

# CompaDur® 125 GF 30 natural (016)

Polybutylene Terephthalate + PET

DimeLika Plast GmbH

## Message:

PBT / PET Blend, injection molding grade, 30% glass fibers, very good surface, high stiffness and strength.

| General Information                         |                                                       |                        |             |
|---------------------------------------------|-------------------------------------------------------|------------------------|-------------|
| Filler / Reinforcement                      | Glass fiber reinforced material, 30% filler by weight |                        |             |
| Features                                    | Rigidity, high                                        |                        |             |
|                                             | High strength                                         |                        |             |
|                                             | Excellent appearance                                  |                        |             |
| Appearance                                  | Natural color                                         |                        |             |
| Processing Method                           | Injection molding                                     |                        |             |
| Physical                                    | Nominal Value                                         | Unit                   | Test Method |
| Density (23°C)                              | 1.55                                                  | g/cm <sup>3</sup>      | ISO 1183    |
| Melt Volume-Flow Rate (MVR) (250°C/2.16 kg) | 14.0                                                  | cm <sup>3</sup> /10min | ISO 1133    |
| Mechanical                                  | Nominal Value                                         | Unit                   | Test Method |
| Tensile Modulus                             | 10500                                                 | MPa                    | ISO 527-2/1 |
| Tensile Stress (Break)                      | 155                                                   | MPa                    | ISO 527-2/5 |
| Tensile Strain (Break)                      | 2.5                                                   | %                      | 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 - 275                                             | °C                     |             |
| Middle Temperature                          | 250 - 275                                             | °C                     |             |
| Front Temperature                           | 250 - 275                                             | °C                     |             |
| Nozzle Temperature                          | 265 - 275                                             | °C                     |             |
| Processing (Melt) Temp                      | 265 - 275                                             | °C                     |             |
| Mold Temperature                            | 90.0 - 120                                            | °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                      |                                                       |                        |             |

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Melt residence time: 5 to 10 minsNozzle: open

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### 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

