

TECHNICAL DATA SHEET

ENVIPLAST® WR PELLETT

DESCRIPTION : Starch bio-based composite
APPLICATION : Blown film
DEGRADATION TIME AFTER DISPOSAL : 3 - 6 months (after disposal)

PHYSICAL PROPERTIES	METHOD	UNIT	VALUE
Appearance	Visual	-	Creamish pellet
Density	ASTM D792	g/cm ³	1.2 - 1.3
Melt Flow Index (190 °C / 2.16 kg)	ASTM D1238	g/10 min	4.0 - 9.0
Moisture Content	Internal Method	%	Max. 1.0

PROCESSING GUIDE	METHOD	UNIT	VALUE
Zone 1 Temperature*	Internal Method	°C	130 - 135
Zone 2 Temperature*	Internal Method	°C	140 - 150
Zone 3 Temperature*	Internal Method	°C	140 - 150
Adaptor Temperature*	Internal Method	°C	140 - 145
Joint Temperature*	Internal Method	°C	130 - 135
Dies Temperature*	Internal Method	°C	110 - 115
Pre-drying Temperature	Internal Method	°C	65 - 75
Pre-drying Time	Internal Method	hours	1 - 2

*Diameter screw : 55 cm, L/D 36

Packaging : ENVIPLAST® WR is supplied in pellet form, in 25 kgs double layered bags, consisting of plastic PE bag as inner layer and PP woven laminated paper bag as outer layer. Store in a cool dry place to prevent contamination and moisture absorption.

These suggestion and data are based on information we believe to be reliable. They are offered in good faith, but without guarantee, as conditions and methods of utilization of our products are beyond our control. We recommend that the prospective user determine the suitability of our materials and suggestions before adopting them on a commercial scale.

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