

Processing advice

Product name: Fibrolon® 3D Bamboo, Fibrolon® 3D Cork, Fibrolon® 3D Wood
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Designation of product, preparation and manufacturer

Trade name: Fibrolon® 3D Bamboo, Fibrolon® 3D Cork, Fibrolon® 3D Wood
Use of product: Biodegradable compound suitable for the production of 3D printing filaments. Contains natural fibers.
Manufacturer: FKUR Kunststoff GmbH
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Processing conditions for profile extrusion

Machine equipment: Standard polyolefin line.
Machine settings:

Feeding Zone	60	[°C]
Zone 1	160	[°C]
Zone 2	170	[°C]
Zone 3	180	[°C]
Zone 4	180	[°C]
Die	185	[°C]

Purging advice: profile extrusion

Before production: Ensure that all temperature zones work correctly. Purge the extruder with low viscosity PP or PE using the above temperature settings. Purging time: approximately 10 to 20 minutes. We recommend to change the screen before production.
During production: Heat extruder and nozzle to the recommended temperature. If melt is too viscous, increase temperature stepwise. Material has a tendency to degrade and therefore should not remain hot inside the machine for too long.
 Reduce the temperature of the die, if the melt stability is too low.
After production: Purge the extruder with high viscosity PP or PE. Do not allow material to remain hot inside the machine for extended periods as the material will degrade.

Drying conditions and storage

General: Fibrolon® is a biodegradable plastic based on PLA and other biopolymers. Moisture content can lead to hydrolysis. Residual moisture content of more than 0.2 % can result in fish eyes and/or pin holes during processing.
Drying: We recommend drying Fibrolon® at 60°C for a period of 2 - 4 hours.
Storage conditions: If not specified otherwise product life is 6 month after shipment from Sellers warehouse if product is in its original packaging, stored under dry (max. 70% relative humidity) and dark conditions (not exposed to sunlight at a temperature of 5 °C to max. 30°C (ambient temperature)). It is important to observe that a major drop in external air temperature (e.g. during transportation) can result in a development of water condensate. Prior to the processing of the material, it should be ensured that there is no condensate on the packaged product.
Storage conditions for finished products: Finished products made from Fibrolon® must be stored dry and cold. It is recommended to wrap goods in black PE liners to protect them against moisture and UV radiation. Storage time depends on processing parameters and of climate conditions in the respective area. Because of these essential and complex interacting parameters, FKUR Kunststoff GmbH cannot give any shelf life guarantees for finished products. Please notice that the conditions mentioned above depend on experience of our customers. Each customer should execute individual storage tests according to product specifications and storage requirements.

Legal notice

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