

Fibrolon® P 7550

Polyolefin

FKuR Kunststoff GmbH

Message:

Natural fibre reinforced compound for injection moulding.

General Information			
Filler / Reinforcement	Wood fiber, 50% filler by weight		
Physical	Nominal Value	Unit	Test Method
Density	1.03	g/cm ³	ISO 1183
Apparent Density	0.46	g/cm ³	ISO 60
Melt Mass-Flow Rate (MFR) (230°C/5.0 kg)	13 - 15	g/10 min	ISO 1133
Molding Shrinkage	0.30 - 0.40	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3250	MPa	ISO 527-2
Tensile Stress			ISO 527-2
Yield	22.0	MPa	ISO 527-2
Fracture	22.0	MPa	ISO 527-2
Tensile Strain (Break)	3.0	%	ISO 527-2
Flexural Modulus	3550	MPa	ISO 178
Flexural Stress (3.5% Strain)	32.0	MPa	ISO 178
Flexural Strain at Flexural Strength	4.0	%	ISO 178
Tensile Strain at Tensile Strength	3.0	%	ISO 527
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	3.3	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	7.9	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	139	°C	ISO 306/A
Melting Temperature (DSC)	150 - 180	°C	ISO 3146
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.30	%	
Rear Temperature	150	°C	
Middle Temperature	170	°C	
Front Temperature	190	°C	
Nozzle Temperature	200	°C	
Mold Temperature	30.0 - 50.0	°C	
Injection Pressure	200	MPa	
Injection Rate	Moderate		

Injection instructions

Holding Pressure Level: 50 to 80%Melt Cushion (of volume): <10%Cooling Time: 10 sec

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