

Bio-Flex® F 6513

Biodegradable Polymers

FKuR Kunststoff GmbH

Message:

Bio-Flex® F 6513 Biodegradable compound for injection moulding.

General Information			
Features	Updatable resources		
	Biodegradable		
Forms	Particle		
Processing Method	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)	3.5 - 5.5	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	3.00 - 5.00	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2600	MPa	ISO 527-2
Tensile Stress			ISO 527-2
Yield	46.0	MPa	ISO 527-2
Fracture	18.0	MPa	ISO 527-2
Tensile Strain (Break)	22	%	ISO 527-2
Flexural Modulus	2790	MPa	ISO 178
Flexural Stress (3.5% Strain)	63.0	MPa	ISO 178
Tensile Strain at Tensile Strength	4.8	%	ISO 527
Flexural Strain at Break	No Break	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	7.6	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

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