

CompaDur® 151 black (021)

Polybutylene Terephthalate

DimeLika Plast GmbH

Message:

PBT, injection moulding, unfilled, high viscosity, easy mould realise, for indoor applications

General Information			
Features	Good demoulding performance		
	Viscosity, High		
Appearance	Black		
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)	20.0	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	> 6.0	%	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	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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