

## Processing advice

**Product name:** Bio-Flex® F 6514

Date of issue: 02 November 2016

Version: 1.0

### Designation of product, preparation and manufacturer

Trade name: Bio-Flex® F 6514

Use of product: Biodegradable polymer compound, suitable for injection moulding applications.

Manufacturer: FKUR Kunststoff GmbH  
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### Processing conditions for injection moulding

Machine equipment: Standard screw, open nozzle.

Machine settings:

Feeding Zone	60	[°C]
Zone 1	150	[°C]
Zone 2	160	[°C]
Zone 3	180	[°C]
Machine nozzle	190	[°C]
Mould temperature	30 - 65	[°C]
Holding pressure level	40 - 70	[%]
Melt cushion (of volume)	3 - 10	[%]
Cooling time	15	[s]
Max. dwell time	300	[s]

General advice: We recommend to use cold runner systems.  
Regrind sprues and runners can be reused at 20%.

### Purging advice: injection moulding

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

During production: Heat tools and plastification unit to the recommended temperature. If tool is not filled, increase temperature stepwise. Material has a tendency to degrade and therefore needs a constant melt flow.

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

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

### Drying conditions and storage

General: Bio-Flex® 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 Bio-Flex® 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 Bio-Flex® 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.

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### Legal notice

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Brand names:

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