

Terratek® BD3018

Sustainability Guide	
Biobased content ASTM 6866	-
Biobased content by weight	-
Recycled content	-
Energy use	-
Compostable	-

Product Description

Terratek® BD3018 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 achieved.

Property	Test Method	Value
Specific Gravity	ASTM D792	1.312 g/cm ³
Shrinkage		0.008 in/in
Melt Index (190C; 2.16 kg)	ASTM D1238	9.0 g/10 min
Tensile Strength	ASTM D638	4,674 psi
Tensile Modulus	ASTM D638	307,990 psi
Elongation		2.59 %
Notched Izod	ASTM D256	0.49 ft lb/in
Flex Strength	ASTM D790	8,666 psi
Flex Modulus	ASTM D790	272,327 psi
Hardness	Shore D	D78

General Processing Recommendations

Green Dot's Terratek® BD3018 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 processing 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	310°F to 360°F
Middle	320°F to 360°F
Front	320°F to 360°F
Nozzle	320°F to 360°F
Mold	40°F to 95°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® BD3018 resin is typically packaged in a sealed plastic-lined Gaylord at 1200 lbs/Gaylord or 250 lbs fiber drums. 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:	2/1/2018
	Revised:	2/3/21
	Approved:	R&D/QC