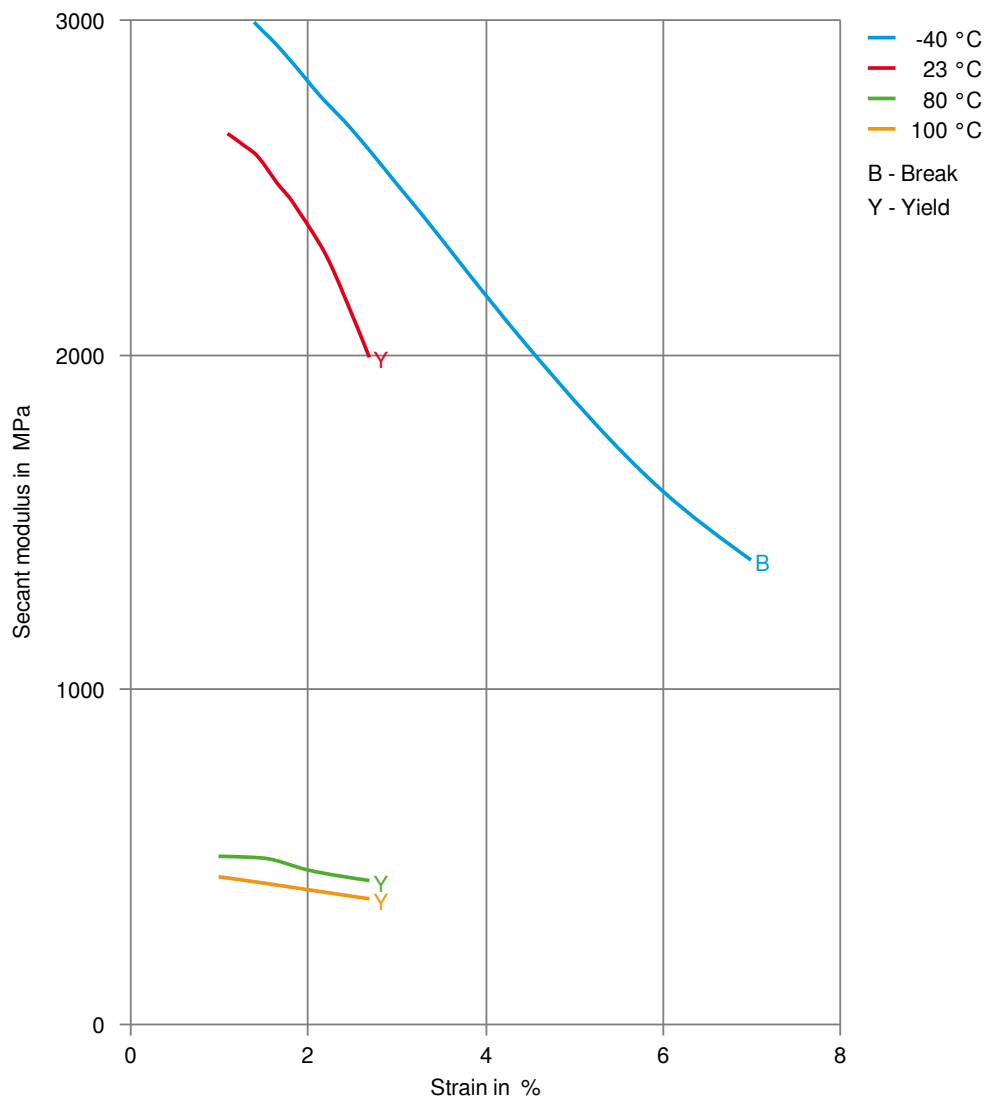
Stress-strain
(measured on Crastin® S600F40 NC010)



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THERMOPLASTIC POLYESTER RESIN

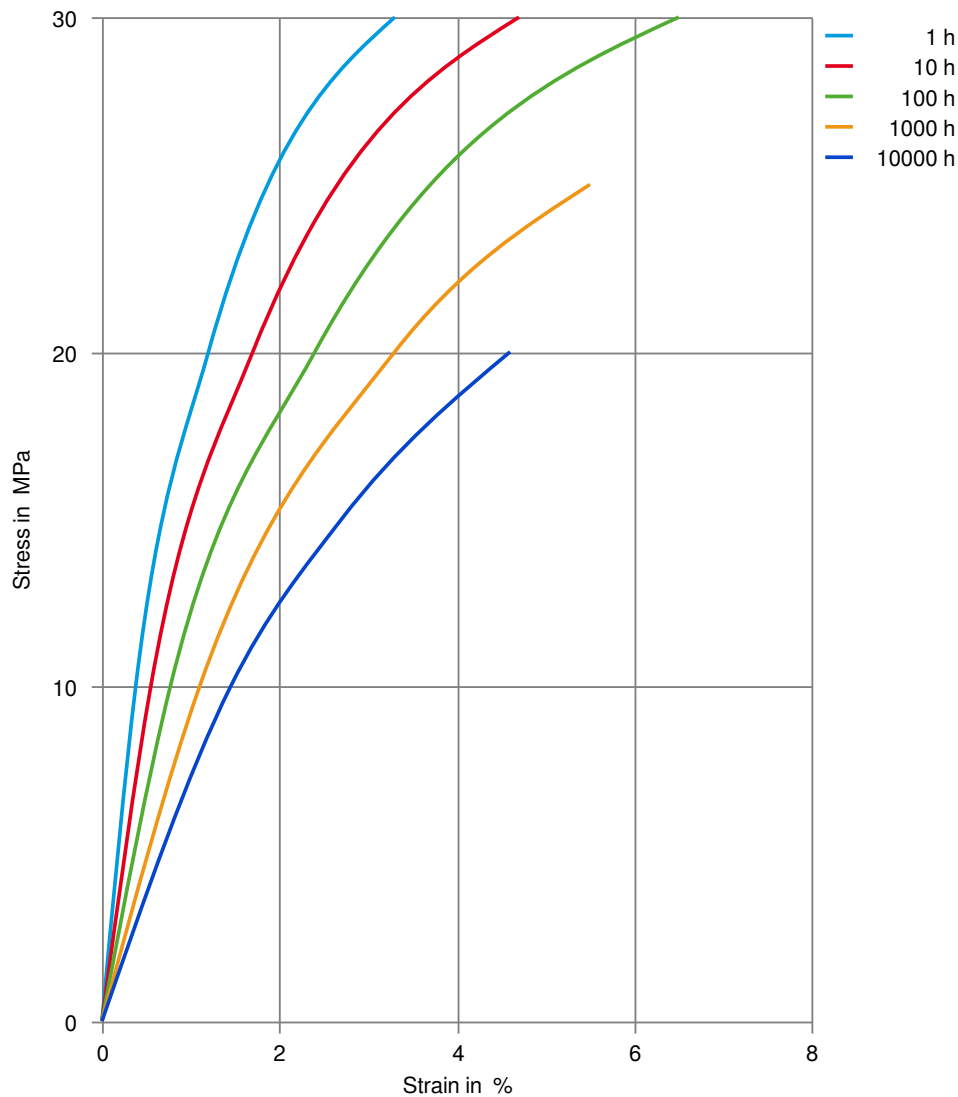
Secant modulus-strain
(measured on Crastin® S600F40 NC010)



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THERMOPLASTIC POLYESTER RESIN

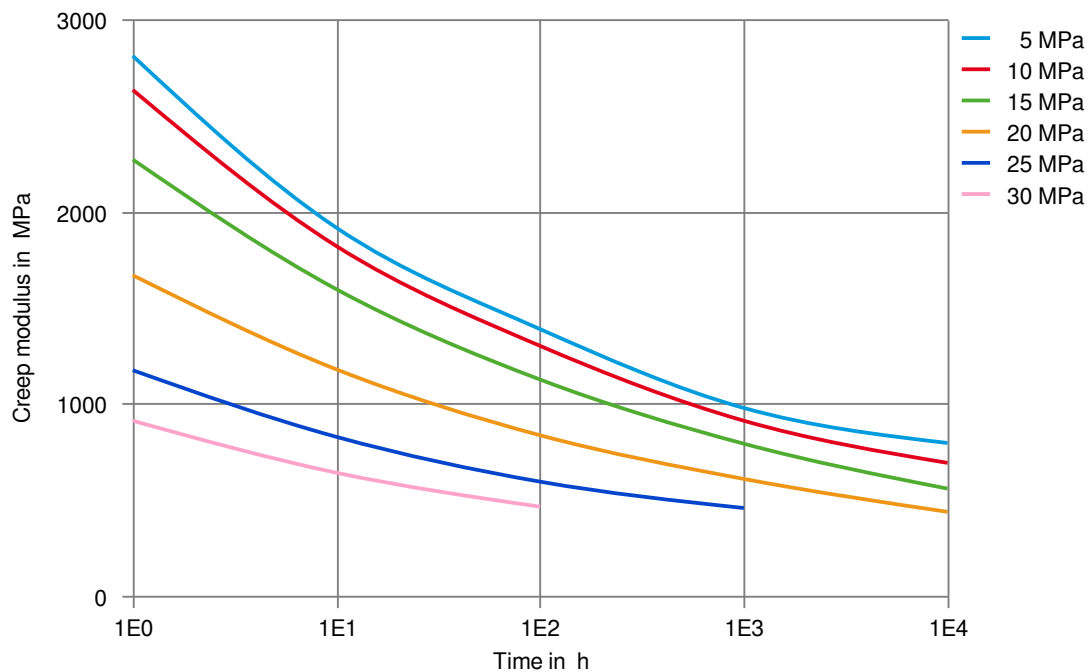
Stress-strain (isochronous) 23°C



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Creep modulus-time 23°C



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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
- ✗ 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

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
- ✗ 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).