TECHNICAL DATA

Terratek® BD

Product Description

Terratek® BD5100

Terratek BD5100 is unique bioplastic featuring good impact resistance, tensile strength, and high gloss. It a biobased resin that will biodegrade in a composting environment.

Property	Value	Method
Specific Gravity	1.575	ASTM D792
Tensile Strength (maximum)	5,098 psi	ASTM D638
Tensile Modulus	236,000 psi	ASTM D638
Tensile Elongation	75%	ASTM D638
Flexural Strength	9,173 psi	ASTM D790
Flexural Modulus	231,133 psi	ASTM D790
Notched Izod	1.07 ft-lb/in	ASTM D256
Shrinkage	0.009 in/in	

General Processing Conditions

Terratek® BD5100 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 120°F

Packaging and Storing

Terratek® BD5100 resin is typically packaged in a sealed plastic-lined Gaylord box at 1200 lbs/box. The product should be stored in a cool, dry, and sanitary area to achieve maximum stability.

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