

Material Data Sheet

GC green 3071 MI T6 Food

Compound with 30 wt% natural fibers derived from sunflower seed hulls.

Fibers derived from sunflower seed hulls are a side product of sunflower oil production. They are GMO free, do not compete with the foodchain and do not require additional areal. Golden Compound green has a lower carbon footprint than the materials it is targeted to replace.

Mechanical Properties

<i>Property</i>	<i>Norm</i>	<i>Units</i>	<i>Value</i>
Density	ISO 1183	g/cm ³	1.3
MVR	ISO 1133 (190 °C/5 kg)	cm ³ /10 min	30
E-Modulus	ISO 527	MPa	1800
Tensile Strength	ISO 527	MPa	24
Elongation at break	ISO 527	%	4.0
Charpy unnotched _{23 °C}	ISO 179/1eU	kJ/m ²	15.0
Charpy notched _{23 °C}	ISO 179/1eA	kJ/m ²	3.2

Thermal Properties

HDT B	ISO 75-1 (0.45 MPa)	°C	90
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Permeability

Oxygen Permeability	ISO 15105-2	cm ³ /(m ² *d*bar)	30
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Processing Guidelines

Melt Temperature	°C	150 - 180
Mold Temperature	°C	20 - 60
Drying Temperature	°C	80
Drying Time	h	4
Moisture Content	%	0.04