Celanese
The chemistry inside innovation™

Crastin® SK603 NC010

THERMOPLASTIC POLYESTER RESIN

Rheological properties

Moulding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.1	%	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	7000	MPa	ISO 527-1/-2
Stress at break	120	MPa	ISO 527-1/-2
Strain at break	3.2	%	ISO 527-1/-2
Charpy impact strength, 23°C	60	kJ/m²	ISO 179/1eU
Charpy impact strength, -30°C	55	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	9	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	8	kJ/m²	ISO 179/1eA
Poisson's ratio	0.35		

Thermal properties

Melting temperature, 10°C/min	224	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	60	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	205	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	220	°C	ISO 75-1/-2

Flammability

FMVSS Class	B		ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	28	mm/min	ISO 3795 (FMVSS 302)

Other properties

Humidity absorption, 2mm	0.15	%	Sim. to ISO 62
Water absorption, 2mm	0.4	%	Sim. to ISO 62
Density	1450	kg/m³	ISO 1183

Injection

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	3	s/mm

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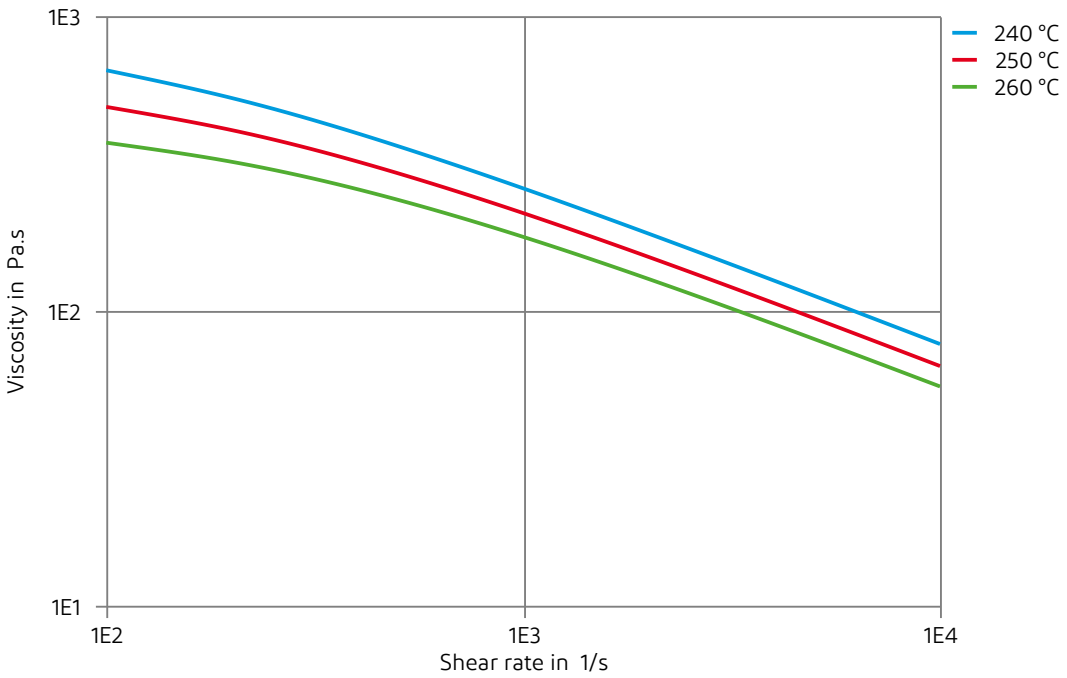
Back pressure	As low as possible	MPa
Ejection temperature	170	°C

Viscosity-shear rate



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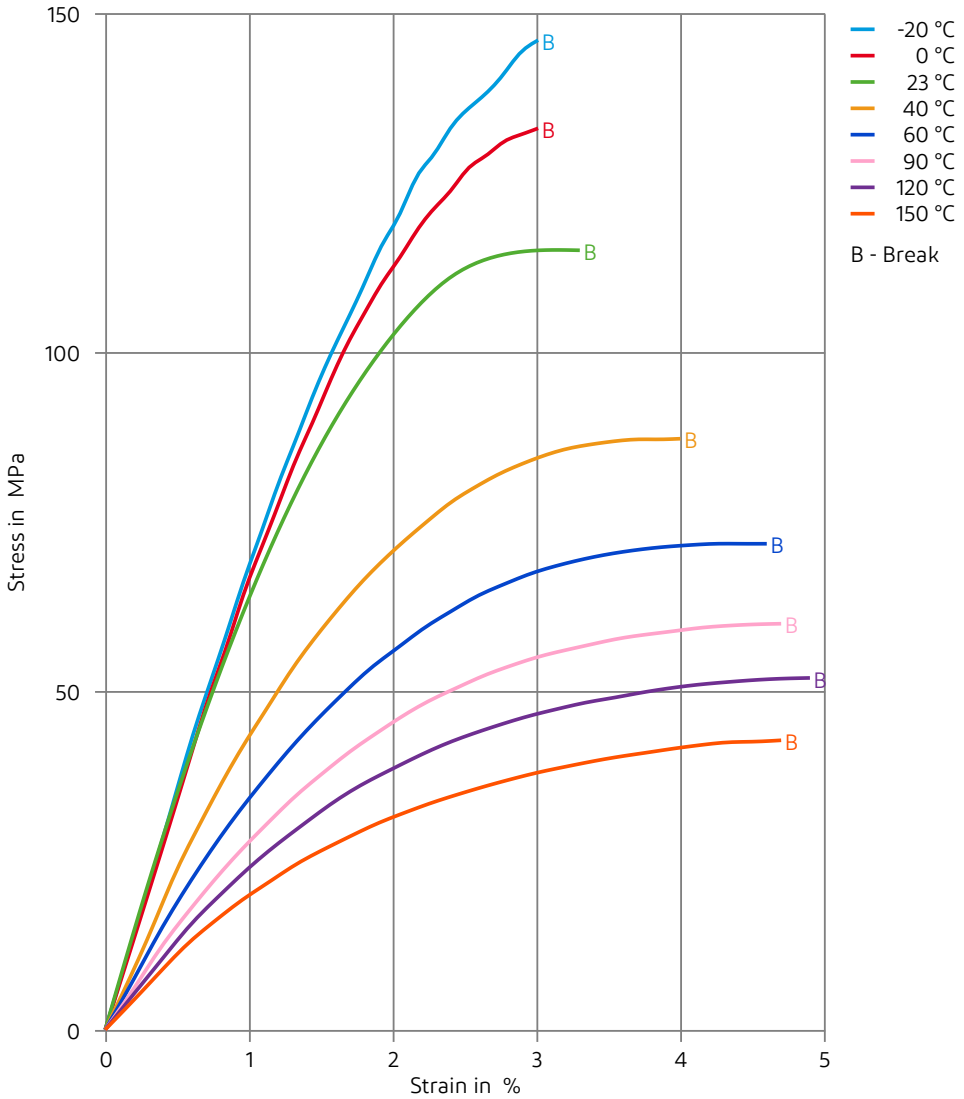
Stress-strain



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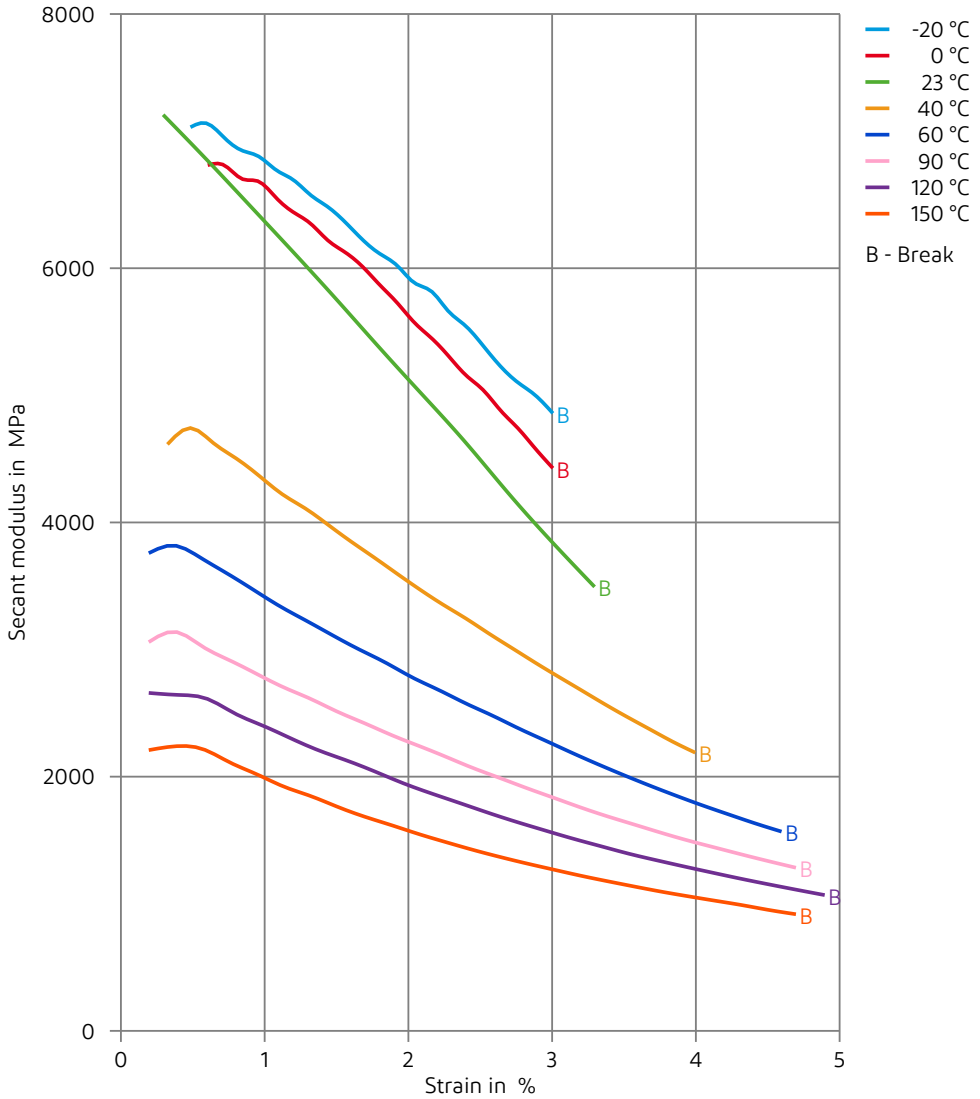
Secant modulus-strain



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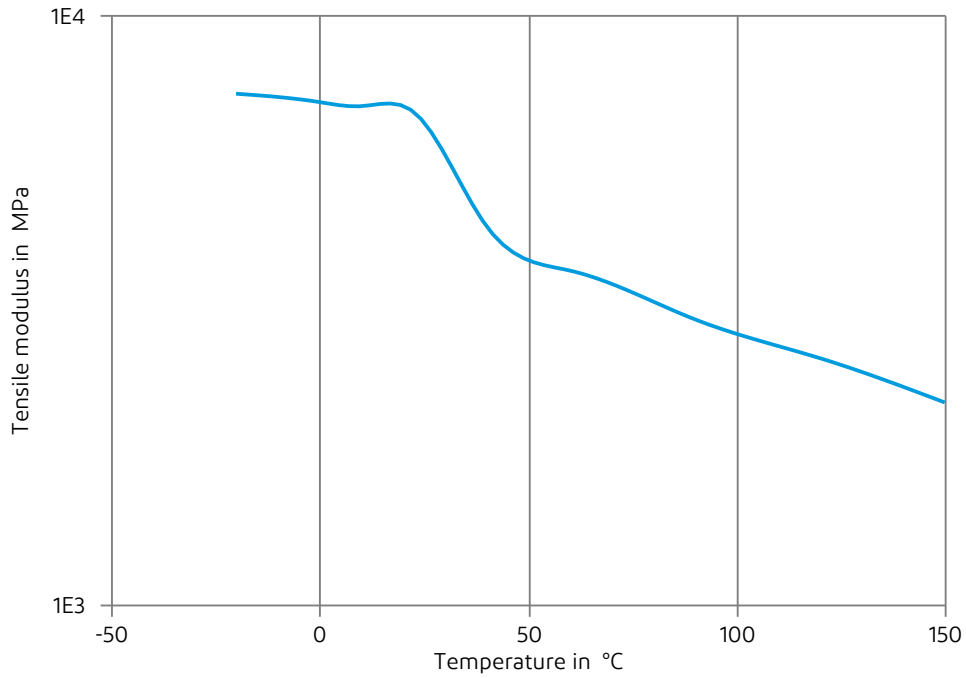
Tensile modulus-temperature



Mobility & Materials