

Biograde® C 9550

Cellulose Acetate

FKuR Kunststoff GmbH

Message:

Biodegradable compound for injection moulding made primarily from renewable resources.

Biograde® C 9550 (prev. Biograde® 300 A)

General Information			
Features	Comstable		
	Updatable resources		
	Biodegradable		
	Compliance of Food Exposure		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.67	g/cm ³	ISO 1183
Apparent Density	0.94	g/cm ³	ISO 60
Melt Mass-Flow Rate (MFR) (230°C/5.0 kg)	11 - 15	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (230°C/5.0 kg)	7.00 - 10.0	cm ³ /10min	ISO 1133
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	83		DIN 53505
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	4200	MPa	ISO 527-2
Tensile Stress			ISO 527-2
Yield	41.0	MPa	ISO 527-2
Fracture	41.0	MPa	ISO 527-2
Tensile Strain			ISO 527-2
Yield	6.0	%	ISO 527-2
Fracture	6.5	%	ISO 527-2
Flexural Modulus	4050	MPa	ISO 178
Flexural Stress (3.5% Strain)	63.0	MPa	ISO 178
Flexural Strain at Break	7.0	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	2.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength	37	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	118	°C	ISO 306/A
Melting Temperature (DSC)	> 180	°C	ISO 3146
Injection	Nominal Value	Unit	

Drying Temperature	60.0	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	0.20	%
Rear Temperature	160	°C
Middle Temperature	190	°C
Front Temperature	200	°C
Nozzle Temperature	205	°C
Mold Temperature	30.0 - 75.0	°C
Injection Rate	Fast	
Injection instructions		

Feeding zone: 60°C Holding pressure level: 50 to 80% Melt cushion (of volume): <10% Cooling time: 5s max. Dwell time: 300s

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