

Material Data Sheet

GC green 1091 MI T6

Compound with 10 wt% natural fibers derived from sunflower seed hulls and wood with high flow for thin wall applications.

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.

Extrusion and thermoforming grade, biodegradable. We recommend purging the extruder with PE and then set up the temperatures stated below. We also recommend using a calender as the material tends to create a rough surface.

Mechanical Properties

<i>Property</i>	<i>Norm</i>	<i>Units</i>	<i>Value</i>
Density	ISO 1183	g/cm ³	1.26
MVR	ISO 1133 (190 °C/5 kg)	cm ³ /10 min	4
E-Modulus	ISO 527	MPa	1100
Tensile Strength	ISO 527	MPa	32
Elongation at break	ISO 527	%	13
Charpy unnotched 23 °C	ISO 179/1eU	kJ/m ²	35,1
Charpy notched 23 °C	ISO 179/1eA	kJ/m ²	5,6

Processing Guidelines

Melt Temperature	°C	170 - 190
Mold Temperature	°C	170 - 180
Drying Temperature	°C	80
Drying Time	h	4
Maximum Moisture Content	%	0.04