

Bio-Flex® F 6510

Biodegradable Polymers

FKuR Kunststoff GmbH

Message:

Bio-Flex ® F 6510 (prev. Bio-Flex® 682CF)
Biodegradable compound for cast film extrusion made primarily from renewable resources.

General Information			
Features	Comstable		
	Updatable resources		
	Biodegradable		
	Compliance of Food Exposure		
Uses	Films		
	cast film		
Agency Ratings	EN 13432		
	European food contact, not rated		
Forms	Particle		
Processing Method	Film extrusion		
Physical	Nominal Value	Unit	Test Method
Density	1.30	g/cm³	ISO 1183
Apparent Density	0.80	g/cm³	ISO 60
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	2.5 - 4.5	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	2.50 - 4.50	cm³/10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2600	MPa	ISO 527-2
Tensile Stress			ISO 527-2
Yield	47.0	MPa	ISO 527-2
Fracture	23.0	MPa	ISO 527-2
Tensile Strain (Break)	19	%	ISO 527-2
Flexural Modulus	2650	MPa	ISO 178
Flexural Stress (3.5% Strain)	64.0	MPa	ISO 178
Tensile Strain at Tensile Strength	4.0	%	ISO 527
Flexural Strain at Break	No Break	%	ISO 178
Oxygen Permeability (20.0 µm)	1.1	cm³/m²/bar/24 hr	ISO 15105-2
Nitrogen Permeability (20.0 µm)	150	cm³/m²/bar/24 hr	DIN 53380-2
Films	Nominal Value	Unit	Test Method

Water Vapor Transmission Rate (20 μm)	130	g/m ² /24 hr	ISO 15106-3
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	7.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	60.0	°C	ISO 306/A
Melting Temperature (DSC)	150 - 170	°C	ISO 3146
Extrusion	Nominal Value	Unit	
Drying Temperature	60.0	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	< 0.20	%	
Cylinder Zone 1 Temp.	170	°C	
Cylinder Zone 2 Temp.	180	°C	
Cylinder Zone 3 Temp.	180	°C	
Cylinder Zone 4 Temp.	190	°C	
Adapter Temperature	190	°C	
Melt Temperature	< 190	°C	
Die Temperature	175 - 190	°C	
Extrusion instructions			
Water jacket (feed): 35°C			

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