NonOilen® FB 3046-5

TECHNICAL DATASHEET

Last actualisation: **3/2024**

Basic description

NonOilen® is thermoplastic material based on biodegradable polymer blends made of 100% renewable raw materials. NonOilen®, produced by PANARA a.s., undergoes biodegradation under various natural conditions (e.g. at home compost, industrial compost, soil, seawater) according to material composition.

Application segment

NonOilen® FB 3046-5 is optimised for film blowing technology.

Physical form

Cylindrical pellets

Composition

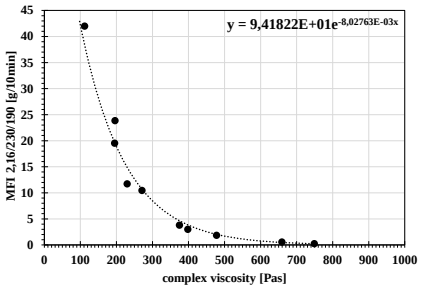
Major components	PLA, PHA polymers
Minor components	Biodegradable plasticiser(s) and other additives

Material properties (typical values, do not perform a specification of given grade)

Parameter		Test method	Unit	Value
Rheological properties				
Complex viscosity (measured using oscillating rheometer)	160°C	Internal method	Pas	970
	180°C	Internal method		640
Mechanical properties				
Density at 23°C		ISO 1183	g/cm^3	1,2
Tensile strength	MD	ISO 527	MPa	13
	TD		MPa	11
Tensile strength at break	MD		MPa	22
	TD		MPa	17
Elongation at break	MD		%	290
	TD		%	330
Tensile modulus	MD		GPa	0,2
	TD		GPa	0,1
Tear strength	MD	ISO 6383	N/mm	11
	TD	ISO 527	N/mm	24
Impact resistance - Dart drop test, 23 °C, 30 µm		ISO 7765-1	g	83

(MD) = Machine direction; (TD) = Transversal direction

MFI is not relevant parameter for NonOilen® materials because measurement system for MFI does not allow to determine true flow properties of NonOilen® blend. The best testing method is represented by oscillating rheometry which give values of complex viscosity. For better understanding relation between complex viscosity and commonly using MFI parameter, correlation curve between both parameters is in Figure on right side. MFI values represent there MFI of LDPE at 190°C or PP at 230°C under 2.16 kg loading. Viscosity was measured at low shear rates (15/s), so at real high shear rate during injection, NonOilen® will flow much easily.



Parameter		Test method	Unit	Value
Thermal properties				
Glass transition temperature		DSC	°C	38
Melting point		DSC	°C	168
Crystallisation temperature		DSC	°C	86
Barrier properties				
Permeation of O_2 (OTR)	23°C, 0 % RH, 1 bar, 150 µm	internal	$cm^3/(m^2.day)$	257
Permeation of H_2O vapour	23°C, 85 % RH, 150 µm	internal	$mg(m^2.day)$	17
Biodegradation				
Industrial compost		EN 13432 ISO 14855	OK compost TÜV AUSTRIA INDUSTRIAL S2777	
Biodegradability at soil conditions		ISO 17556	N/A	

*** Under certification process**

Storage and handling

NonOilen® is delivered in 20kg barrier bags. The original package should be stored at humidity up to 60% and temperature in range 10 – 30°C. Pellets are pre-dried. Before processing, drying for 1 hour at 70°C is recommended. The moisture content should be below 1000 ppm (0,1%).

Special additives

Colour masterbatches and other additive masterbatches can be used for processing as well as other properties modification. The Avient masterbatches for NonOilen® are recommended.

Processing conditions

Standard film blowing line for LDPE processing is recommended. Melt temperature should not exceed 200°C, optimally it should range from 150 to 170°C on the head. IBC is recommended.

Zone 1	Zone 2	Zone 3	Zone 4	Transition	Die
160-180 °C	160-180 °C	160-180 °C	160-180 °C	160-180 °C	150-170°C