

DuPont™ Crastin® SK605LM BK591

THERMOPLASTIC POLYESTER RESIN

Product Information

Crastin® SK605LM BK591 is a 30% Glass Reinforced, Laser Markable, Polybutylene Terephthalate

General information	Value	Unit	Test Standard
Resin Identification	PBT-GF30	-	ISO 1043
Part Marking Code	PBT-GF30	-	ISO 11469
Rheological properties	Value	Unit	Test Standard
Melt volume-flow rate	5	cm ³ /10min	ISO 1133
Temperature	250	°C	ISO 1133
Load	2.16	kg	ISO 1133
Molding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Molding shrinkage, normal	1.1	%	ISO 294-4, 2577
Mechanical properties	Value	Unit	Test Standard
Tensile Modulus	9500	MPa	ISO 527-1/-2
Stress at break	130	MPa	ISO 527-1/-2
Strain at break	2.5	%	ISO 527-1/-2
Flexural Strength	200	MPa	ISO 178
Charpy impact strength, 73°F	70	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 73°F	10	kJ/m ²	ISO 179/1eA
Thermal properties	Value	Unit	Test Standard
Melting temperature, 18°F/min	225	°C	ISO 11357-1/-3
Temp. of deflection under load, 260 psi	205	°C	ISO 75-1/-2
Flammability	Value	Unit	Test Standard
Burning Behav. at 60mil nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	IEC 60695-11-10
Burning Behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.75	mm	IEC 60695-11-10
Oxygen index	20	%	ISO 4589-1/-2
Glow Wire Flammability Index			IEC 60695-2-1/2
30mil	725	°C	
60mil	725	°C	
120mil	825	°C	
Glow Wire Ignition Temperature			IEC 60695-2-1/3
30mil	750	°C	
60mil	750	°C	
120mil	800	°C	
FMVSS Class	B	-	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	54	mm/min	ISO 3795 (FMVSS 302)
Other properties	Value	Unit	Test Standard
Density	1520	kg/m ³	ISO 1183
VDA Properties	Value	Unit	Test Standard
Emission of organic compounds	91.4	µgC/g	VDA 277
Odor test	3	class	VDA 270
Fogging, F-value (refraction)	99	%	ISO 6452
Injection	Value	Unit	Test Standard
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. mold temperature	30	°C	-

To find out more, visit [DuPont Performance Polymers](#) or contact nearest DuPont location.

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Max. mold temperature	130 °C	-
Hold pressure range	≥60 MPa	-
Hold pressure time	3 s/mm	-
Back pressure	As low as possible	-
Ejection temperature	170 °C	-

Characteristics

Processing	• Injection Molding		
Delivery form	• Pellets		
Additives	• Release agent		
Regional Availability	• North America	• Asia Pacific	• Near East/Africa
	• Europe	• South and Central America	• Global

Contact DuPont for Material Safety Data Sheet, general guides and/or additional information about ventilation, handling, purging, drying, etc. ISO Mechanical properties measured at 160 mil (Hytrel® measured at 80 mil), IEC Electrical properties measured at 80 mil, all ASTM properties measured at 120 mil, and test temperatures are 73°F unless otherwise stated.

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