

## Material Data Sheet

GC green 3092 MIF

Compound with 30 wt% natural fibers derived from sunflower seed hulls. Certified with OK Biodegradable Soil.

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 <sup>3</sup>	1.3
MVR	ISO 1133 (190 °C/5 kg)	cm <sup>3</sup> /10 min	16
E-Modulus	ISO 527	MPa	880
Tensile Strength	ISO 527	MPa	15
Elongation at break	ISO 527	%	9.3
Charpy unnotched <sub>23 °C</sub>	ISO 179/1eU	kJ/m <sup>2</sup>	23.6
Charpy notched <sub>23 °C</sub>	ISO 179/1eA	kJ/m <sup>2</sup>	7.3

### Thermal Properties

HDT B	ISO 75-1 (0.45 MPa)	°C	60
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### Processing Guidelines

Melt Temperature	°C	150 - 170
Mold Temperature	°C	20 - 60
Drying Temperature	°C	80
Drying Time	h	4
Maximum Moisture Content	%	0.04

