

ECOPOND® Compostable Polyesters

G600 M35

Production Description

FEATURES	APPLICATIONS
<ul style="list-style-type: none"> • Biodegradable • Food contact 	<ul style="list-style-type: none"> • Excellent Property • Injection Molding

Typical Properties

Properties ^[1]	Test Method	Test Condition	S.I. Units	Values ^[2]
Granules				
Melt Flow Rate	ASTM D1238	190°C, 2.16kg	g/10min	11.0-17.0
Specific Gravity	ASTM D792	23°C	g/cm ³	1.4-1.7
Mechanical Properties				
Tensile Strength	ASTM D638	50 mm/min	MPa	28.4
Elongation	ASTM D638	50 mm/min	%	3
Flexural Strength	ASTM D790	2 mm/min	MPa	50.4
Flexural Modulus	ASTM D790	2 mm/min	MPa	300
Impact Strength, IZOD notched	ASTM D256	3.2 mm, 23°C	J/m	30.8

[1] The values of pigmented material may be different.

[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, 2.16Kg, according to ASTM D1238 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 4 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

Grade name	Form Supplied
G600 M35	25 kg/package

Temperatures during transportation and storage may not exceed 60°C at any time. Storage time in an unopened bag may not surpass 12 month at room temperature (23°C).

Processing Conditions for Injection

Setting		Start Point	Range
Melt Temp.		200℃	180-235℃
Barrel Zone Temp.	Rear	200℃	160-235℃
	Center	200℃	180-235℃
	Front	200℃	190-235℃
Processing Temp. Limit		235℃	
Injection Speed		Slow to Moderate	
Packing Time		6-16s	10s
Cooling time		3-14s	6s
Back Pressure		5-15MPa	
Pre-Dry Requirements		80℃, 4 h	

[1] The above values are only for the reference of injection molding machine. The above processes can be adjusted according to the models, molds and product requirements

[2] Cooling time is the time of cold molding

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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