

DuPont™ Crastin® 6130 NC010

THERMOPLASTIC POLYESTER RESIN

Product Information

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, DuPont recommends, 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® 6130 NC010 is an unreinforced, medium high viscosity polybutylene terephthalate resin for extrusion and injection moulding.

General information	Value	Unit	Test Standard
Resin Identification	PBT	-	ISO 1043
Part Marking Code	PBT	-	ISO 11469
Rheological properties	Value	Unit	Test Standard
Melt mass-flow rate	16	g/10min	ISO 1133
Melt mass-flow rate, Temperature	250	°C	ISO 1133
Melt mass-flow rate, Load	2.16	kg	ISO 1133
Viscosity number	130	cm ³ /g	ISO 307, 1157, 1628
Moulding shrinkage, parallel	1.7	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.7	%	ISO 294-4, 2577
Mechanical properties	Value	Unit	Test Standard
Tensile Modulus	2600	MPa	ISO 527-1/-2
Yield stress	59	MPa	ISO 527-1/-2
Yield strain	8	%	ISO 527-1/-2
Nominal strain at break	50	%	ISO 527-1/-2
Strain at Break, 23°C, 50mm/min	110	%	ISO 527-1/-2
Poisson's ratio	0.38	-	ISO 527-1/-2
Charpy notched impact strength			ISO 179/1eA
23°C	5	kJ/m ²	
-30°C	4.5	kJ/m ²	
Izod notched impact strength, 23°C	4	kJ/m ²	ISO 180/1A
Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	225	°C	ISO 11357-1/-3
Temp. of deflection under load			ISO 75-1/-2
1.8 MPa	50	°C	
0.45 MPa	115	°C	
0.45 MPa, annealed	180	°C	
1.8 MPa, annealed	60	°C	
Coeff. of linear therm. expansion, parallel	108	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	144	E-6/K	ISO 11359-1/-2
Thermal conductivity of melt	0.25	W/(m K)	-
Spec. heat capacity of melt	2050	J/(kg K)	-
RTI, electrical			UL 746B
0.75mm	75	°C	
1.5mm	75	°C	
3mm	75	°C	

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RTI, impact			UL 746B
0.75mm	75	°C	
1.5mm	75	°C	
3mm	75	°C	
RTI, strength			UL 746B
0.75mm	75	°C	
1.5mm	75	°C	
3mm	75	°C	
Flammability	Value	Unit	Test Standard
Burning Behav. at 1.5mm nom. thckn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	IEC 60695-11-10
UL recognition	UL	-	UL 94
Burning Behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.81	mm	IEC 60695-11-10
UL recognition	UL	-	UL 94
Oxygen index	22	%	ISO 4589-1/-2
FMVSS Class	B	-	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	<100	mm/min	ISO 3795 (FMVSS 302)
Electrical properties	Value	Unit	Test Standard
Relative permittivity, 1MHz	3.2	-	IEC 62631-2-1
Volume resistivity	>1E13	Ohm*m	IEC 62631-3-1
Electric strength	26	kV/mm	IEC 60243-1
Comparative tracking index	600	-	IEC 60112
Other properties	Value	Unit	Test Standard
Density	1300	kg/m ³	ISO 1183
Density of melt	1110	kg/m ³	-
VDA Properties	Value	Unit	Test Standard
Fogging, G-value (condensate)	0.1	mg	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. mould temperature	30	°C	-
Max. mould temperature	130	°C	-
Hold pressure range	≥60	MPa	-
Hold pressure time	4	s/mm	-
Back pressure	As low as possible		-
Ejection temperature	170	°C	-
Extrusion	Value	Unit	Test Standard
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	<ul style="list-style-type: none"> Injection Moulding Profile Extrusion 	<ul style="list-style-type: none"> Sheet Extrusion Other Extrusion 	<ul style="list-style-type: none"> Coatable
Delivery form	<ul style="list-style-type: none"> Pellets 		
Regional Availability	<ul style="list-style-type: none"> North America Europe 	<ul style="list-style-type: none"> South and Central America Near East/Africa 	

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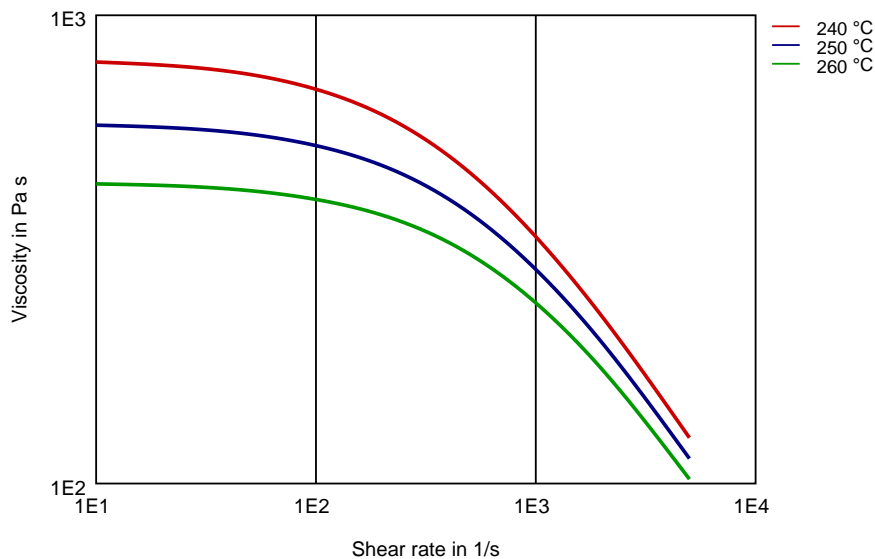
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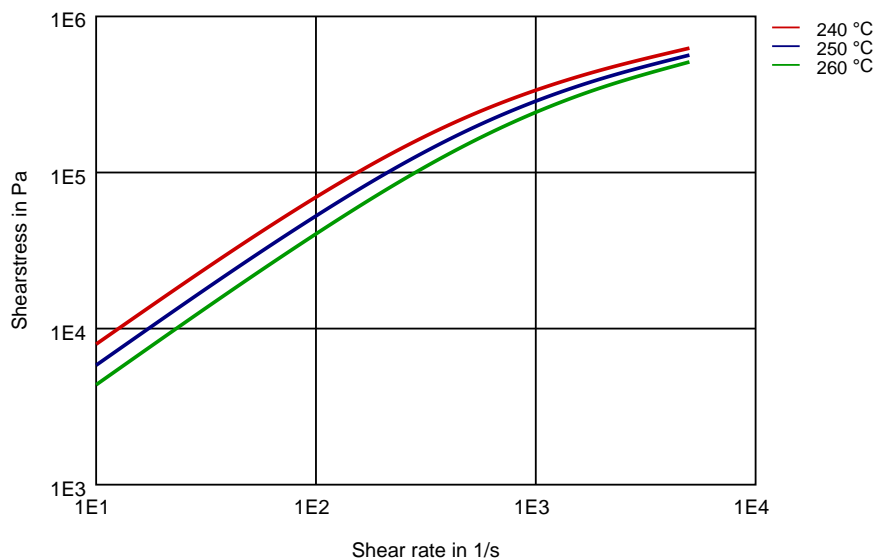
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Diagrams

Viscosity-shear rate



Shearstress-shear rate



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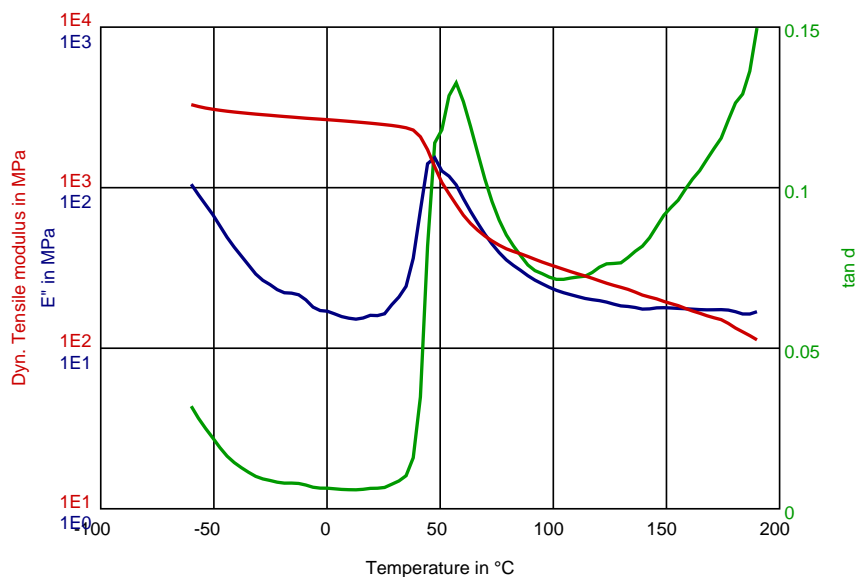
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Dynamic Tensile modulus-temperature (measured on Crastin® S600F20 NC010)



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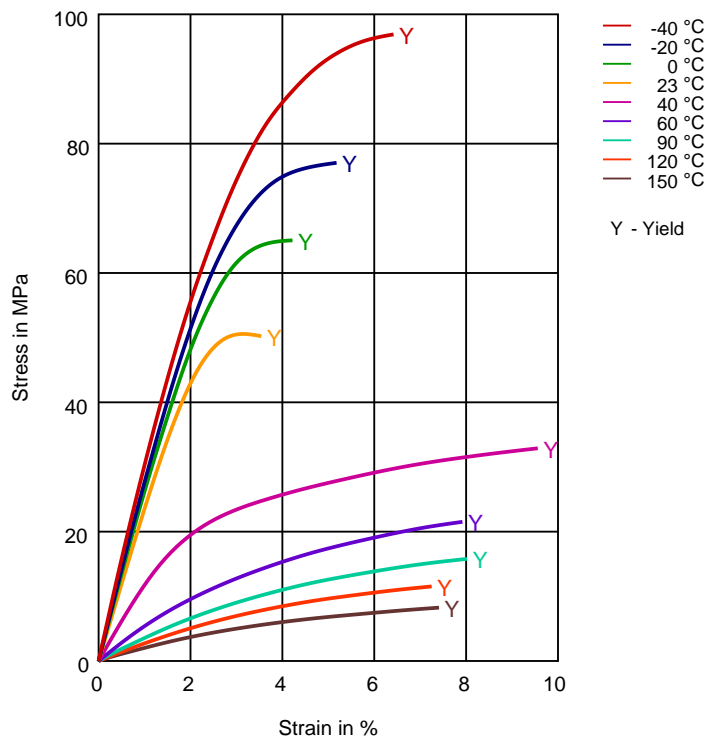
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Stress-strain (measured on Crastin® 6129 NC010)



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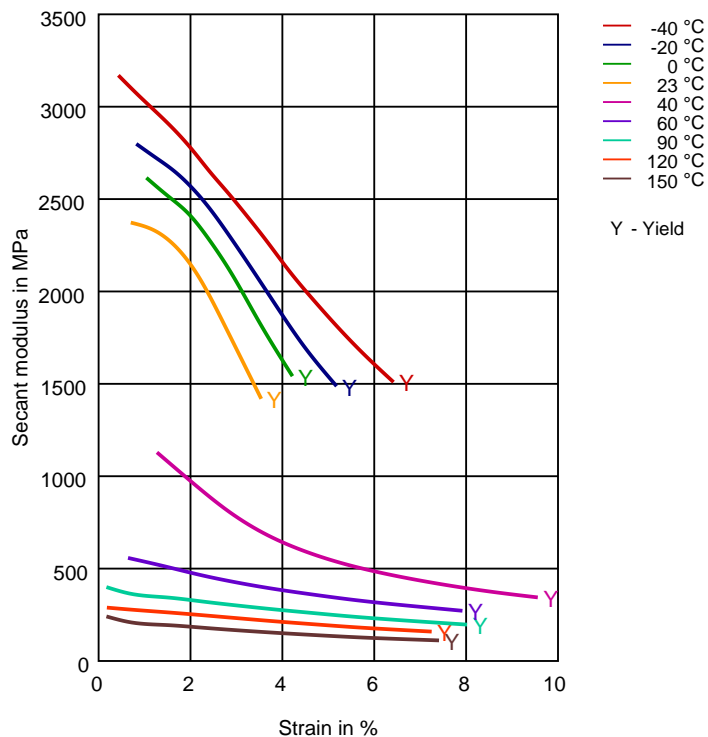
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THERMOPLASTIC POLYESTER RESIN

Secant modulus-strain (measured on Crastin® 6129 NC010)



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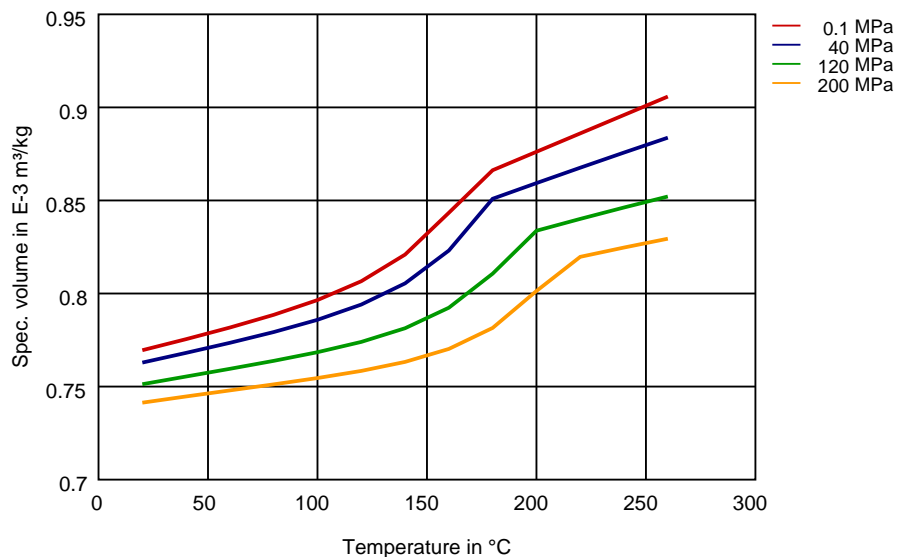
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Specific volume-temperature (pvT)



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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)



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- ✓ 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)
- ✓ 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).

Contact DuPont for Material Safety Data Sheet, general guides and/or additional information about ventilation, handling, purging, drying, etc. ISO Mechanical properties measured at 4mm (Hytrel® measured at 2 mm), IEC Electrical properties measured at 2mm, all ASTM properties measured at 3.2mm, and test temperatures are 23°C unless otherwise stated.

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