

# **CORK COMPOUNDS**

## **Natural Cork for Thermoplastic Processing**

# Properties

Cork compounds consist of natural cork splinters which are integrated into different thermoplastic materials at high concentrations.

The finished or semi-finished products thus produced acquire a cork-like surface and possess a number of advantageous properties:

- pleasant haptics
- warm grip
- good damping behaviour
- very good abrasion resistance
- soft and flexible
- good UV stability

## Range of Products

<b>GODIFLEX TPE-S CORK</b> Thermoplastic Elastomer (based on SBS, SEBS)	<ul style="list-style-type: none"><li>■ cork content 30 - 40 %</li><li>■ excellent appearance</li><li>■ very good adhesion to PP</li><li>■ adjustable in 35 - 85 Shore A</li><li>■ foamable</li></ul>
<b>GODIFIN TPE-O CORK</b> Thermoplastic Polyolefin	<ul style="list-style-type: none"><li>■ cork content 30 - 40 %</li><li>■ excellent appearance</li><li>■ adjustable in 80 - 98 Shore A</li><li>■ foamable</li></ul>
<b>GODIPLAST PVC-P CORK</b> Polyvinylchloride plasticized	<ul style="list-style-type: none"><li>■ cork content 20 %</li><li>■ adjustable in 50 - 90 Shore A</li><li>■ foamable</li></ul>
<b>GODIPRENE TPE-U CORK</b> Thermoplastic Polyurethane	<ul style="list-style-type: none"><li>■ cork content 20 - 30 %</li><li>■ good abrasion resistance</li><li>■ adjustable in 55 - 80 Shore A</li><li>■ oil resistant</li><li>■ foamable</li></ul>

## Examples of Applications

- **Sports-/ Leisure Industry**  
Bicycle grips, ski pole grips, Nordic Walking pole grips
- **Shoe Industry**  
Shoe soles and beds
- **Furniture Industry**  
Panels, knobs, handles
- **Construction Industry**  
Profiles and boards
- **Other**  
Handles for irons, screw-driver grips

## Processing Instructions

Due to the compounding, only a low degree of humidity remains in the compound. This way, a pre-drying before procession is not necessary in the majority of the cases. As cork absorbs humidity, material from bags which have been open for quite a while should be pre-dried.

As a rule, cork compounds are carefully processed, i. e. with a low screw speed, minimum back pressure, slow injection speed. Temperatures from the feed section to the nozzle: 150°C, 170°C, 175-185°C, 175°C.

A slower injection is more favourable. The mould should only be filled under the injection moulding pressure so that the mould is only just filled. This way, cork will retain its typically bright colour.

When working regularly with cork compounds the tools should be protected from corrosion. During injection some water is always released which may corrode the surface of the tool. After manufacturing of cork moulds it is recommended to clean the tools.

An adjusted spreader opening at the tool is recommended. Depending on the size of the injection-moulded part, this opening should be between 1 and 2 mm. With parts of more than 200 g, the opening should be approx. 2.5 to 3.5 mm.

# Application technology service

The GODIPLAST application technology service provides you with advice and support with regard to:

- your choice of materials
- the construction of tools
- the optimisation of the processing conditions

## Contact

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The values stated are average values which can be changed due to many possible influences. A guarantee of the stated values can generally not therefore be given. They do not release the producer from the obligation of the suitability testing of the product for the respective usage purpose.