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:
<table>
<thead>
<tr>
<th>Extruder Zone</th>
<th>Rear</th>
<th>Center</th>
<th>Front</th>
<th>Nozzle</th>
</tr>
</thead>
<tbody>
<tr>
<td>Temperature °F</td>
<td>300° - 329°</td>
<td>300° - 329°</td>
<td>300° - 329°</td>
<td>300° - 329°</td>
</tr>
</tbody>
</table>

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 | ISO 1183-1 | 1.23
Hardness | ISO 868 | 74 Shore A
Tensile Strength (Ultimate) | ISO 37 | 9.4 MPa
Elastic Modulus | ISO 37 | 4.4 MPa
Elongation at Break | ISO 37 | >600%
Tear Strength | ISO 34-1 | 57 N/mm
MFI @ 190° C/2.2kg | ISO 1133 | 57 g/10min
Compress Set, 22 hrs @ 23°C | ISO 815/ASTM D395(B) | 33%
Compress Set, 22 hrs @ 70°C | ISO 815/ASTM D395(B) | 82%
Melt Flow | | 29.1 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.

Sustainability Guide

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Biobased content ASTM 6866</td>
<td>16%</td>
</tr>
<tr>
<td>Biobased content by weight</td>
<td>35%</td>
</tr>
<tr>
<td>Recycled content</td>
<td>0%</td>
</tr>
<tr>
<td>Energy use</td>
<td>4.21 Mj/kg</td>
</tr>
<tr>
<td>Compostable</td>
<td>yes</td>
</tr>
</tbody>
</table>