Crastin® ST820 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® ST820 NC010 is an unreinforced, Super Tough polybutylene terephthalate resin for injection molding.

Product information

Resin Identification	PBT-HI	ISO 1043
Part Marking Code	>PBT-HI<	ISO 11469
TGA curve	available	ISO 11358-1

Rheological properties

Melt mass-flow rate	2	g/10min	ISO 1133
Melt mass-flow rate, Temperature	482	°F	
Melt mass-flow rate, Load	11	lb	
Molding shrinkage range, parallel	1.8 - 2.4	%	ISO 294-4, 2577
Molding shrinkage range, normal	1.7 - 2.3	%	ISO 294-4, 2577
Melt viscosity, @ 1000 sec-1, 250°C	4800	P	ISO 11443

Typical mechanical properties

Tensile modulus	247000	psi	ISO 527-1/-2
Tensile stress at yield, 50mm/min	5500	psi	ISO 527-1/-2
Tensile strain at yield, 50mm/min	7	%	ISO 527-1/-2
Tensile stress at break, 50mm/min	4350	psi	ISO 527-1/-2
Nominal strain at break	>50	%	ISO 527-1/-2
Tensile strain at break, 50mm/min	150	%	ISO 527-1/-2
Flexural modulus	225000	psi	ISO 178
Flexural strength	7250	psi	ISO 178
Charpy impact strength, 23°C	N	ftlb/in²	ISO 179/1eU
Charpy impact strength, -30°C	N	ftlb/in²	ISO 179/1eU
Charpy notched impact strength, 23°C	40.4	ftlb/in²	ISO 179/1eA
Charpy notched impact strength, -30°C	4.76	ftlb/in²	ISO 179/1eA
Charpy notched impact strength, -40°C	4.76	ftlb/in²	ISO 179/1eA
Izod notched impact strength, 23°C	28.5	ftlb/in²	ISO 180/1A
Izod notched impact strength, -30°C	7.14	ftlb/in²	ISO 180/1A
Izod notched impact strength, -40°C	4.76	ftlb/in²	ISO 180/1A
Izod impact strength, 23°C	N	ftlb/in²	ISO 180/1U
Izod impact strength, -30°C	N	ftlb/in²	ISO 180/1U
Izod impact strength, -40°C	128	ftlb/in²	ISO 180/1U

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Hardness, Rockwell, R-scale	104		ISO 2039-2

Thermal properties

Melting temperature, 10°C/min	437	°F	ISO 11357-1/-3
Glass transition temperature, 10°C/min	131	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	122	°F	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	212	°F	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa, annealed	293	°F	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	257	°F	ISO 306
Coefficient of linear thermal expansion (CLTE), parallel	0.82	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), parallel, -40-23°C	0.55	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), parallel, 55-160°C	1.29	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	0.861	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal, -40-23°C	0.6	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal, 55-160°C	1.06	E-4/°F	ISO 11359-1/-2
Thermal conductivity of melt	0.2	W/(m K)	ISO 22007-2
Specific heat capacity of melt	2100	J/(kg K)	ISO 22007-4
RTI, electrical, 0.75mm	167	°F	UL 746B
RTI, impact, 0.75mm	167	°F	UL 746B
RTI, strength, 0.75mm	167	°F	UL 746B

Flammability

Burning Behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.0315	in	IEC 60695-11-10
UL recognition	yes		UL 94
Oxygen index	19	%	ISO 4589-1/-2
Glow Wire Flammability Index, 2.0mm	1290	°F	IEC 60695-2-12
Glow Wire Flammability Index, 3.0mm	1290	°F	IEC 60695-2-12
FMVSS Class	B		ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	1.5	in/min	ISO 3795 (FMVSS 302)
Burning rate, Thickness 2 mm	1.26	in/min	ISO 3795 (FMVSS 302)

Electrical properties

Relative permittivity, 1MHz	3.4		IEC 62631-2-1
Dissipation factor, 100Hz	200	E-4	IEC 62631-2-1
Dissipation factor, 1MHz	190	E-4	IEC 62631-2-1
Volume resistivity	>1E13	Ohm.m	IEC 62631-3-1
Surface resistivity	1E15	Ohm	IEC 62631-3-2
Electric strength	686	kV/in	IEC 60243-1
Comparative tracking index	600		IEC 60112

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Physical/Other properties

Humidity absorption, 2mm	0.12	%	Sim. to ISO 62
Water absorption, 2mm	0.31	%	Sim. to ISO 62
Density	0.044	lb/in^3	ISO 1183
Density of melt	64.3	lb/ft^3	

Emissions

Fogging, G-value (condensate)	0.1	mg	ISO 6452

Injection

Drying Recommended	yes	
Drying Temperature	248	°F
Drying Time, Dehumidified Dryer	2 - 4	h
Processing Moisture Content	≤0.04	%
Melt Temperature Optimum	482	°F
Min. melt temperature	464	°F
Max. melt temperature	500	°F
Mold Temperature Optimum	176	°F
Min. mold temperature	140	°F
Max. mold temperature	266	°F
Hold pressure range	≥8700	psi
Hold pressure time	0.0762	s/mil
Hold Pressure Time (h is the max. wall thickness of the part in mm)	1.5h^2+2	s
Back pressure	as low as possible	psi
Ejection temperature	329	°F

Extrusion

Drying Temperature	230 - 266	°F
Drying Time, Dehumidified Dryer	2 - 4	h
Processing Moisture Content	≤0.04	%
Melt Temperature Range	464 - 500	°F

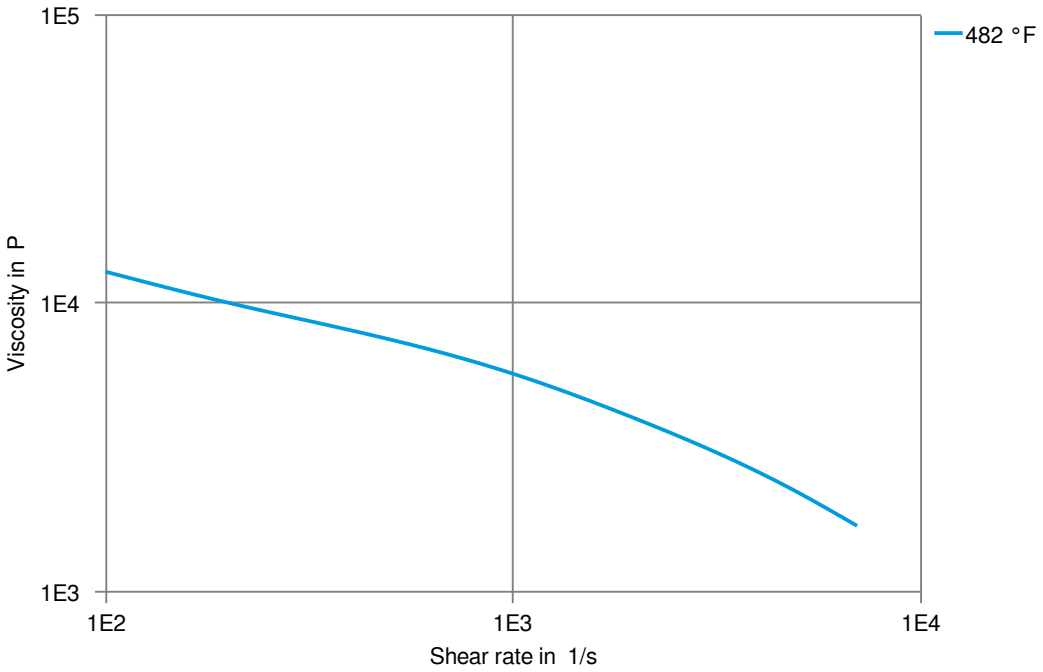
Characteristics

Processing	Injection Molding, Film Extrusion, Extrusion, Sheet Extrusion, Other Extrusion, Extrusion - Wire and Cable
Additives	Release agent

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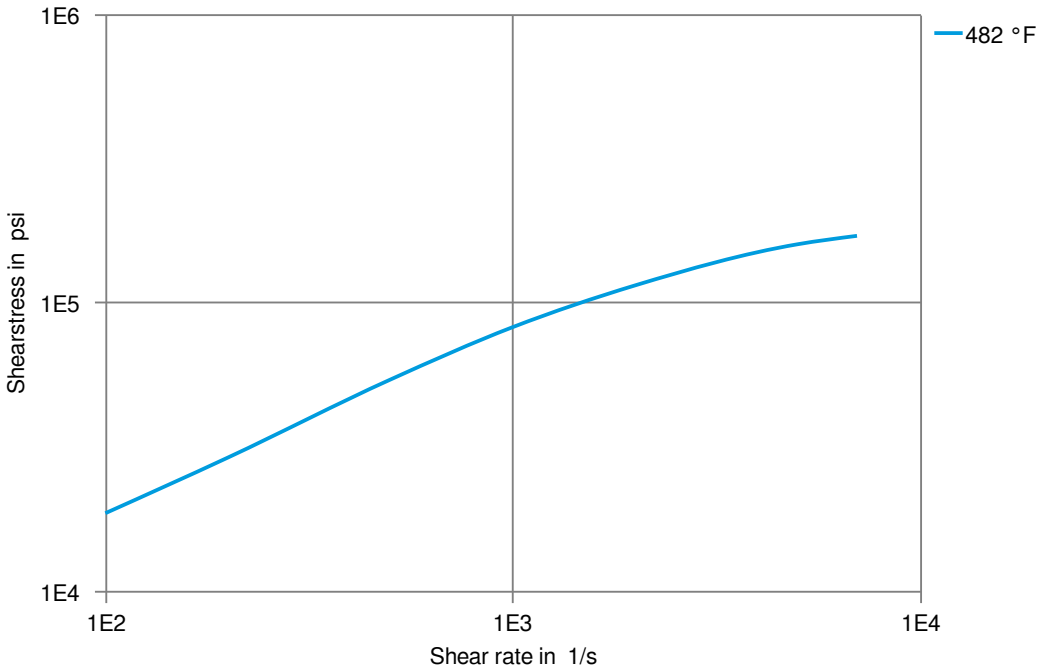
Viscosity-shear rate



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THERMOPLASTIC POLYESTER RESIN

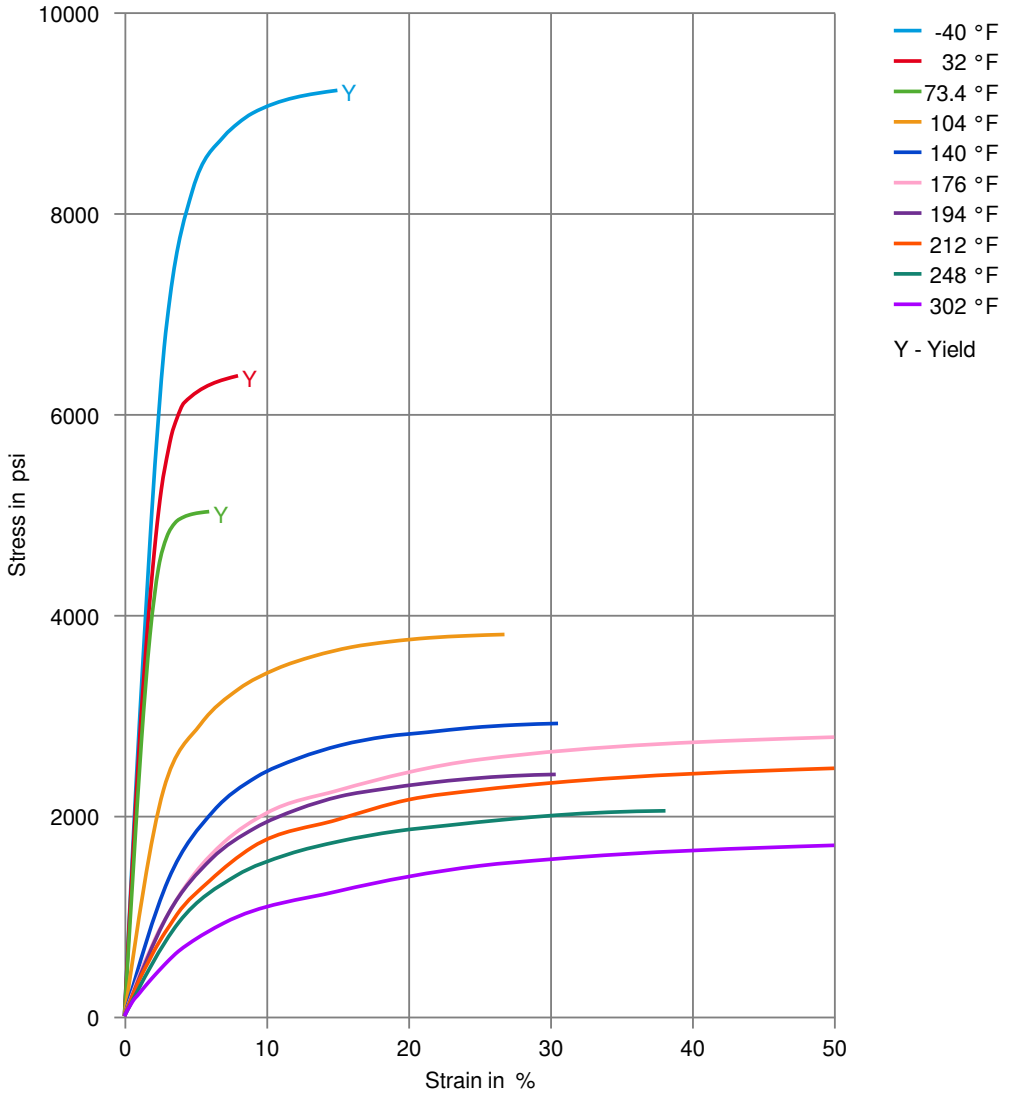
Shearstress-shear rate



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Stress-strain

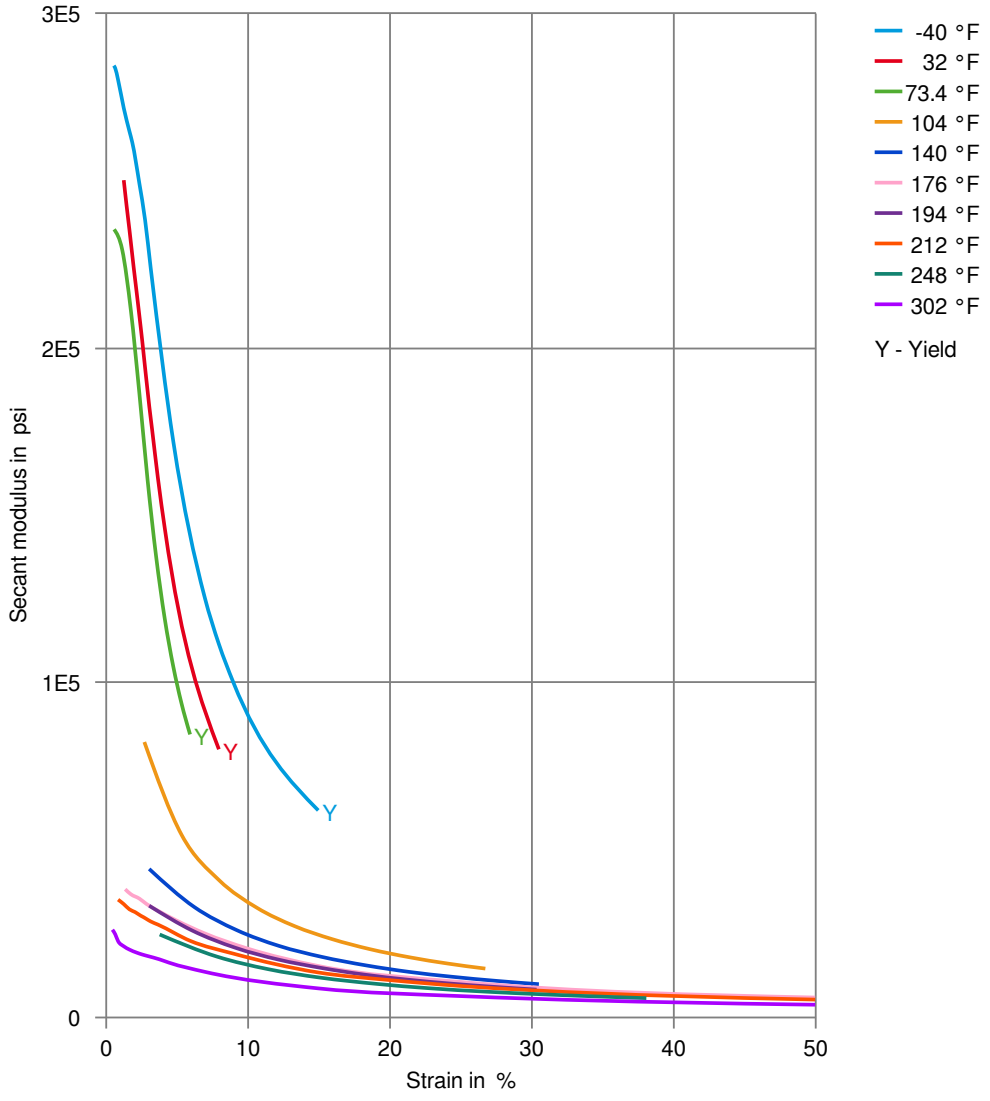


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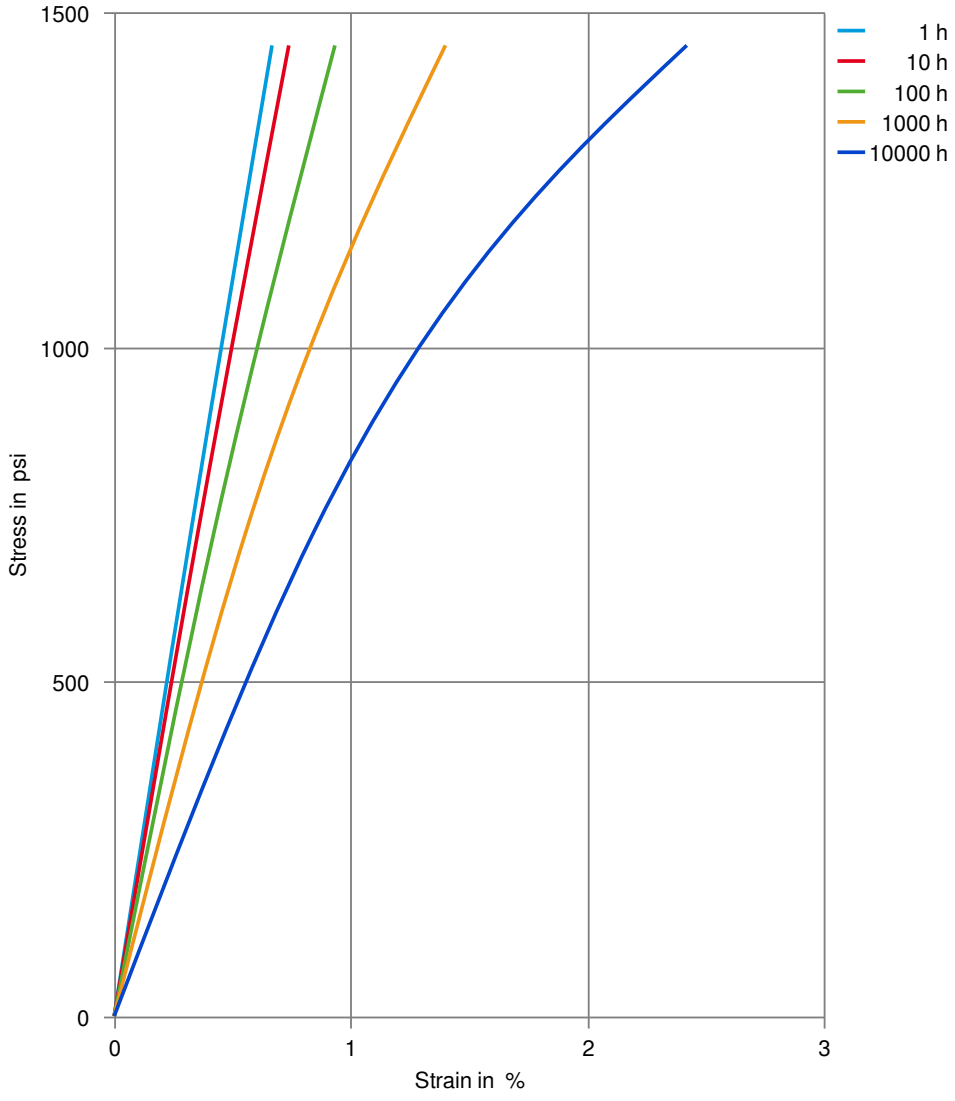
Secant modulus-strain



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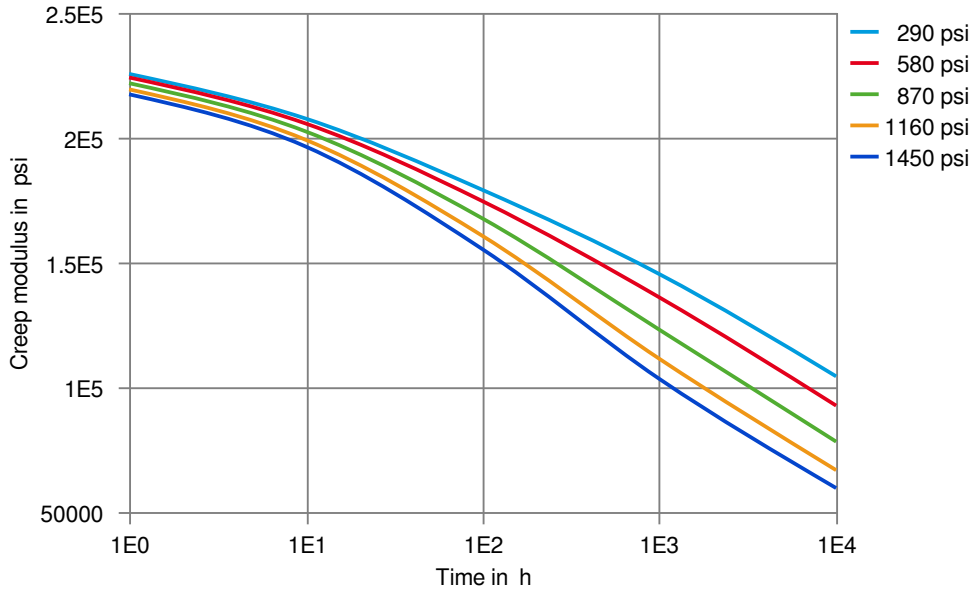
Stress-strain (isochronous) 73.4 °F



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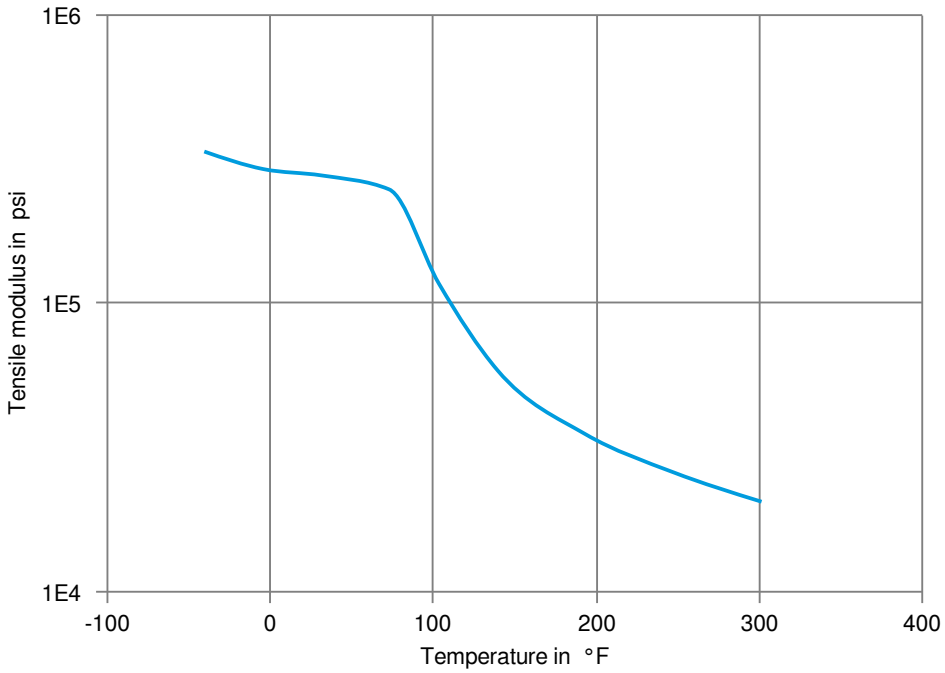
Creep modulus-time 73.4 °F



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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
- ✘ 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).

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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. Colorants or other additives may cause significant variations in data values. Properties of molded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design, 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 seek and adhere to the manufacturer's current instructions for handling each material they use, and entrust the handling of such material to adequately trained personnel only. Please call the telephone numbers listed for additional technical information. Call Customer Services for the appropriate Materials Safety Data Sheets (MSDS) before attempting to process our products.
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