

Fibrolon® P 8540

Polypropylene

FKuR Kunststoff GmbH

Message:

Fibrolon® P 8540 (prev. Fibrolon® 46 N)

Natural fibre reinforced compound for injection moulding

General Information			
Filler / Reinforcement	Wood fiber, 40% filler by weight		
Features	Updatable resources		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.05	g/cm ³	ISO 1183
Apparent Density	0.36	g/cm ³	ISO 60
Melt Mass-Flow Rate (MFR) (190°C/5.0 kg)	2.0 - 3.0	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (190°C/5.0 kg)	3.00 - 4.00	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3400	MPa	ISO 527-2
Tensile Stress			ISO 527-2
Yield	26.0	MPa	ISO 527-2
Fracture	24.0	MPa	ISO 527-2
Tensile Strain (Break)	4.5	%	ISO 527-2
Flexural Modulus	3500	MPa	ISO 178
Flexural Stress (3.5% Strain)	41.0	MPa	ISO 178
Tensile Strain at Tensile Strength	3.0	%	ISO 527
Flexural Strain at Break	6.0	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	3.6	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	11	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	155	°C	ISO 306/A
Melting Temperature (DSC)	160 - 180	°C	ISO 3146
Injection	Nominal Value	Unit	
Drying Temperature	60.0	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.30	%	
Rear Temperature	160	°C	
Middle Temperature	170	°C	
Front Temperature	180	°C	

Nozzle Temperature	180	°C
Processing (Melt) Temp	170	°C
Mold Temperature	30.0	°C
Injection Pressure	< 200	MPa
Injection Rate	Moderate	
Back Pressure	< 5.00	MPa

Injection instructions

Feeding zone: 150°C Cylinder kneeling temp: 140°C Screw peripheral velocity: up to 150 mm/s Holding pressure level: 40 to 70% Holding pressure time: 15 to 30 s Melt cushion (of volume): 3 to 10% Cooling time: 10 to 30 s

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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

