Crastin® HR5330HFS NC010
THERMOPLASTIC POLYESTER RESIN

Product Description
Crastin® HR5330HFS is a 30% glass fiber reinforced, moderately toughened, hydrolysis resistant polybutylene terephtalate for injection molding.

General			
Material Status	• Preliminary Data [1]		
Availability	• Africa & Middle East • Asia Pacific • Central America	• Europe • Latin America • North America	• South America
Filler / Reinforcement	• Glass Fiber Reinforcement, 30% Filler by Weight		
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		
Part Marking Code (ISO 11469)	• >PBT-IGF30<		
Resin ID (ISO 1043)	• PBT-IGF30		
Product Category	• Glass Reinforced Resins	• Hydrolysis Resistant Resins	

Physical	Nominal Value Unit	Test Method
Density	1.50 g/cm³	ISO 1183
Mechanical	**Nominal Value Unit**	**Test Method**
Tensile Modulus (23°C)	8400 MPa	ISO 527-2
Tensile Stress (Break, 23°C)	130 MPa	ISO 527-2
Tensile Strain (Break, 23°C)	3.1 %	ISO 527-2
Impact	**Nominal Value Unit**	**Test Method**
Charpy Notched Impact Strength (23°C)	13 kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	70 kJ/m²	ISO 179/1eU
Thermal	**Nominal Value Unit**	**Test Method**
Heat Deflection Temperature		
0.45 MPa, Unannealed	222 °C	ISO 75-2/B
1.8 MPa, Unannealed	207 °C	ISO 75-2/A
Melting Temperature [3]	225 °C	ISO 11357-3
Flammability	**Nominal Value Unit**	**Test Method**
Flammability Classification (1.50 mm)	HB	IEC 60695-11-10, -20

Injection	Nominal Value Unit
Drying Temperature	110 to 130 °C
Drying Time	3.0 to 4.0 hr
Suggested Max Moisture	< 0.040 %
Processing (Melt) Temp	240 to 260 °C
Melt Temperature, Optimum	250 °C
Mold Temperature, Optimum	80 °C

Notes

[1] The above data are preliminary and are subject to change as additional data are developed on subsequent lots.

[2] Typical properties: these are not to be construed as specifications.

[3] 10°C/min

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ISO Mechanical properties measured at 4.0mm, ISO Electrical properties measured at 2.0mm, and all ASTM properties measured at 3.2mm.

Test temperatures are 23°C unless otherwise stated.

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