

DuPont™ Crastin® LW9330 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® LW9330 NC010 is a 30% glass fiber reinforced polybutylene terephthalate blend for injection molding. It has improved surface aesthetics, excellent dimensional stability and low warpage characteristics.

Product information	Value	Unit	Test Standard
Resin Identification	PBT+SAN-GF30	-	ISO 1043
Part Marking Code	PBT+SAN-GF30	-	ISO 11469
Rheological properties	Value	Unit	Test Standard
Melt volume-flow rate	10	cm ³ /10min	ISO 1133
Temperature	250	°C	ISO 1133
Load	5	kg	ISO 1133
Melt mass-flow rate	13	g/10min	ISO 1133
Melt mass-flow rate, Temperature	250	°C	ISO 1133
Melt mass-flow rate, Load	5	kg	ISO 1133
Molding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6	%	ISO 294-4, 2577
Mechanical properties	Value	Unit	Test Standard
Tensile Modulus	9800	MPa	ISO 527-1/-2
Stress at break	135	MPa	ISO 527-1/-2
Strain at break	2.3	%	ISO 527-1/-2
Flexural Modulus	8400	MPa	ISO 178
Flexural Strength	200	MPa	ISO 178
Charpy impact strength			ISO 179/1eU
73°F	55	kJ/m ²	
-40°F	50	kJ/m ²	
Charpy notched impact strength			ISO 179/1eA
73°F	9	kJ/m ²	
-22°F	9	kJ/m ²	
-40°F	9	kJ/m ²	
Izod notched impact strength			ISO 180/1A
73°F	7	kJ/m ²	
-40°F	7	kJ/m ²	
Izod impact strength			ISO 180/1U
73°F	45	kJ/m ²	
-40°F	45	kJ/m ²	
Thermal properties	Value	Unit	Test Standard
Melting temperature, 18°F/min	225	°C	ISO 11357-1/-3
Temp. of deflection under load, 260 psi	185	°C	ISO 75-1/-2
Ball pressure test	195	°C	IEC 60695-10-2
Thermal conductivity of melt	0.28	W/(m K)	-
Spec. heat capacity of melt	1790	J/(kg K)	-

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RTI, electrical			UL 746B
30mil	130	°C	
60mil	130	°C	
120mil	130	°C	
RTI, impact			UL 746B
30mil	125	°C	
60mil	125	°C	
120mil	130	°C	
RTI, strength			UL 746B
30mil	130	°C	
60mil	130	°C	
120mil	130	°C	
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
UL recognition	yes	-	UL 94
Burning Behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.75	mm	IEC 60695-11-10
UL recognition	yes	-	UL 94
Glow Wire Flammability Index			IEC 60695-2-12
30mil	700	°C	
60mil	700	°C	
120mil	775	°C	
Glow Wire Ignition Temperature			IEC 60695-2-13
30mil	725	°C	
60mil	725	°C	
120mil	800	°C	
FMVSS Class	B	-	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	28	mm/min	ISO 3795 (FMVSS 302)
Electrical properties	Value	Unit	Test Standard
Surface resistivity	>1E15	Ohm	IEC 62631-3-2
Comparative tracking index	550	-	IEC 60112
Other properties	Value	Unit	Test Standard
Humidity absorption, 80mil	0.25	%	Sim. to ISO 62
Water absorption, 80mil	1	%	Sim. to ISO 62
Density	1420	kg/m ³	ISO 1183
Density of melt	1270	kg/m ³	-
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	-
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		

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Additives	• Release agent		
Regional Availability	• North America	• Asia Pacific	• Near East/Africa
	• Europe	• South and Central America	• Global

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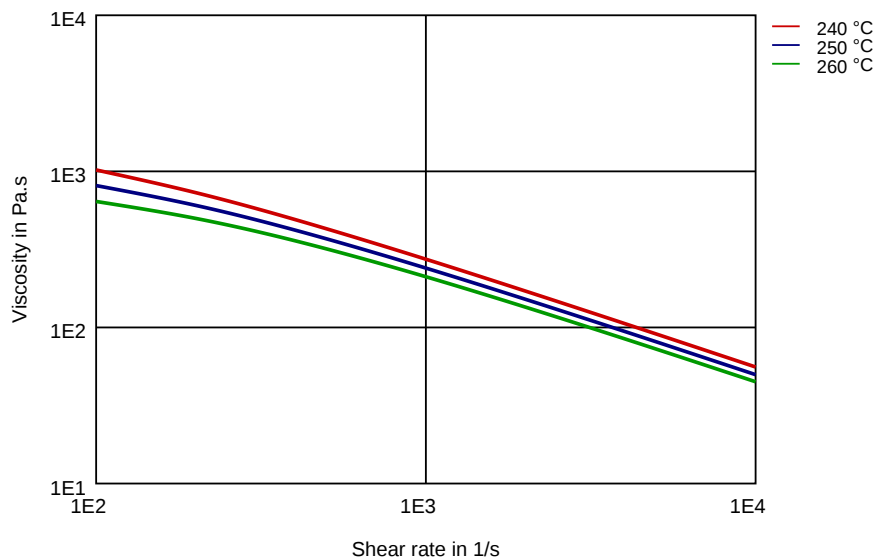


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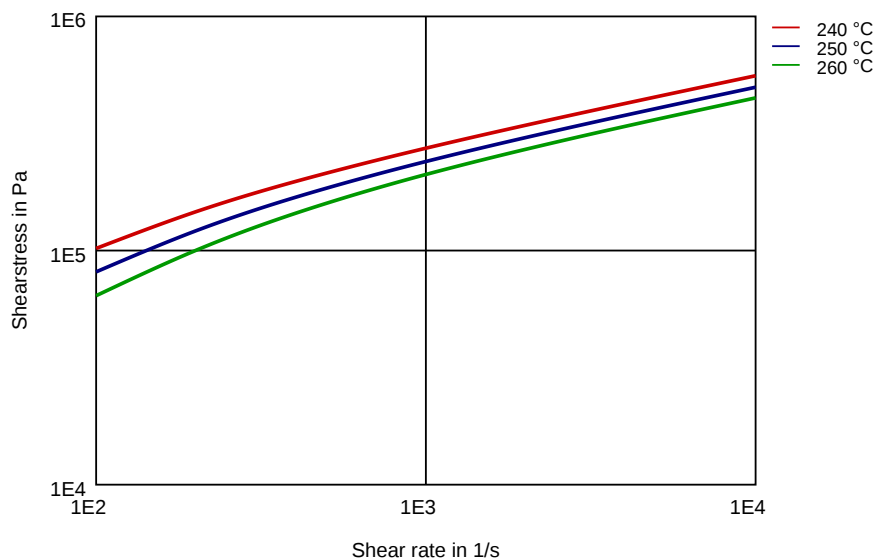
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Diagrams

Viscosity-shear rate



Shearstress-shear rate



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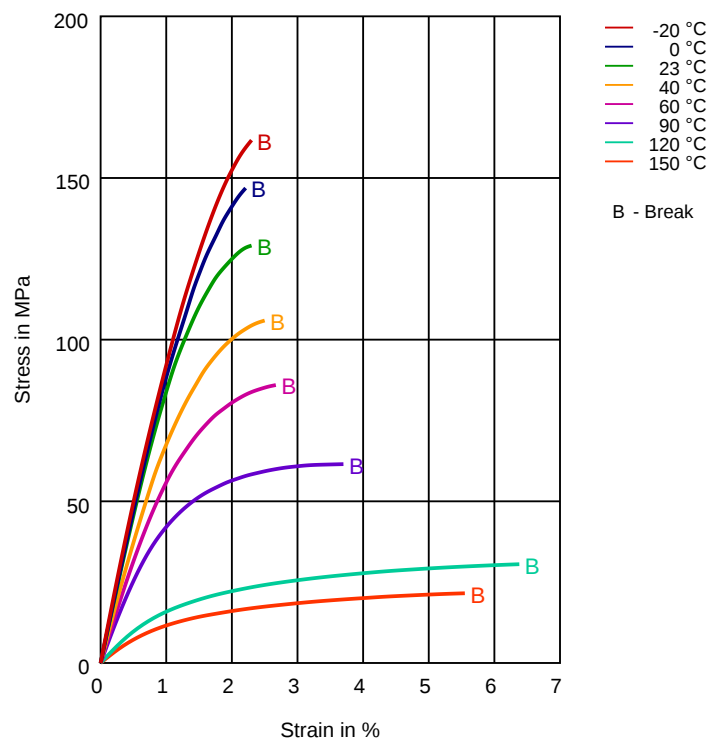
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THERMOPLASTIC POLYESTER RESIN

Stress-strain



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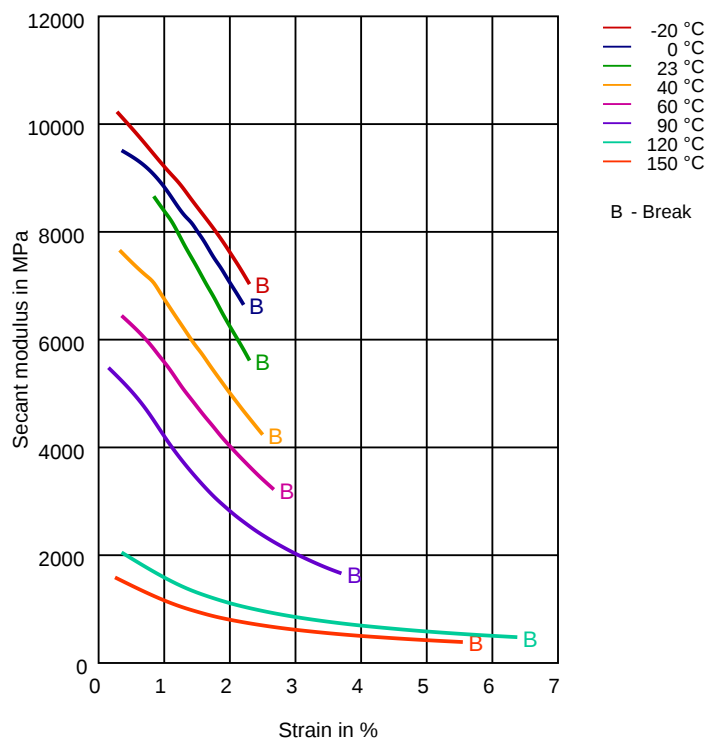
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Secant modulus-strain



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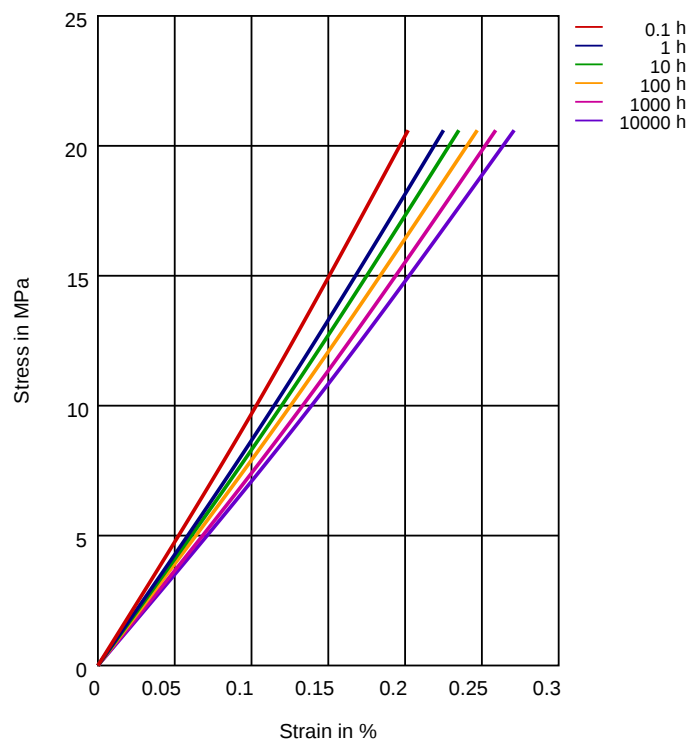
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THERMOPLASTIC POLYESTER RESIN

Stress-strain (isochronous) 23 °C



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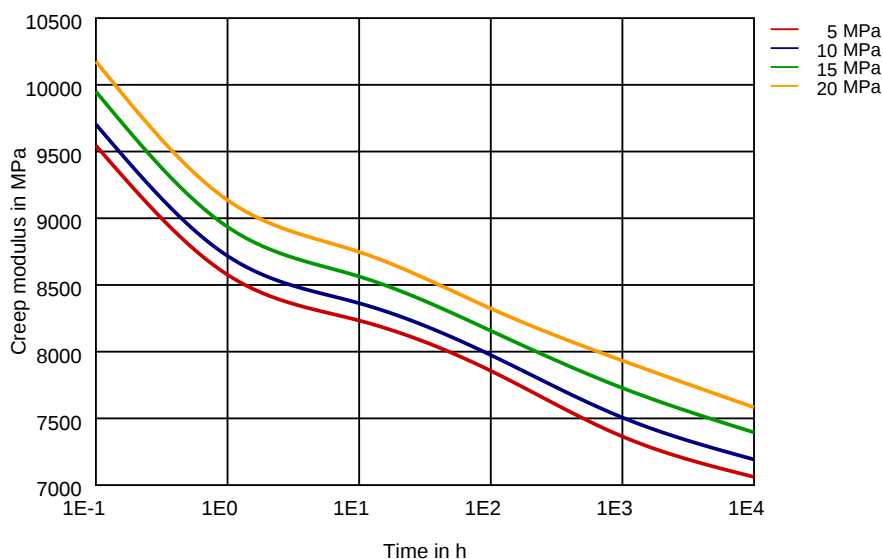


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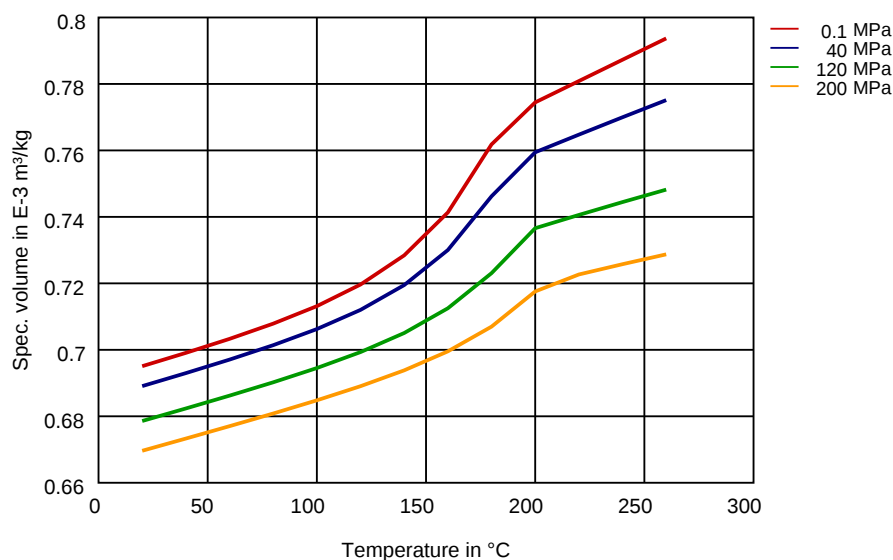
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Creep modulus-time 23 °C



Specific volume-temperature (pvT)



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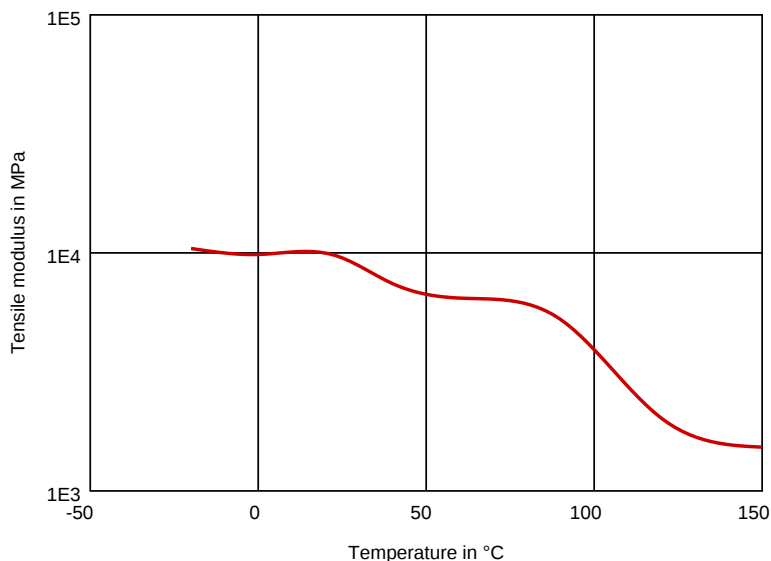
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Tensile modulus-temperature



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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)



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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 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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