

**TECHNICAL DATA SHEET****Product Name: CGTECH-BCR-THERM-HS-COMP****Product Description: The properties below are typical of our compostable resins intended for blowing film, extrusion, and thermoforming.**

Physical Properties	Typical Values*	Test Method
Melt Flow Index	6.5g/10min@190°C,2.16Kg	ISO 1133
Tensile Elongation at Break MD/TD	250%/450%	ISO 527

Note: *Values provided are typical and should not be interpreted as product specification.

The results reported are typical with the caveat that due to variable processing methods and conditions, no guarantees or warranties are expressed or implied, including expressions of fitness for purpose or merchantability.

This is a patent pending formulation.

Suggested Processing Guidelines**Drying of Resin:**

Dry down to 0.1% at 90°C in desiccant dryer with -40°C dew point of air – should take 4 hours based on our supplied resin at moisture content of 0.5%. (Please check incoming moisture to verify).

Processing:

Melt Temperature: 130°C-140°C

Barrel temperature: 125°C-135°C at rear, 130°C-140°C at Center, 125°C-135°C at Front

Die Head Temp: 130°C-140°C

Processing Temp: Lower than 180°C

Caution:

Resin should not sit in the manifold or the barrel for more than three minutes at elevated temperatures. If any resin has sat for more than this time, please purge.

Because of resin shrinkage, being 0.13%, molding should be done in molds specifically made using the mold flow analysis (MFA) of our resin and the .UDB file. Using a mold intended for higher shrinkage resin like fossil polymer polypropylene for example, can result in an oversized part, and could pose ejection related issues.

Cooling cycle reduction advantage may not be realized when using our resin in a mold not designed for our compostable bio-composite barrier resin's shrinkage.

Rev. [2]
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