

Bio-Flex® F 2201 CL

Polylactic Acid

FKuR Kunststoff GmbH

Message:

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	1.25	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	8.0 - 10	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	7.00 - 9.50	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1150	MPa	ISO 527-2
Tensile Stress (Yield)	27.0	MPa	ISO 527-2
Flexural Modulus	1050	MPa	ISO 178
Flexural Stress (3.5% Strain)	28.0	MPa	ISO 178
Tensile Strain at Tensile Strength	> 400	%	ISO 527
Flexural Strain at Break	No Break		ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	12	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
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.	160	°C	
Cylinder Zone 2 Temp.	170	°C	

Cylinder Zone 3 Temp.	175	°C
Cylinder Zone 4 Temp.	180	°C
Adapter Temperature	180	°C
Melt Temperature	< 190	°C
Die Temperature	170 - 180	°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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