

Fibrolon® F 8530

Polylactic Acid

FKuR Kunststoff GmbH

Message:

Fibrolon® F 8530 (prev. Fibrolon® B 53 AW)

Biodegradable and natural fibre reinforced compound for injection moulding made primarily from renewable resources

General Information			
Filler / Reinforcement	Wood fiber, 30% filler by weight		
Features	Updatable resources		
	Biodegradable		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.10	g/cm ³	ISO 1183
Apparent Density	0.64	g/cm ³	ISO 60
Melt Mass-Flow Rate (MFR) (190°C/5.0 kg)	9.0 - 11	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (190°C/5.0 kg)	7.00 - 9.00	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3800	MPa	ISO 527-2
Tensile Stress			ISO 527-2
Yield	34.0	MPa	ISO 527-2
Fracture	34.0	MPa	ISO 527-2
Tensile Strain			ISO 527-2
Yield	3.4	%	ISO 527-2
Fracture	3.8	%	ISO 527-2
Flexural Modulus	3700	MPa	ISO 178
Flexural Strain at Break	3.0	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	4.8	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	12	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	72.0	°C	ISO 306/A
Melting Temperature (DSC)	150 - 160	°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 Shot volume 1 to 3 D [-]

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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

