

Processing advice

Product name: Terralene® WF 3516

Date of issue: September 9th 2014

Version: 1.1

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1. Designation of product, preparation and manufacturer

1.1 Trade name: Terralene® WF 3516

1.2 Description: High density polyethylene with narrow molar mass distribution, containing a low amount of wood fibers and functional additives. Recommended for the production of injection moulded articles.

1.3 Manufacturer: FKUR Kunststoff GmbH
Siemensring 79
D - 47 877 Willich
Phone: + 49 (0) 2154 / 92 51-0
Fax: + 49 (0) 2154 / 92 51-51
Mail: info@fkur.com
Web: www.fkur.com

2. Processing conditions for injection moulding

2.1 Machine equipment: Standard screw

| | | | |
|-----------------------|--------------------------|-------------|------------|
| 2.2 Machine settings: | Zone 1 | 170 | [°C] |
| | Zone 2 | 180 | [°C] |
| | Zone 3 | 190 | [°C] |
| | Machine nozzle | 195 | [°C] |
| | Mould temperature | 30 - 50 | [°C] |
| | Holding pressure level | 50 - 80 | [%] |
| | Melt cushion (of volume) | < 10 | [%] |
| | Cooling time | 15 | [s] |
| | max. Dwell time | 300 | [s] |
| | Density | 1.014 | [g/cm³] |
| | Bulk density | n/a | [kg/m³] |
| | MFR (190 °C/2.16 kg) | 13.0 - 16.5 | [g/10 min] |
| | Longitudinal shrinkage | 2.45 | [%] |
| | Latitudinal shrinkage | 1.39 | [%] |

2.3. General advice: We recommend cold runner systems.

3. Purging advice

3.1 Before production: Purge the plastification unit and, if existing, the hot runner with PE or purging compound.

3.2 During production: Heat tools and plastificator unit up to the recommended temperature. If tool is not filled, increase temperature stepwise.

3.3 After production: Purge the plastification unit and, if existing, the hot runner with PE or purging compound.

3.4 Important information: The dwell time of the material inside the machine shall be reduced to a minimum in order to lower the risk of pyrolysis.

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4. Drying conditions and storage

4.1 General:

Terralene[®] WF 3516 is a mainly biobased compound for injection moulding. Residual moisture content of more than 0.2 % can result in evaporation during the injection process or in condensed moisture on the mould.

4.2 Drying:

Drying is recommended at 70 °C for a period of 2 - 4 hours.

4.3 Storage conditions:

If not specified otherwise product shelf life is 6 months after shipment from Sellers warehouse if product is in its original packaging and stored under dry conditions (max. 70 % relative humidity) and normal room temperature or, if necessary, using air conditioning. Please keep in mind that a major drop in external air temperature (e.g. during transportation) can result in the development of water condensate. Prior to the processing of the material it should be ensured that there is no condensate on the packaged product.

4.4 Storage conditions for finished products:

Finished products made from Terralene[®] should be stored dry and cold. Storage time depends on processing parameters and on climate conditions in the respective area. FKUR Kunststoff GmbH cannot give any shelf life guarantees for finished goods. Please notice that the conditions mentioned above depend on experiences of our customers. We recommend that each customer executes individual storage tests according to his product specifications and storage requirements.

5. Legal notice

5.1 General:

Neither FKUR Kunststoff GmbH nor its marketing affiliates shall be responsible for the use of this information or of any product, method or equipment mentioned. Customers must undertake their own determination of this product's suitability and completeness for their own use, for the protection of the environment, for the health and safety of their employees and purchasers of their products. No warranty is made of the merchantability or fitness of any product, and nothing herein waives any of the seller's conditions of sale.