

Material Data Sheet

GC green 1591 MI T6

Compound with 15 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.

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/5kg)	cm ³ /10min	12
E-Modulus	ISO 527	MPa	1250
Tensile Strength	ISO 527	MPa	31.5
Elongation at break	ISO 527	%	17
Charpy unnotched _{23°C}	ISO 179/1eU	kJ/m ²	32.6
Charpy notched _{23°C}	ISO 179/1eA	kJ/m ²	7.9

Processing Guidelines

Barrel Temperature	°C	150 - 190
Die Temperature	°C	150 - 180
Calender & Chill Roll	°C	50
Drying Temperatur	°C	80
Drying Time	h	4
Moisture Content	%	0.04

