

PRODUCT DATASHEET

## Starpulen CU 35BF4 NAT

**Description :** Starpulen CU35BF4 is a 35% Bamboo Fiber Reinforced Polypropylene copolymer Resin (advised for extrusion processing). (PRELIMINARY DATASHEET)

PROPERTY (1)	UNIT	STANDARD	VALUE Dry As Moulded
<b>MECHANICAL</b>			
Flexural Modulus	MPa	ISO 178	3100
Flexural Stress	MPa	ISO 178	66
Tensile Strain, break	%	ISO 527	2.7
Tensile Stress, yield	MPa	ISO 527	32
<b>IMPACT</b>			
Izod Impact, notched 80*10*4 +23°C	kJ/m <sup>2</sup>	ISO 180/1A	4,8
Izod Impact, unnotched 80*10*4 +23°C	kJ/m <sup>2</sup>	ISO 180/1U	12
<b>THERMAL</b>			
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	°C	ISO 75/Af	86
<b>PHYSICAL</b>			
Density	g/cm <sup>3</sup>	ASTM D 792	1.00
Melt Flow Rate (230°C / 2.16 kg)	g/10 min	ISO 1133	5
Mold Shrinkage, flow (4mm thickness)	%	E2P Method	0.5-0.7

Source LR3882

(1) Typical values, variations are possible for various colors.

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PRODUCT DATASHEET

## Starpylen CU 35BF4 NAT

**Description :** Starpylen CU35BF4 is a 35% Bamboo Fiber Reinforced Polypropylene copolymer Resin (advised for extrusion processing). (PRELIMINARY DATASHEET)

PARAMETER	Setting	Unit
Mold Temperature	30 - 50	°C
Rear - Zone 1 Temperature	185 - 195	°C
Middle - Zone 2 Temperature	185 - 195	°C
Front - Zone 3 Temperature	185 - 195	°C
Melt Temperature	185 - 195	°C
Drying Temperature	70	°C
Drying Time	3	hrs

PROCESSING PARAMETERS : see above typical molding conditions.

DRYING : is not essential when material is delivered in sealed bags with moisture content below 0.2 %.

BARRELS, SCREWS, MOULDS : use wear resisting steel or alloy such as bimetallic cylinders, nitrided screws.

USE OF REGRIND : the properties of the component should be checked in order to ascertain the maximum acceptable level of regrind.

SAFETY : please refer to Material Safety Datasheet.

Source LR3882

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