

ECOPOND[®] Compostable Polyesters

D300 M40

Production Description

FEATURES	APPLICATIONS
<ul style="list-style-type: none"> Totally biodegradable, compostable Cost-effective 	<ul style="list-style-type: none"> Film making Bags

Typical Properties

Properties ^[1]	Test Method	Test Condition	S.I. Units	Values ^[2]
Granules				
Melt Flow Rate	ISO 1133	190 °C, 2.16 kg	g/10min	1.0-5.0
Specific Gravity	ISO 1183	23 °C	g/cm ³	1.5-1.7
Melt Point	DSC	-	°C	110-130
Film			Thickness:	18 µm
Tensile strength (MD/TD)	ISO 527	500 mm/min	MPa	13/6
Elongation at Break (MD/TD)	ISO 527	500 mm/min	%	180/400
Tear Strength (MD/TD)	ISO 6383-2	400 g	mN	800/2200
Dart Drop	ISO 7765-1	25 °C	g	180

[1] Tested with freshly blowing film, not to be construed as specifications.

[2] The listed values are measured by test specification and used for referential purpose only.

Quality Control

The melt flow rate, MFR, at 190 °C, 2.16 kg, according to ISO 1133 has been defined as specified parameter for quality control. A certificate can be provided with each lot number upon request. In order to obtain a high accuracy for the MFR measurement, the granules should be dried for 5 hours at 80 °C. Other data given in our literature are typical values, which are not part of our product specification.

Form Supplied and Storage

Temperatures during transportation and storage should not exceed 70 °C at any time. Storage time is not suggested to be over 12 months under proper conditions in an unopened bag, the product should be used as soon as possible when the package is opened.

Trade name	Net weight
D300 M40	25 kg/package
D300 M40D	900 kg/package

Processing Conditions

- Well packaged products can be used directly. If the package is damaged before use, the product should be dried prior to processing. Moisture levels above 1000 ppm may affect film-blowing operation;
- Effective drying takes place at 80°C for 5 hours.
- Processing parameters for blowing film:

Temperature zone		Set value ^[1]	Range
Melt Temperature		140°C	130-150°C
Barrel Zone Temperature	Rear	140°C	130-150°C
	Center	145°C	130-160°C
	Front	145°C	130-160°C
Die Head Temperature		140°C	130-150°C
Processing Temperature Limit		180°C	

[1] The data sheet is just for reference. In actual process, the parameter should be adjusted.

Safety Advice

Direct contact with the melting resin should be avoided during processing operations. The processing area should be well ventilated, as during processing the materials might emit fumes containing decomposing substances, which may be irritating. We recommends that clients should investigate the application demand of their products in advance to ensure proper use of this product, and feel free to contact with us for technical support when necessary.

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