Terratek® BD

BD5175

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

Product Description

Terratek® BD5175 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 generated.

Property	Test Method	Value
Specific Gravity	ASTM D792	1.23
Shrinkage (48 hrs)	ASTM D955	0.00948 in/in (parallel)
Shrinkage (48 hrs)	ASTM D955	0.00420 in/in (perpendicular)
Melt Index (2.16 kg; 190° C)	ASTM D1238	38.6 g/10 min
Tensile Strength	ASTM D638	5,589.9 psi
Tensile Modulus	ASTM D638	194,363.4 psi
Elongation		158.5 %
Notched Izod	ASTM D256	25.54 ft lb/in
Flex Strength	ASTM D790	7,156.3 psi
Flex Modulus	ASTM D790	186,325.4 psi

General Processing Recommendations

Green Dot's Terratek® BD5175 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® BD5175 resin is typically packaged in a sealed plastic-lined Gaylord at 1200 lbs/Gaylord or 250 lbs fiber drum. The product should be stored in a cool, dry, and sanitary area to achieve maximum stability.

Issued: 10/16/19
Revised: 2/3/21
Approved: R&D/QC