

Bio-Flex® F 1130

Polylactic Acid

FKuR Kunststoff GmbH

Message:

Biodegradable compound for film extrusion

Bio-Flex® F 1130 (prev. Bio-Flex® 219F)

General Information			
Features	Comstable		
	Biodegradable		
	Compliance of Food Exposure		
Uses	Films		
Agency Ratings	European food contact, not rated		
Forms	Particles		
Processing Method	Film extrusion		
Physical	Nominal Value	Unit	Test Method
Density	1.40	g/cm ³	ISO 1183
Apparent Density	0.83	g/cm ³	ISO 60
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	2.0 - 5.0	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	1.50 - 4.00	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	390	MPa	ISO 527-2
Tensile Stress (Yield)	17.0	MPa	ISO 527-2
Flexural Modulus	370	MPa	ISO 178
Flexural Stress (3.5% Strain)	9.00	MPa	ISO 178
Tensile Strain at Tensile Strength	> 300	%	ISO 527
Oxygen Permeability (45.0 µm)	850	cm ³ /m ² /bar/24 hr	ISO 15105-2
Nitrogen Permeability (45.0 µm)	160	cm ³ /m ² /bar/24 hr	DIN 53380-2
Films	Nominal Value	Unit	Test Method
Water Vapor Transmission Rate (45 µm)	70	g/m ² /24 hr	ISO 15106-3
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (24°C)	No Break		ISO 179/1eA
Charpy Unnotched Impact Strength (24°C)	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	89.0	°C	ISO 306/A
Melting Temperature (DSC)	> 155	°C	ISO 3146
Extrusion	Nominal Value	Unit	Test Method
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.	165	°C
Cylinder Zone 4 Temp.	170	°C
Adapter Temperature	170	°C
Melt Temperature	< 190	°C
Die Temperature	175	°C
Extrusion instructions		

Water jacket (feed): 35 [°C]Die gap: 0.8 - 1.4 mmDie diameter: up to 400 mmBlow film ratio: 2.5 - 4

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

