

CompaDur® 121 GF 10 black (022)

Polybutylene Terephthalate

DimeLika Plast GmbH

Message:

PBT, injection moulding, 10% glass fibre, heat stabilized, excellent flow ability and strength, for exterior applications

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 10% filler by weight		
Additive	heat stabilizer		
Features	High strength		
	Good liquidity		
	Thermal Stability		
Uses	Outdoor application		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.38	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (250°C/2.16 kg)	18.0	cm³/10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	4600	MPa	ISO 527-2/1
Tensile Stress (Yield)	90.0	MPa	ISO 527-2/50
Tensile Strain (Yield)	4.0	%	ISO 527-2/50
Flammability	Nominal Value	Test Method	
Flame Rating (0.800 mm)	HB	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	120 - 140	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	240 - 260	°C	
Middle Temperature	240 - 260	°C	
Front Temperature	240 - 260	°C	
Nozzle Temperature	250 - 260	°C	
Processing (Melt) Temp	250 - 260	°C	
Mold Temperature	75.0 - 85.0	°C	
Injection Pressure	60.0 - 100	MPa	
Injection Rate	Fast		
Holding Pressure	1.00 - 3.00	MPa	
Back Pressure	40.0 - 80.0	MPa	

Screw Speed	80	rpm
Injection instructions		

Melt residence time: 5 to 10 minsNozzle: open

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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