

A biodegradable polyester compound for injection moulding.
Can be processed without problems on all commonly used machines
OK compost INDUSTRIAL (EN 13432, certified by TÜV AUSTRIA Belgium).

Applications	Features
Cutlery	Renewable Resource Content
Coffee Capsules	Food Contact Acceptable
	Compostable

Sustainability
Bio-Based Content 65%
Compostability Industrially Compostable

Physical Properties		
Density	1.44 g/cm ³	ISO 1183
Melt Volume Flow Rate	10 cm ³ /10min	ISO 1133

Mechanical Properties		
Charpy Impact Strength	50 kJ/m ²	ISO 179-1/1eU
Charpy Notched Impact Strength	4 kJ/m ²	ISO 179-1/1eA
Tensile Elongation	2 %	ISO 527-1-2 At Yield
Tensile Elongation	4.7 %	ISO 527-1-2 At Break
Tensile Modulus	4100 MPa	ISO 527-1-2
Tensile Strength	40 MPa	ISO 527-1-2
Tensile Strength	41 MPa	ISO 527-1-2 At Yield

Thermal Properties		
Heat Distortion Temperature	50 - 115 °C	ISO 75/B
Shrinkage	0.4 - 0.21 %	

Processing Methods
Injection Moulding

Injection Parameters	
Drying Temperature	80 °C
Drying Time	4 hr
Mould Temperature	40 °C
Nozzle Temperature	175 - 195 °C
Processing (Melt) Temp	230 °C
Zone 1	175 - 195 °C
Zone 2	175 - 195 °C
Zone 3	175 - 195 °C

Forms

Pellets

Notes

Safety precautions:

- Processing at a melt temperature not higher than 230 °C
- Processing with adequate ventilation

Handling:

- 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 best performance hot runners are recommended

Interruption & shut-down:

- Never leave the product in processing equipment for a long periods, 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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