

TECHNICAL DATA SHEET
(Wood Plastic compound MFQ-WP02)

• **Product Description:**

Compound PP/Wood Flour (WPC-Wood plastic compound) containing between 30% and 45% of wood fillers. High Degree of fluidity for injection of parts with thicknesses even less than 3 mm; excellent overall balance of mechanical and thermal properties, high impact resistance.

• **Technical Properties:**

Specific gravity at 23 ° C	1	gr/cm ³	ISO 1183
MVR-Melt Volume Rate (190-10)	62	m ³ /10'	ISO 1133
Water absorption	< 1	%	D1037(ASTM)

• **Mechanical Properties:**

Flexural Modulus	2458	MPa	ISO 178/A/2
Flexural Yield strength	49	MPa	
Tensile Modulus	1421	MPa	ISO 527-2/1A/1
tensile Strength at break	28	MPa	
Elongation at break	6	%	
Charpy unnotched impact test at 23°	16	Kj/m ²	ISO 179-11eU

• **Suggested Condition:**

For drying process, it is recommended to keep the material at 75 ° C for at least 3 hours and subsequently to dehumidify it for 4-7 hours. For a better aesthetic appearance the moisture content before molding process must be less than 0.05 %, in order to avoid surface grain and flow marks due to possible residual moisture.

Molding suggested conditions: temperature of the press head at about 170/180° C temperature near the nozzle at 185-190 ° C, die temperature at 40-60 ° C, medium - high injection speed. It is recommended to maintain the temperature of the screw around 160/165 ° C because the fractioning material may overheat. Any temperature higher than 190/200 ° C could cause degradation, darkening or combustion of the wood flour.

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