

Bio-Flex® F 5710

Polylactic Acid

FKuR Kunststoff GmbH

Message:

Biodegradable compound for film extrusion.

General Information			
Features	Comstable		
	Biodegradable		
Uses	Films		
	Bags		
Processing Method	Film extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.29	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	2.0 - 4.5	g/10 min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2130	MPa	ISO 527-2
Tensile Stress			ISO 527-2
Yield	37.0	MPa	ISO 527-2
Fracture	15.0	MPa	ISO 527-2
Tensile Strain (Break)	65	%	ISO 527-2
Flexural Modulus	2300	MPa	ISO 178
Flexural Stress (3.5% Strain)	51.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ¹	30	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength ²	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Melting Temperature (DSC)	150 - 170	°C	ISO 3146
Injection	Nominal Value	Unit	
Rear Temperature	150	°C	
Middle Temperature	160	°C	
Front Temperature	175	°C	
Nozzle Temperature	190	°C	
Mold Temperature	25 - 40	°C	
Holding Pressure	40.0 - 60.0	MPa	

Injection instructions		
Holding pressure level: 40 - 60 %Melt cushion (of volume): <10 %Cooling Time: 15 sec.max. Dwell time 300 sec.		
Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	160	°C
Cylinder Zone 2 Temp.	170	°C
Cylinder Zone 3 Temp.	175	°C
Cylinder Zone 4 Temp.	180	°C
Adapter Temperature	185	°C
Die Temperature	190	°C
NOTE		
1.	RT	
2.	RT	

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