

FEATURES

- 40% Thermoplastic Starch (biodegradable according to **ISO 20200:2015***)
- Easy to Process
- Lower Processing Temperatures
- FDA Compliant

APPLICATIONS

- Extrusion-thermoforming and Injection-Molding Applications
- Cutlery
- Cups
- Containers

PROPERTIES

Physical	English	Value	Metric	Value	Test Method
Melt Flow Rate (200°C/5.0 Kg)	g/10 min	7.0	g/10 min	7.0	ASTM D1238
Melt Flow Rate (230°C/2.16 Kg)	g/10 min	9.0	g/10 min	9.0	ASTM D1238
Density	lb/ft ³	74	g/cm ³	1.2	ASTM D792
Mechanical					
Tensile Strength, Break	Psi	1,800	MPa	12	ASTM D638
Break Elongation	%	3	%	3	ASTM D638
Flexural Modulus	Kpsi	200	MPa	1,380	ASTM D638
Impact					
Notched Izod (0.125 in / 3.175 mm)	ft-lbf/in	0.4	J/m	21	ASTM D256

Properties reported in this data sheet are determined according to referred standard methods. Values shown represent averages from typical results measured in the laboratory and are provided only as a guide, not as specification limits.

INJECTION MOLDING CONDITIONS
EXTRUSION CONDITIONS

	°C	°F		°C	°F
Rear	170-180	340-360	Rear	160-170	320-340
Center	180-190	360-375	Center	175-185	347-365
Front	190-200	375-392	Front	190-200	375-392
Maximum Recommended	220	410	Maximum Recommended	220	410

ADDITIONAL INFORMATION

This product presents a very low moisture absorption and it is a common practice to process it without pre-drying; however, if it has been exposed to high humidity or in direct contact with water, it is recommended to dry it for 2 hours at 140°F (60°C). Resirene's materials are biological and chemically inert. If possible recycling of final parts is recommended. If you require dispose it, follow indications established by government laws, related norms and the material safety data sheet.

Warning

Combustion of this material may cause hazardous fumes and gases that may be dangerous to health, especially in enclosed places. It should be noted that excessive heating or long residence times may cause degradation or yellowing.

Note:

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* **ISO 20200:2015:** Plastics -- Determination of the degree of disintegration of plastic materials under simulated composting conditions in a laboratory-scale test