

# Terratek® BD

**Product Description**

**Terratek® BD1216**

Terratek® BD resins are a proprietary blend of bio fillers, natural and synthetic biodegradable polymers. The resins are made with ingredients which pass industry standards for composting.

<u>Property</u>	<u>Test Method</u>	<u>Value</u>
Specific Gravity	ASTM D792	1.624 g/cm3
Shrinkage		0.009 in/in
Melt Index (190C 2.06kg)	ASTM D1238	65 g/10 min
Tensile Strength	ASTM D638	4,846 psi
Tensile Modulus	ASTM D638	414,338 psi
Flex Strength	ASTM D790	9,059 psi
Flex Modulus	ASTM D790	369,272 psi
Elongation		1.94 %
Notched Izod	ASTM D256	0.32 ft lb/in

**General Processing Conditions**

Terratek® BD1216 resin needs to be dried before processing if the moisture is above 0.1%. Resin will dry quickly at 150°F in a desiccant dryer, in approximately 2 to 4 hours. Avoid prolonged resin exposure to air during molding or storage as the material can pick up moisture.

Typical injection molding temperatures are listed below, these are only a guide and may need to be changed based on the particular application:

Rear	330°F to 350°F
Middle	340°F to 360°F
Front	340°F to 360°F
Nozzle	340°F to 360°F
Mold	60°F to 80°F

The melt temperature of the resin should remain below 400°F to prevent material degradation.

**Packaging and Storing**

Terratek® BD resin is typically packaged in a sealed plastic-lined Gaylord at 1200 lbs/Gaylord. The product should be stored in a cool, dry, and sanitary area to achieve maximum stability. Keep material in a sealed package or container to prevent excess moisture absorption.

The information and recommendations in this sheet are based on our experience and analysis using standard procedures, and are believed to be accurate and reliable. However, they serve merely as typical guides, and are presented in good faith for the benefit of our customers. No guarantee, expressed or implied, is made regarding accuracy of the analysis, patent infringement, liabilities, or risks involved from the application of our products.	Issued:	2/1/2018
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