

**Production Description:****FEATURES**

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

**APPLICATIONS**

- Glasses
- Cups
- Trays
- Plates

**Typical Properties**

Properties	Test Method	S.I. Units	Clear	Clear	Opaque	Opaque
			General Purpose	High Heat	General Purpose	High Heat
Values						
Tensile Strength	ISO527-1	Mpa	45	50	45	50
Tensile Modulus	ISO527-1	Mpa	3500	3500	3500	3500
Elongation at Break	ISO527-1	%	≤ 5	≤ 5	≤ 5	≤ 5
Charpy notched Impact, 23°C	ISO 179-1eA	KJ/m <sup>2</sup>	≤ 5	≤ 5	≤ 5	≤ 5
Melting Temperature	DSC	°C	155	175	160	180
Glass Transition Temperature	DSC	°C	60	60	60	60
Density	ISO1183	g/cm <sup>3</sup>	1.24	1.24	1.35	1.35
Melt Flow Rate (190°C/2.16 Kg)	ISO1133-A	g/10min	3	3	5 ~ 6	5 ~ 6
Melt Flow Rate 210°C/2.16 Kg)	ISO1133-A	g/10min	6	8	9 ~ 10	9 ~ 10
Moisture Content	Coulometric Karl Fischer	ppm	≤ 400	≤ 400	≤ 500	≤ 500
Heat Deflection Temperature Amorphous	ISO75-1	°C	60	60	65	65
Heat Deflection Temperature Crystalline	ISO75-1	°C	-	105	-	105

[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 FT 6 grades can be processed on a conventional extrusion machines. The recommended general purpose screw with L/D ratio between 24 and 32.

**Processing Conditions:**

Feed Zone - 20-40°C

Melt Zone - 180-190°C

Mixing &amp; Conveying - 190-210°C

Die Head Temperature - 190-210°C

**Startup and Shutdown:**

Before introducing ADFLEX FT6, 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 FT 6 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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