

CompaDur® 121 GF 20 FR natural (012)

Polybutylene Terephthalate

DimeLika Plast GmbH

Message:

PBT, injection molding grade, 20% glass fiber, heat-stabilized, flame retardant, balanced flow -ability and strength

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Additive	heat stabilizer		
	Flame retardancy		
Features	Good liquidity		
	Good strength		
	Thermal Stability		
	Flame retardancy		
Appearance	Natural color		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.58	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (250°C/2.16 kg)	7.00	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8200	MPa	ISO 527-2/1
Tensile Stress (Break)	130	MPa	ISO 527-2/5
Tensile Strain (Break)	2.5	%	ISO 527-2/5
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 - 95.0	°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

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