

Technical data sheet

Product name: PP Homo Raffia White
Date of issue: 18 April 2023

Version: 1.1

Designation of product, preparation and manufacturer

Trade name: PP Homo Raffia White
Use of product: Post consumer recycled polypropylene suitable for injection moulding applications in various colour.

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Mechanical properties

Modulus of elasticity	1,270	[MPa]	ISO 527
Tensile strength	28	[MPa]	ISO 527
Tensile strain at tensile strength	9	[%]	ISO 527
Tensile stress at break	17	[MPa]	ISO 527
Tensile strain at break	150	[%]	ISO 527
Notched impact strength (Charpy), RT	2.1	[kJ/m ²]	ISO 179-1/1 eA
Impact Strength (Charpy), RT	70	[kJ/m ²]	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 (230 °C/2.16 kg)	17	[g/10 min]	ISO 1133
Melting temperature	160 - 180	[°C]	
Density	0.9	[g/cm ³]	ISO 1183

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.

Processing and Handling Information

General

This material is a post consumer recycled polyolefin. Due to its chemical structure, it should be handled and processed like standard polyolefins.

Drying

If packed in its original packaging and stored in good conditions drying is not necessary.
 If moisture uptake is too high the material can be dried at 60 °C for a period of 2 - 4 hours.

Storage

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.

Finished products shall 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 a shelf life guarantees for finished products cannot be given. Each customer should execute individual storage tests according to product specifications and storage requirements.

Processing conditions for injection moulding

Machine settings:	Feeding Zone	0	[°C]
	Zone 1	0	[°C]
	Zone 2	0	[°C]
	Zone 3	0	[°C]

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Machine nozzle	0	[°C]
Mould temperature	0	[°C]
Holding pressure level	0	[%]
Melt cushion (of volume)	0	[%]
Cooling time	0	[s]
Max. dwell time	0	[s]

General advice: Regrind sprues and runners can be reused at 20%.

Processing conditions for blown film extrusion

Machine settings:	Feeding Zone	0	[°C]
	Zone 1	0	[°C]
	Zone 2	0	[°C]
	Zone 3	0	[°C]
	Zone 4	0	[°C]
	Adapter	0	[°C]
	Die	0	[°C]
	Mass temperature	0	[°C]
	Die gap	0	[mm]
	Die diameter	0	[mm]
Blow up ratio	0	[-]	

General advice: Start at temperatures given above. If gel particles or die lines appear, increase temperature stepwise by 5°C.

Processing conditions for cast film extrusion

Machine settings:	Feeding Zone	0	[°C]
	Zone 1	0	[°C]
	Zone 2	0	[°C]
	Zone 3	0	[°C]
	Zone 4	0	[°C]
	Wide slot nozzle	0	[°C]
	Calender roll temperature	0	[°C]
	Mass temperature	0	[°C]

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