

CompaDur® 121 GF 10 black (023)

Polybutylene Terephthalate

DimeLika Plast GmbH

Message:

PBT, injection molding grade, 10 % glass fiber, heat stabilized, excellent flow ability and strength, for interior applications.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 10% filler by weight		
Additive	heat stabilizer		
Features	Good liquidity		
	Good strength		
	Thermal Stability		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.38	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (250°C/2.16 kg)	19.0	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	4700	MPa	ISO 527-2/1
Tensile Stress (Yield)	95.0	MPa	ISO 527-2/5
Tensile Strain (Yield)	4.0	%	ISO 527-2/5
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 - 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 mins
Nozzle: open

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