

Production Description**FEATURES**

- 100% Compostable & Biodegradable
- Food Contact
- Excellent Mechanical Properties

APPLICATIONS

- Spoons
- Forks
- Knives
- Stirrers

Typical Properties

Properties	Test Method	S.I. Units	General Purpose	High Melt Flow	High Heat
			Values		
Tensile Strength	ISO527-1	MPa	45	50	50
Tensile Modulus	ISO527-1	MPa	3500	3500	3500
Elongation at Break	ISO527-1	%	≤ 5	≤ 5	≤ 5
Charpy notched Impact, 23°C	ISO 179-1eA	KJ/m ²	≤ 5	≤ 5	≤ 5
Melting Temperature	DSC	°C	155	175	175
Glass Transition Temperature	DSC	°C	60	60	60
Density	ISO1183	g/cm ³	1.24	1.24	1.24
Melt Flow Rate (190°C/2.16 Kg)	ISO1133-A	g/10min	3	30	3
Melt Flow Rate 210°C/2.16 Kg)	ISO1133-A	g/10min	6	70	8

[1] Not to be construed as specifications.

[2] The listed values are measured by test specification and used for referential purpose only.

Storage Conditions:

Temperatures during transportation and storage may not exceed 70°C at any time. Storage time in an unopened bag may not surpass 12 month at room temperature (23°C).

Processing Information & Recommendations:

ADFLEX FT5 grades can be processed on a conventional injection molding machines.

Processing Conditions:

Feed Zone - 20-40°C
 Melt Zone - 180-190°C
 Mixing & Conveying - 190-210°C
 Die Head Temperature - 190-210°C

Startup and Shutdown:

Before introducing ADFLEX FT5, machine needs to be well cleaned and purged to prevent cross contamination. Purging procedure to be followed, with respect to material change and processing temperature.

Drying Conditions:

Resins can be dried using most conventional drying systems. The preferred method to dry ADFLEX FT5 is by using a desiccant hot air dryer system. Another option is to use a vacuum drying oven.
 Ideal air temperature for drying 85°C - (It should be dried for 4hour)

Form Supplied:

25Kg/Package

Notice:

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