

M-VERA® F4003 (B0270)

Preliminary technical description

Product description

M-VERA® F4003 (B0270):	Biodegradable polyester compound
Applications:	Additive manufacturing etc.
Suitable for:	Extrusion technology
Certification:	OK compost INDUSTRIAL (EN 13432, certified by TÜV AUSTRIA Belgium) possible

Properties

	Standard	Unit	F4003 (B0270)
MVR 190 °C/2.16 kg	ISO 1133	cm ³ /10 min	2–5
Density	ISO 1183	g/cm ³	1.43
Biobased carbon content*	-	%	~70
Appearance	-	-	grey
Tensile modulus	ISO 527-1/-2	MPa	2,600
Tensile strength	ISO 527-1/-2	MPa	30
Elongation at break	ISO 527-1/-2	%	30

* Calculated according ISO 16620; TC

The information given here is only valid for M-VERA® grades in their original packaging, sold by BIO-FED® and/or its authorized partners. If M-VERA® grades are mixed in any capacity with foreign material, beside masterbatches recommended by BIO-FED®, BIO-FED® declines any further responsibility. M-VERA® grades shall be stored in dry, closed rooms in closed packaging in original state. For keeping the product properties, the material must be protected against direct sun and the temperature must not exceed 50 °C at any time during transport and storage. M-VERA® grades have a remaining shelf life of six (6) months at room temperature (23 °C) from the delivery date. We recommend that products made of M-VERA® grades shall be stored under same conditions. All M-VERA® products listed here can be colored with AF-Eco® masterbatches from AF-COLOR, also certified according to EN 13432. Please note that the use of AF-Eco® might influence the mechanical and/or optical properties of the final part.

The information contained herein is based on our current knowledge and experience. A legally binding promise of certain characteristics or suitability for a concrete individual case cannot be derived from this information. The information supplied here is not intended to release processors and users from the responsibility of carrying out their own tests and inspections in each concrete individual case. BIO-FED®, M-VERA® and AF-Eco® are registered brands of AKRO-PLASTIC GmbH.



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Preliminary processing guide

Processing recommendations

Safety precautions:

- Processing at a melt temperature not higher than 220 °C
- Processing with adequate ventilation

Handling:

- Delivered ready-to-use
- Keep package sealed until use
- Reseal opened package of the M-VERA® product directly after use

Drying:

- In case the M-VERA® product becomes too humid, drying at 80 °C for 4 h by using a vacuum dryer or purging with dry air (dew point -35 °C)
- Recommended humidity below 0.1 %

Delivery & storage:

- Supply in 20 kg foil-aluminium bags or 1 ton octabin with PE-inliner
- To be stored in dry place, protected from heat and direct sun radiation

Start-up:

- Purge with polyolefin with MFR = 6 g/10 min for ~10 minutes
- Adjust the temperature to recommended settings
- Start transition while purging the screw, when the temperatures are within 10 °C of desired range

Extrusion equipment:

- M-VERA® grades are designed for standard extrusion equipment

Interruption & shut-down:

- Never leave M-VERA® product in the extruder for a longer period, e.g. over night
- By interruption for a considerable time, slow down screw speed to 5 rpm approx.
- For a longer period, please purge with same polyolefin from start-up procedure

Processing temperatures

Grade	Die	Zone 4	Zone 3	Zone 2	Zone 1
F4003 (B0270)	170–190 °C	170–190 °C	170–190 °C	170–190 °C	170–190 °C

