

“NATURE 50” NP-FF PELLETS

DENSITY

Hemp / PP	1,04 kg / liter
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PROCESS PARAMETER

Hemp / PP	Extruder	Last zone until 175°C
	Hot runner Tool Temp.	175°C / 180°C 30°C - 80°C
Cycle time	identical to PC ABS GF 20	
Special	manual feeding for Pellets to Extruder	
Drying	80°C for 4h (one bag; 25 kg)	
For reducing smell after injection dry at 120°C for 2h.		

LABORATORY VALUES

	Hanf / PP (mean values of trials)
Dart impact strength +23°C	27,80 kJ/m ² -
Dart impact strength -30°C	23,80 kJ/m ² -
Density	1,04
E-Modul	3000 Mpa
Tensile strength	25,00 Mpa
Breaking elongation	3,20 %
Holding force for screws (required > 150N)	365 N
Smell (2h by 80°C in glass bottle) required < 3	2
Shrinkage	0,26 %
Combustion behaviour	GS97038 Set point: < 100 mm/min
i.O actual value	12 mm/min

PASSED ADDITIONAL TESTS:

- Bonding test with Aluminium
- Backmolding Hemp plats
- Colored Surface
- Colored Hemp Material

SAFETY INDICATION:

Hemp fibers are natural fibers. For temperatures over 195°C solvent evaporation will start. Over 200°C the material will be pyrolysed. For a longer production stop it is recommended to fill the extruder with PP. If the material is pyrolysed it is recommended to deplete the extruder and refill extruder with PP. The extended material is to fill in a metal box and if necessary clean up with water.