

CompaDur® 121 GK 20 natural (008)

Polybutylene Terephthalate

DimeLika Plast GmbH

Message:

PBT, injection molding grade, 20% glass beads, heat stabilized, low warp, good surface

General Information			
Filler / Reinforcement	Glass beads, 20% filler by weight		
Additive	heat stabilizer		
Features	Low warpage		
	Thermal Stability		
	Excellent appearance		
Appearance	Natural color		
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)	22.0	cm³/10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3800	MPa	ISO 527-2/1
Tensile Stress (Break)	50.0	MPa	ISO 527-2/5
Tensile Strain (Break)	5.0	%	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 - 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 - 100	°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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