

Material Data Sheet

GC green 2012-91 MI T15

Compound with 20 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.

Material for extrusion of pipes and other semi-finished product. 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	1.4
MVR	ISO 1133 (190°C/5kg)	cm ³ /10min	4
E-Modulus	ISO 527	MPa	1470
Tensile Strength	ISO 527	MPa	31
Elongation at break	ISO 527	%	6.5
Charpy unnotched _{23°C}	ISO 179/1eU	kJ/m ²	18.5
Charpy notched _{23°C}	ISO 179/1eA	kJ/m ²	4.3

Processing Guidelines

Barrel Temperature	°C	150 - 180
Die Temperature	°C	150 - 180
Calender & Chill Roll	°C	50 - 60
Drying Temperatur	°C	80
Drying Time	h	4
Moisture Content	%	0.04

