

Biograde® C 5508

Biodegradable Polymers

FKuR Kunststoff GmbH

Message:

Biodegradable compound for injection moulding made partially from biobased resources

General Information			
Features	Biodegradable		
Processing Method	Film extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.27	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/5.0 kg)	18 - 25	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (230°C/5.0 kg)	16.0 - 22.0	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Transverse flow	0.85	%	ISO 294-4
Flow	0.39	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2460	MPa	ISO 527-2
Tensile Stress			ISO 527-2
Yield	55.0	MPa	ISO 527-2
Fracture	53.0	MPa	ISO 527-2
Tensile Strain (Break)	17	%	ISO 527-2
Flexural Modulus	2620	MPa	ISO 178
Flexural Stress (3.5% Strain)	62.0	MPa	ISO 178
Tensile Strain at Tensile Strength	7.0	%	ISO 527
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ¹	11	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength ²	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	107	°C	ISO 306/A
Melting Temperature (DSC)	> 180	°C	ISO 3146
Injection	Nominal Value	Unit	
Rear Temperature	190	°C	
Middle Temperature	190	°C	
Front Temperature	200	°C	
Nozzle Temperature	200 - 220	°C	
Mold Temperature	30 - 65	°C	

Injection instructions		
Feeding zone: 60 °CHolding pressure level: 40 - 80 %Melt cushion (of volume): <10 %Cooling time: 10 sec.Max. dwell time: 300 sec.		
Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	175	°C
Cylinder Zone 2 Temp.	180	°C
Cylinder Zone 3 Temp.	180	°C
Cylinder Zone 4 Temp.	185	°C
Extrusion instructions		
Feeding zone: 60 °CWide slot nozzle 190 - 200 °CCalender roll temperature: 20 65 °C		
NOTE		
1.	RT	
2.	RT	

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