



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® LW9020 BK580 is a 20% glass fiber reinforced polybutylene terephthalate blend for injection moulding. It has improved surface aesthetics, excellent dimensional stability and low warpage characteristics.

Product information

Resin Identification Part Marking Code	PBT+ASA-GF20 >PBT+ASA-GF20<		ISO 1043 ISO 11469
Rheological properties			
Moulding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Moulding shrinkage, normal	0.7	%	ISO 294-4, 2577
Typical mechanical properties			
Tensile modulus	7000	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	108	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.5	%	ISO 527-1/-2
Flexural modulus	6200	MPa	ISO 178
Flexural strength	160	MPa	ISO 178
Charpy impact strength, 23°C	50	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C		kJ/m²	ISO 179/1eA
Izod notched impact strength, 23°C		kJ/m²	ISO 180/1A
Poisson's ratio	0.35		
Thermal properties			
Melting temperature, 10°C/min	225	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	120	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	150	°C	ISO 75-1/-2
Temperature of deflection under load, 1.8 MPa, annealed	180	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	205	°C	ISO 75-1/-2
RTI, electrical, 0.75mm	130	°C	UL 746B
RTI, electrical, 1.5mm	130	°C	UL 746B
RTI, electrical, 3.0mm	130		UL 746B
RTI, electrical, 6mm	130		UL 746B
RTI, impact, 0.75mm	125		UL 746B
RTI, impact, 1.5mm	125	°C	UL 746B

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RTI, impact, 3.0mm	130	°C	UL 746B
RTI, impact, 6mm	130	°C	UL 746B
RTI, strength, 0.75mm	130	°C	UL 746B
RTI, strength, 1.5mm	130		UL 746B
RTI, strength, 3.0mm	130	°C	UL 746B
RTI, strength, 6mm	130	°C	UL 746B
Flammability			
Burning Behav. at 1.5mm nom. thickn.	НВ	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	0.75		IEC 60695-11-10
UL recognition	yes		UL 94
Glow Wire Flammability Index, 3.0mm	700	°C	IEC 60695-2-12
FMVSS Class	В		ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	38	mm/min	ISO 3795 (FMVSS 302)
Electrical properties			
Relative permittivity, 100Hz	3.7		IEC 62631-2-1
Relative permittivity, 1MHz	3.5		IEC 62631-2-1
Dissipation factor, 100Hz		E-4	IEC 62631-2-1
Dissipation factor, 1MHz	178		IEC 62631-2-1
Volume resistivity		Ohm.m	IEC 62631-3-1
Surface resistivity	1E14		IEC 62631-3-2
Electric strength		kV/mm	IEC 60243-1
Comparative tracking index	275		IEC 60112
Physical/Other properties			
Density	1350	kg/m³	ISO 1183
Density of melt		kg/m³	100 1100
VDA Properties			
Odour	3.5	class	VDA 270
Injection			
Drying Recommended	yes		
Drying Temperature	120	°C	
Drying Time, Dehumidified Dryer	2 - 4		
Processing Moisture Content	≤0.04		
Melt Temperature Optimum	250		
Min. melt temperature	240		
Max. melt temperature	260		
Mold Temperature Optimum		°C	
Min. mould temperature	60	°C	
A.A. III.	100	0.0	

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130 °C

≥60 MPa

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Max. mould temperature Hold pressure range





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Hold pressure time 3 s/mm Back pressure As low as MPa

possible

Ejection temperature 180 °C

Characteristics

Processing Injection Moulding
Special characteristics Low Warpage

Automotive

OEM STANDARD

BMW GS93016-PBT+ASA-GF20

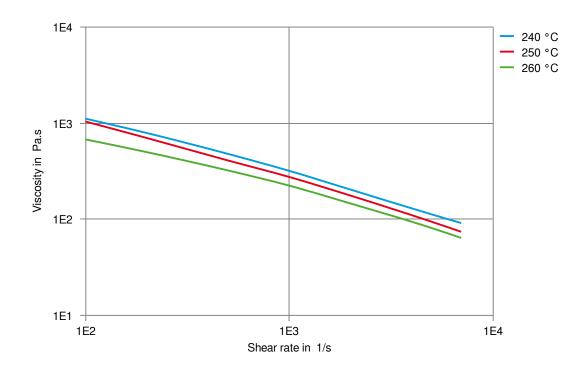
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Viscosity-shear rate



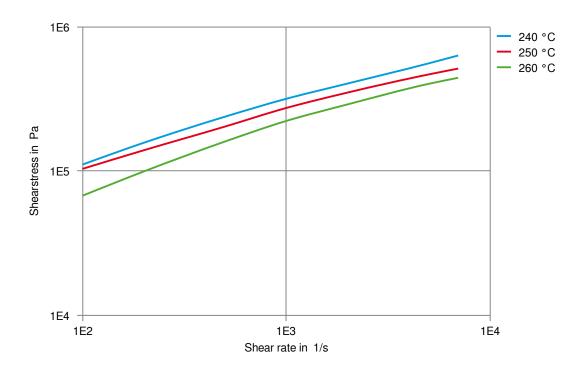
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Shearstress-shear rate



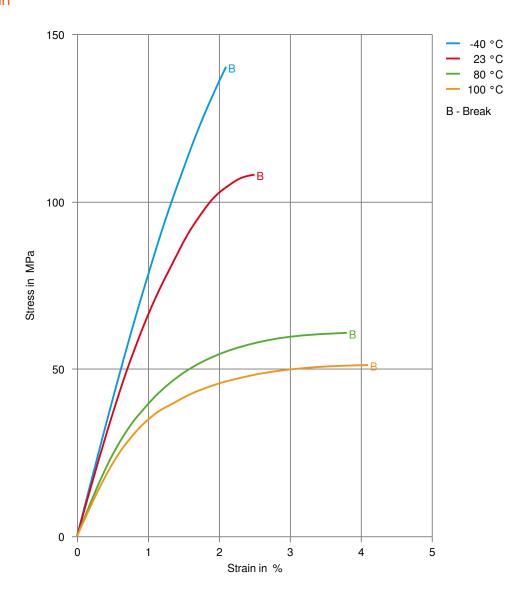
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Stress-strain



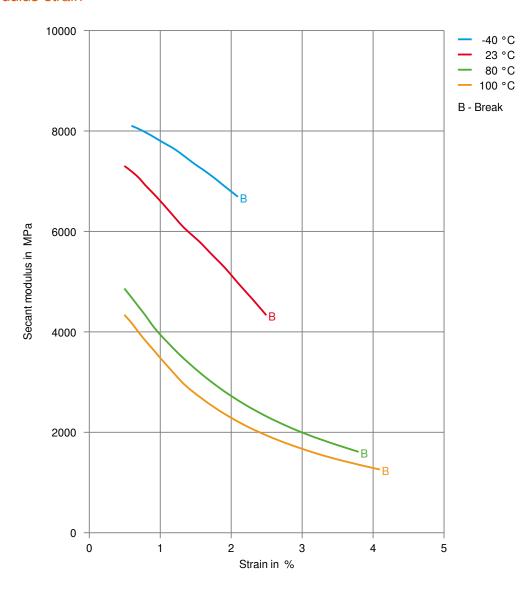
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Secant modulus-strain



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Crastin® LW9020 BK580

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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
- X 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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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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