

CompaDur® 111 GK 20 natural (017)

Polybutylene Terephthalate

DimeLika Plast GmbH

Message:

PBT, Injection moulding grade, 20% glass beads, heat stabilized, balanced flow and strength, interior applications.

General Information			
Filler / Reinforcement	Glass beads, 20% filler by weight		
Additive	heat stabilizer		
Features	Good liquidity		
	Good strength		
	Thermal Stability		
Appearance	Natural color		
Processing Method	Injection molding		
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3600	MPa	ISO 527-2/1
Tensile Stress (Break)	60.0	MPa	ISO 527-2/50
Tensile Strain (Break)	5.0	%	ISO 527-2/50
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength (23°C)	20	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Melting Temperature ¹	223	°C	ISO 11357-3
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	250 - 265	°C	
Middle Temperature	250 - 265	°C	
Front Temperature	250 - 265	°C	
Nozzle Temperature	260 - 270	°C	
Processing (Melt) Temp	260 - 270	°C	
Mold Temperature	75.0 - 100	°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 mins Nozzle: open

NOTE

1. 10°C/min

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