

M·VERA® GP1012 (B0065)

Preliminary Technical Description

Product Description

M·VERA® GP1012 (B0065):	Biodegradable polyester compound for injection moulding; due to the used natural filler, it may cause variations in color and visible inclusions
Applications:	Coffee capsules, cutlery, etc.
Suitable for:	Injection moulded parts
Recommended thickness range:	<1 mm
Certification:	OK compost HOME (NF T51-800 [11-2015], certified by TÜV AUSTRIA Belgium), OK biodegradable SOIL (ISO 17556/EN 13432, certified by TÜV AUSTRIA Belgium)

Properties*

	Standard	Unit	GP1012 (B0065)
MVR 160 °C/2.16 kg	ISO 1133	cm ³ /10 min	1.8
Density	ISO 1183	g/cm ³	1.26
Renewable Content	-	%	~100
Moisture**	-	%	<0.5
Tensile modulus	ISO 527-1/-2	MPa	2,000
Tensile strength	ISO 527-1/-2	MPa	16
Tensile strength at yield	ISO 527-1/-2	MPa	16
Elongation at yield	ISO 527-1/-2	%	3
Elongation at break	ISO 527-1/-2	%	6
Flexural modulus	ISO 178	MPa	2,690
Flexural strength	ISO 178	MPa	35
Flexural elongation	ISO 178	%	2
Charpy notched impact strength	ISO 179-1/1eA	kJ/m ²	4
Heat distortion temperature, HDT/B	ISO 75/B	°C	104

** Needs to be dried by the fabricator before use to <0.1 %. Please pay attention to the paragraph "Drying" on the second page of this document.

***Remark:** The above listed properties were measured on specimen/material with moisture <0.1 %. The aforementioned information 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 and to be protected against direct sun light not longer than 3 months. For keeping product properties, the recommended maximum temperature of 30 °C and the maximum humidity of 50 % shall not be exceeded. Products made of M·VERA® grades have to be stored under same conditions. All M·VERA® products can be colored with AF-Eco® biomasterbatches 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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Processing Guide

Processing Recommendations

Safety Precautions:

- Processing at a temperature not higher than 170 °C
- Processing with adequate ventilation

Handling:

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

Drying:

- Before use, material has to be dried to <0.1 % moisture at 80 °C for 4 h by using a vacuum dryer or purging with dry air (dew point -35 °C)

Delivery & Storage:

- Supply in 25 kg foil-aluminum 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 = 30 g/10 min for ~10 minutes
- Lower the temperature to recommended settings
- Start transition, when the temperature are within 10 °C of desired range

Equipment:

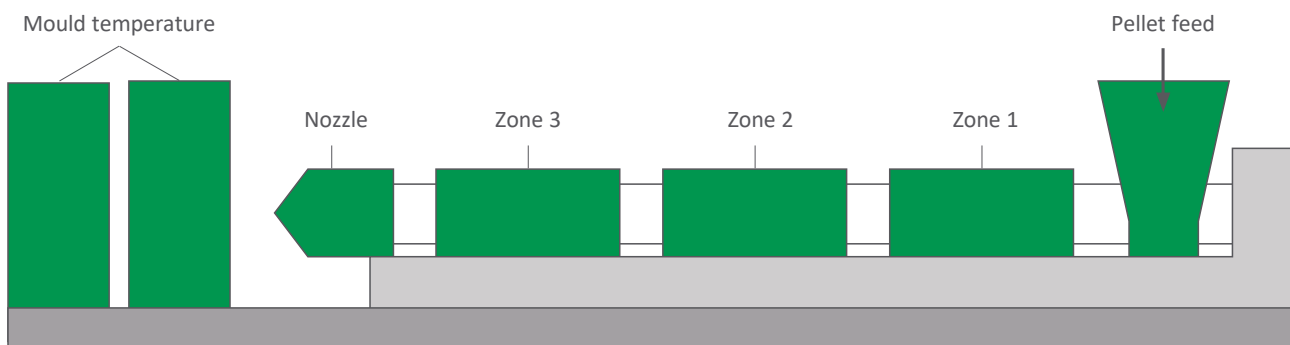
- M·VERA® grades are designed for standard equipment

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 procedur

Processing Temperatures

Grade	Mould Temp.	Nozzle	Zone 3	Zone 2	Zone 1
GP1012 (B0065)	55–75 °C	140–160 °C	150–160 °C	140–150 °C	130–140 °C



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