

CompaDur® 121 FR black (034)

Polybutylene Terephthalate

DimeLika Plast GmbH

Message:

PBT, injection molding grade, non-reinforced, flame retardant, heat stabilized, for exterior applications.

General Information			
Additive	heat stabilizer		
	Flame retardancy		
Features	Thermal Stability		
	Flame retardancy		
Uses	Outdoor application		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.45	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (250°C/2.16 kg)	18.0	cm³/10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3100	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	20	%	ISO 527-2/50
Flammability	Nominal Value	Test Method	
Flame Rating (0.800 mm)	V-0	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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Recommended distributors for this material

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

