

A biodegradable polyester compound specifically designed for injection moulding applications that demand transparency. Certified by TÜV AUSTRIA Belgium, meets the requirements of OK compost INDUSTRIAL (EN 13432) standards

Applications	Features
General Purpose	Biodegradable
Toys	Renewable Resource Content
Rigid Packaging	

Sustainability	
Bio-Based Content	100%
Compostability	Industrially Compostable

Physical Properties			
Density	1.24 g/cm <sup>3</sup>	ISO 1183	
Melt Volume Flow Rate	30 cm <sup>3</sup> /10min	ISO 1133	160 °C/5 kg

Mechanical Properties			
Charpy Impact Strength	2 kJ/m <sup>2</sup>	ISO 179-1/1eA	Notched
Tensile Elongation	2.3 %	ISO 527-1-2	At Yield
Tensile Elongation	3.8 %	ISO 527-1-2	At Break
Tensile Modulus	3500 MPa	ISO 527-1-2	
Tensile Strength	61 MPa	ISO 527-1-2	
Tensile Strength	61 MPa	ISO 527-1-2	At Yield

Thermal Properties		
Heat Distortion Temperature	50 - 115 °C	ISO 75/B

Processing Methods
Injection Moulding

Injection Parameters	
Drying Temperature	80 °C
Drying Time	4 hr
Mould Temperature	40 °C
Nozzle Temperature	195 - 205 °C
Zone 1	160 - 175 °C
Zone 2	175 - 185 °C
Zone 3	185 - 195 °C

Forms
Pellets

### Appearance

Clear/Transparent

### Notes

Safety precautions:

Processing at a melt temperature not higher than 230 °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 0.1 %

Start-up:

Purge with polyolefin with MFR = 30 g/10 min for ~10 minutes

Lower the temperature to recommended settings

Start transition while purging the screw, when the temperatures are within 10 °C of desired range

Equipment:

Designed for standard equipment

For some applications a mould release agent might be needed.

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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