

Bio-Flex® F 1110

Biodegradable Polymers

FKuR Kunststoff GmbH

Message:

Bio-Flex® F 1110 (prev. Bio-Flex® 221 F)

Biodegradable compound for film extrusion

Compostable Compound according to EN 13 432, max. layer thickness 110µm

Certified according to: DIN Certco

Compound registration no.: 7W0087

General Information			
Features	Comstable		
	Updatable resources		
	Biodegradable		
Uses	Films		
Agency Ratings	EN 13432		
Forms	Particle		
Processing Method	Film extrusion		
Physical	Nominal Value	Unit	Test Method
Density	1.28	g/cm ³	ISO 1183
Apparent Density	0.76	g/cm ³	ISO 60
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	2.0 - 4.0	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	1.50 - 3.50	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	230	MPa	ISO 527-2
Tensile Stress (Yield)	16.0	MPa	ISO 527-2
Tensile Strain (Yield)	> 300	%	ISO 527-2
Flexural Modulus	215	MPa	ISO 178
Flexural Stress (3.5% Strain)	6.00	MPa	ISO 178
Tensile Elongation at Break	No Break		ISO 527
Flexural Strain at Break	No Break		ISO 178
Tensile fracture strength	No Break		ISO 527
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	No Break		ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	68.0	°C	ISO 306/A
Melting Temperature (DSC)	> 155	°C	ISO 3146
Extrusion	Nominal Value	Unit	

Drying Temperature	60.0	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	< 0.30	%
Cylinder Zone 1 Temp.	160	°C
Cylinder Zone 2 Temp.	160	°C
Cylinder Zone 3 Temp.	160	°C
Cylinder Zone 4 Temp.	160	°C
Adapter Temperature	165	°C
Melt Temperature	< 190	°C
Die Temperature	165	°C
Extrusion instructions		

Water jacket (feed): 35°C Die gap: 0.8 - 1.2 mm Die diameter: up to 400 mm Blow film ratio: 2.5 - 4

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