

A biodegradable polyester compound specifically designed for film extrusion, capable of producing both mono- and multilayer films. This innovative compound is certified by TÜV AUSTRIA Belgium according to the OK compost HOME standard (NF T51-800 [11-2015]).

Applications		Features	
Multilayer		Home-Compostable	
Monolayer		Biodegradable	
Film			
Bags			

Sustainability	
Bio-Based Content	100%
Compostability	Home Compostable

Physical Properties		
Density	1.28 g/cm ³	ISO 1183
Melt Volume Flow Rate	0.5 - 5 cm ³ /10min	ISO 1133

Film Properties			
Elongation at Break	390 %	ISO 527-3	Machine Direction
Elongation at Break	550 %	ISO 527-3	Transverse Direction
Film Thickness	18 - 31 µm		
Tear Strength	210 MPa	ISO 6383	Machine Direction
Tear Strength	240 MPa	ISO 6383	Transverse Direction
Tensile Modulus	170 MPa	ISO 527-3	Machine Direction
Tensile Modulus	120 MPa	ISO 527-3	Transverse Direction
Tensile Strength	19 MPa	ISO 527-3	Machine Direction
Tensile Strength	19 MPa	ISO 527-3	Transverse Direction

Processing Methods	
Film Extrusion	

Extrusion Parameters	
Cylinder Zone 1 Temp.	140 - 155 °C
Cylinder Zone 2 Temp.	145 - 155 °C
Cylinder Zone 3 Temp.	150 - 160 °C
Cylinder Zone 4 Temp.	155 - 165 °C
Die Temperature	150 - 170 °C
Transition	150 - 170 °C

Forms
Pellets

Notes

Safety precautions:

- Processing at a melt temperature not higher than 175 °C
- Processing with adequate ventilation

Handling:

- Delivered with ready-to-use moisture content
- Keep package sealed until use
- Reseal opened package directly after use

Drying:

- In case the product becomes too humid, drying at 80 °C for 4 h by using a vacuum dryer or purging with dry air (dew point -35 °C)
- Recommended humidity below 0.2 %

Start-up:

- Purge with polyolefin with MFR = 4-7 g/10 min for ~10 minutes
- Lower the temperature to recommended settings
- Start transition while purging when the temperatures are within 10 °C of desired range

Extrusion equipment:

- Designed for standard extrusion lines
- Die gap: 0.5–1.6 mm
- Dual-lip air ring recommended, also IBC if possible
- Chilled air supply leads to more stable bubble on higher output rates

Interruption & shut-down:

- Never leave product in the extruder for a longer period, e.g. over night
- By interruption for a considerable time, slow down screw speed to 5 rpm approx.
- For a longer period, please purge with same polyolefin from start-up procedure

Estimated Properties

Properties identified as 'Estimated**' have been estimated from the generic equivalent. These are provided for comparative purposes and are not reflective of the actual grade as the relevant data is not available.

Storage Recommendations

Keep dry at ambient temperature. Store indoors avoiding a humid environment, heat and direct sunlight. Use material within 6 months after delivery date, in order to prevent possible material quality deterioration.

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