

Rui'an Gregeo GPM3 M35B

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 25 um | | | |
|---------------------------|-------------|-------------------|-----------------------|
| Properties ^[1] | Test Method | Units | Values ^[2] |
| Granule Density | ISO 1188 | g/cm ³ | 1.52 |
| MFR (190°C,2160g) | ISO 1133 | g/10min | 1.42 |
| Tensile Strength MD/TD | ISO 527-3 | MPa | 19/24 |
| Elongation at Break MD/TD | ISO 527-3 | % | 780/508 |
| Tear Strength | ASTM D 1922 | N/mm | 60 |
| Dart Drop | ISO 7765 | g | 275 |
| Safe Load-Bearing | - | kg | 4.5 |

[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 M35B 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°C | 100-120°C |
| Heating Temperature of Blowing Film | Posterior Segment | 140°C |
| | Middle Segment | 140°C |
| | Anterior Segment | 150°C |
| Die Temperature | 160°C | 150-165°C |
| Processing Temperature Limit | 185°C | |
| Pre-drying Conditions | 80°C, 2 hours | |



Statement

All information provided herein is based on the current knowledge and experience of Rui'an 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.

