

# Terratek<sup>®</sup> BD

**Product Description**

**Terratek<sup>®</sup> BD2114**

Terratek<sup>®</sup> 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	1.27 g/cm <sup>3</sup>
Shrinkage		0.012 in/in
Melt Index (190C 2.16kg)	ASTM D1238	8.0 g/10 min
Tensile Strength	ASTM D638	4,815 psi
Tensile Modulus	ASTM D638	429,531 psi
Flex Strength	ASTM D790	9,519 psi
Flex Modulus	ASTM D790	374,486 psi
Elongation		1.97 %
Notched Izod	ASTM D256	1.18 ft lb/in

**General Processing Conditions**

Terratek<sup>®</sup> BD2114 resin needs to be dried before processing if the moisture is above 0.1%. Resin will dry quickly at 130°F in a desiccant dryer, in approximately 2 to 4 hours. Pellets may become tacky if dried at temperatures above 140°F. 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	350°F to 360°F
Middle	350°F to 360°F
Front	360°F to 375°F
Nozzle	360°F to 375°F
Mold	60°F to 170°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<sup>®</sup> 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:	7/28/17
	Revised:	2/13/2018
	Approved:	R&D/QC