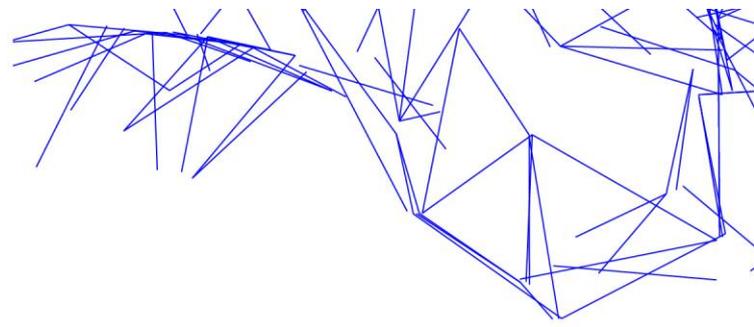


EarthBi



PRODUCT DATA SHEET

EarthBi IM 502

DESCRIPTION

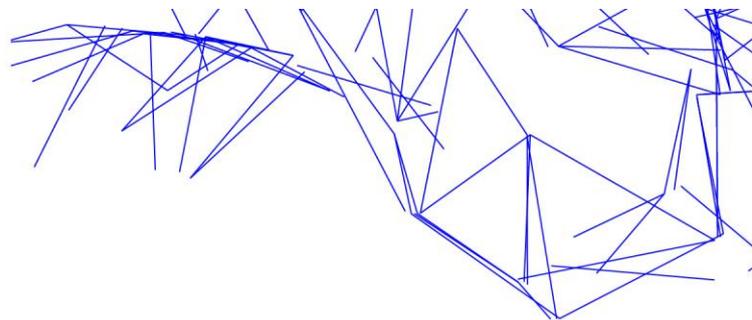
EarthBi is a bio based polymer derived from natural resources and belonging to the PLA family. As other bio based polymers EarthBi offers a significant reduction in carbon footprint compared to oil-based plastics.

EarthBi IM 502 is a grade for injection moulding applications when is required less cristallinity or amorphous applications. It shows good melt flow properties, low cristallinity, medium molecular weight and medium melting temperature. Suitable for stretch-blow-molding application.

PROCESSING INFORMATION

EarthBi polymers can be processed on conventional injection moulding machines. PLA polymers are quite sensitive to thermal degradation that means they needs to minimize the residence time at high temperature . Screw with a L/D ratio of 20:1 can be sufficient for general purpose. Pre-drying is always recommended.

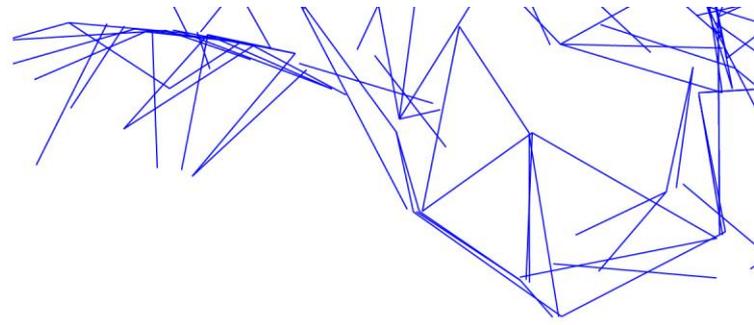




<u>Physical Properties</u>	<u>Method</u>	<u>Typical Value</u>
Shape		Round pellets
Yellowness Index	ASTM D6290	<10
Density (g/ml)	ISO 1183	1,25±10%
Glass Transition (°C)	DSC	60±5
Residual monomer (%w/w)	Gas Chrom.	<0,3
Moisture (ppm)	Karl-Fisher	<250
MFI 2,16 Kg/190°C (g/10')	ISO 1133-1	22±7
D-isomer (%)	Gas Chrom.	5
Melting Point (°C)	DSC,onset	153
Crystallinity (%)	DSC	20-25
<u>Mechanical Properties</u>	<u>Method</u>	<u>Typical Value</u>
Tensile modulus (MPa)	ISO 527-1	3500
Tensile strength (MPa)	ISO 527-1	50
Elongation at break (%)	ISO 527-1	≤5%
Hot deflection temp, amorph. (°C)	ISO 75-1	55-60
Hot deflection temp, crystalline (°C)	ISO 75-1	100-110

PROCESSING SUGGESTIONS

Predrying	4-6 hours at 100°C
Throat	20-40°C
Feed zone	155-175 °C
Compression zone	180-220 °c
Metering zone	180-220 °c
Tmelt	180-210 °C
Back pressure	50-100 bar



MOISTURE & PRE-DRYING

It is recommended to dry EarthBi IM 502, as all the polymers PLA based, from the packaging for 4-6 hours at 80-100°C. Drying of semicrystalline PLA homopolymer can be performed in a hot air dryer, air with a dew point of -40°C or less. It is recommended to reduce the moisture content before melt processing to a level less than 250ppm and preferably less than 100 ppm, measured by e.g. Karl-Fischer. Predrying is important essentially to convert the pellets by injection molding, film and sheet production. Moisture causes hydrolysis of the PLA polymers in the molten state, resulting in reduced molecular weight and poor mechanical performance in the final part.

PACKAGING & STORAGE CONDITIONS

EarthBi IM 502 is available in 700 kg aluminum-lined octabins and on request in 20 Kg aluminum-lined boxes. It is recommended to store PLA polymers in its closed, original moisture barrier packaging at temperatures below 50°C. Storage in direct sunlight should be avoided. The supplied PLA polymer pellets are typically semi-crystalline, unless otherwise reported.