

Bio-Flex® F 6611

Biodegradable Polymers

FKuR Kunststoff GmbH

Message:

Bio-Flex® F 6611 Biodegradable compound for thermoforming.

General Information			
Features	Updatable resources		
	Biodegradable		
Forms	Particle		
Processing Method	cast film		
	Thermoforming		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.29	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	2.0 - 3.5	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	1.50 - 3.00	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2740	MPa	ISO 527-2
Tensile Stress			ISO 527-2
Yield	47.0	MPa	ISO 527-2
Fracture	19.0	MPa	ISO 527-2
Tensile Strain (Break)	22	%	ISO 527-2
Flexural Modulus	2840	MPa	ISO 178
Flexural Stress (3.5% Strain)	63.0	MPa	ISO 178
Tensile Strain at Tensile Strength	5.2	%	ISO 527
Flexural Strain at Break	No Break	%	ISO 178
Calendar Temperature Profile	20 - 50	°C	
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	7.2	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Melting Temperature (DSC)	150 - 170	°C	ISO 3146
Injection	Nominal Value	Unit	
Drying Temperature	60.0	°C	
Drying Time	2.0 - 4.0	hr	
Rear Temperature	150	°C	

Middle Temperature	160	°C
Front Temperature	175	°C
Nozzle Temperature	190	°C
Mold Temperature	25.0 - 40.0	°C

Injection instructions

Holding pressure level: 40 - 60%Melt cushion (of volume): < 10%Cooling time: 15 secmax. Dwell time: 300 sec

Extrusion	Nominal Value	Unit
Drying Temperature	60.0	°C
Drying Time	2.0 - 4.0	hr
Cylinder Zone 1 Temp.	170	°C
Cylinder Zone 2 Temp.	175	°C
Cylinder Zone 3 Temp.	180	°C
Cylinder Zone 4 Temp.	185	°C
Adapter Temperature	195	°C
Die Temperature	195	°C

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