

Terratek[®] BD

Product Description

Terratek[®] BD4015

Terratek[®] BD resins are a proprietary blend of natural and synthetic biodegradable polymers. The resins are made with ingredients which pass industry standards for composting. By altering the ratio of the natural to synthetic biodegradable polymers, a wide range of properties can be generated.

<u>Property</u>	<u>Value</u>
Melt Flow	8.8 g/10 min (190°C, 2.06kg)
Shrink rate	0.009 in/in.
Density	1.30 g/cm ³
Bulk Density	52 lbs/cubic ft.
Moisture	<1%
Tensile Strength (at yield)	2,700 psi
Impact Strength (notched)	0.93 ft-lb/in

General Processing Conditions

Terratek[®] BD resin needs to be dried before processing if the moisture is above 0.1%. Resin will dry quickly at 200°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.

For best molding results, larger gates and runners are recommended. The injection pressure required to fill the mold is much higher than typical injection molding grade plastics. 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 120°F

The melt temperature of the resin should remain below 400°F to prevent the material from discoloring and having a burnt odor.

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.

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:	8/22/12
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