

Ruian Gregeo GPM3 M30

Biodegradable PBAT Composite

- 1.1 Product Name:** PBAT Composite
1.2 Product Features: Biodegradable; Industrial compostable
1.3 Typical Application: Packaging film
1.4 Form: Granules, 25 kg / bag or 800 kg / bag
2. Mechanical Properties

Film Thickness 30 um			
Properties ^[1]	Test Method	Units	Values ^[2]
Granule Density	ISO 1188	g/cm ³	1.48
MFR (190℃,2160g)	ISO 1133	g/10min	1.42
Tensile Strength MD/TD	ISO 527-3	MPa	33/22
Elongation at Break MD/TD	ISO 527-3	%	340/890
Tear Strength	ASTM D 1922	N/mm	79
Dart Drop	ISO 7765	g	210
Safe Load-Bearing	-	kg	5.5

[1] Not to be construed as specifications.

[2] The values are measured by test standards listed, which may vary depending on different processing methods and conditions, are for reference only and should not be construed as indicators of quality.

3. Recommendations for Use

GPM 3 M30 is a calcium carbonate-based biodegradable blown film material. Moisture can cause hydrolysis of the material, and residual moisture above 200 ppm can lead to defects such as fish eyes during processing.

4. Transportation and Storage

Transport and storage temperatures should not exceed 60° C. The product should be stored in a dry, well-ventilated warehouse, pay attention to moisture-proof, avoid contact with soil, water, etc. Shelf life is 6 months at an ambient temperature of 23° C.

The product can be used directly if the package is intact. If damaged, it needs to be dried before use, because moisture above 200ppm will affect the process; the effective drying condition is 80° C for 2 hours. The dried product should be treated with moisture and be used as soon as possible after opening.

5. Blown film processing parameter recommendations

Setting		Start Point	Range
Melting Temperature		115℃	100-120℃
Heating Temperature of Blowing Film	Posterior Segment	140℃	135-145℃
	Middle Segment	140℃	135-145℃
	Anterior Segment	150℃	145-150℃
Die Temperature		160℃	150-165℃
Processing Temperature Limit		185℃	
Pre-drying Conditions		80℃, 2 hours	



Statement

All information provided herein is based on the current knowledge and experience of Ruian biodegradable polyester. The version will be updated when necessary. All information is only for customers' reference in material selection and evaluation, and is not used as the basis for judging product quality

