

Technical data sheet

Product name: Bio-Flex® F 6510
Date of issue: 14 March 2018

Version: 4.1

Designation of product, preparation and manufacturer

Trade name: Bio-Flex® F 6510

Use of product: Biodegradable and compostable compound suitable for the production of cast films and production of injection moulding articles with higher wall thickness and short flowpath. The compound is certified compostable, according EN 13432, with a thickness up to 96 µm. The biobased carbon content (BCC) is > 70 % (calculated).

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Mechanical properties

Modulus of elasticity	2,600	[MPa]	ISO 527
Tensile strength	47	[MPa]	ISO 527
Tensile strain at tensile strength	4	[%]	ISO 527
Tensile stress at break	23	[MPa]	ISO 527
Tensile strain at break	19	[%]	ISO 527
Flexural modulus	2,650	[MPa]	ISO 178
Flexural strain at break	no break	[%]	ISO 178
Flexural stress at 3.5 % strain	64	[MPa]	ISO 178
Notched impact strength (Charpy), RT	7	[kJ/m²]	ISO 179-1/1 eA
Impact Strength (Charpy), RT	no break	[kJ/m²]	ISO 179-1/1 eU

The values listed have been established on standardized test specimens (DIN EN ISO 3167, type A) at standard temperature and humidity conditions.

Physical properties

Melt flow rate (190 °C/2.16 kg)	2.0 - 4.5	[g/10 min]	ISO 1133
Melt volume rate (190 °C/2.16 kg)	1.5 - 4.0	[cm³/10 min]	ISO 1133
Melting temperature	> 155	[°C]	ISO 3146-C
Vicat A softening temperature	60	[°C]	ISO 306
Density	1.30	[g/cm³]	ISO 1183
Shrinkage (Lengthwise / Crosswise)	0.29 / 0.32	[%]	ISO 294-4

Legal notice

The figures should be regarded as guide values only. Under certain conditions the properties can be influenced to a significant extent by the processing conditions.

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