

CompaDur® 121 natural (001)

Polybutylene Terephthalate

DimeLika Plast GmbH

Message:

PBT, injection molding grade, non-reinforced, high viscosity, easy release

General Information			
Features	Good demoulding performance		
	Viscosity, High		
Appearance	Natural color		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.30	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (250°C/2.16 kg)	38.0	cm³/10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2600	MPa	ISO 527-2/1
Tensile Stress (Yield)	60.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2/50
Yield	4.0	%	ISO 527-2/50
Fracture	35	%	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	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 minsNozzle: open

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