

Bio-Flex® F 2110

Polylactic Acid
FKuR Kunststoff GmbH

Message:
Bio-Flex ® F 2110 (prev. Bio-Flex® 467F)
Biodegradable compound for film extrusion

General Information			
Features	Comstable		
	Biodegradable		
	Compliance of Food Exposure		
Uses	Films		
Agency Ratings	EN 13432		
	European food contact, not rated		
Forms	Particle		
Processing Method	Film extrusion		
Physical	Nominal Value	Unit	Test Method
Density	1.27	g/cm³	ISO 1183
Apparent Density	0.77	g/cm³	ISO 60
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	3.0 - 5.0	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	3.00 - 4.00	cm³/10min	ISO 1133
Moisture (30.0 µm)	130	g/m²/24 hr	ISO 15106-3
Flexural Strain at Break	No Break		ISO 178
Tensile fracture strength	No Break		ISO 527
Tensile fracture strain	No Break		ISO 527
Oxygen Permeability (30.0 µm)	1500	cm³/m²/bar/24 hr	ISO 15105-2
Nitrogen Permeability (30.0 µm)	230	cm³/m²/bar/24 hr	DIN 53380-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	730	MPa	ISO 527-2
Tensile Stress (Yield)	20.0	MPa	ISO 527-2
Tensile Strain (Yield)	> 300	%	ISO 527-2
Flexural Modulus	680	MPa	ISO 178
Flexural Stress (3.5% Strain)	17.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	83	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method

Vicat Softening Temperature	78.0	°C	ISO 306/A
Melting Temperature (DSC)	145 - 160	°C	ISO 3146
Extrusion	Nominal Value	Unit	
Drying Temperature	60.0	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	< 0.30	%	
Cylinder Zone 1 Temp.	170	°C	
Cylinder Zone 2 Temp.	170	°C	
Cylinder Zone 3 Temp.	170	°C	
Cylinder Zone 4 Temp.	175	°C	
Adapter Temperature	175	°C	
Melt Temperature	< 190	°C	
Die Temperature	175	°C	
Extrusion instructions			

Water jacket (feed): 35 °C Die gap: 0.8 - 1.4 mm Die diameter: up to 400 mm Blow film ratio: 2.5 - 4

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