Terratek® Flex

GDH-B1FA

U.S. Patent No. 9,023,918

Sustainability Guide	
Biobased content	35%
Recycled content	0%
Energy use	4.21 Mj/kg
Compostable	yes

Product Description

Terratek® GDH-B1FA is a unique elastomeric bioplastic with a diverse range of potential applications. The bioplastic is verified to meet U.S. (ASTM D6400-04) and E.U. (EN13432) standards for compostability.

Applications

This material is suitable for injection molding, profile extrusion, sheet extrusion, blow molding, and blown film.

Processing Recommendations

Drying: Resin must be dried before processing.
Drying Conditions: Out of a sealed box: 90° to 100° F for 2 to 3 hours
Open box: 100° to 120° F for 4 to 5 hours

Suggested Temperature Settings:

Extruder Zone	Rear	Center	Front	Nozzle
Temperature °F	300°- 329°	300° - 329°	300° - 329°	300° - 329°

Processing at temperatures above 350° F and in combination with high shear conditions such as high injection speed may result in thermal degradation of this resin.

Specific recommendation for processing GDH-B1 can be made based on customer equipment and processes. For further suggestions, please contact Green Dot.

Property	Test Method	Value
Specific Gravity	ASTM D792	1.23 g/cm3
Hardness	ASTM 2240	83 Shore A
Izod Impact	ASTM D256	no break ft lb/in
Tensile Strength	ASTM D638	665 psi
Tensile Modulus	ASTM D638	3,350 psi
% Elongation	ASTM D790	300%
Flex Strength	ASTM D790	5,390 psi
Flex Modulus	ASTM D790	19,500 psi
Melt Index (190 C and 2160 g)	ASTM D1238	30.2 g/10 min
Shrink Rate	ASTM D955	flow direction .005 in/in trans flow direction .001 in/in

Packaging and Storing

Terratek® GDH-B1FA resin is typically packaged in a sealed plastic-lined fiber drum of 250 lbs. 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.

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