

PHIMER ABUS DC



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Key Features

- Water Resistant
- Heat Sealing Properties
- OTR/WVTR/Odour Barriers

Applications



Extrusion film blowing

APPROVED & CERTIFIED BY



Typical Parameters

TEST	RESULT (MD)	RESULT (CD)
PHIMER ABUS DC Compostable Film (45 MICRONS)		
Thickness (μm)	45.960 \pm 1.567	49.4 \pm 1.730
Tensile strength (MPa)	18.936 \pm 1.042	17.332 \pm 1.312
Young's Modulus (MPa)	105.45 \pm 5.823	102.09 \pm 4.829
% Elongation	516.0 \pm 28.1	496.0 \pm 27.7
Tear Strength (kgf/mm)	6.892 \pm 0.170	3.654 \pm 0.316
Seal Strength (Kgf)	0.479 \pm 0.028	
PHIMER ABUS DC Compostable Film (95 MICRONS)		
Thickness (μm)	95.5 \pm 5.986	81.4 \pm 5.898
Tensile strength (MPa)	16.067 \pm 1.052	9.843 \pm 1.198
Young's Modulus (MPa)	113.48 \pm 5.722	132.63 \pm 13.013
% Elongation	796.0 \pm 41.4	751.0 \pm 40.3
Tear Strength (kgf/mm)	4.656 \pm 0.066	7.187 \pm 0.132
Seal Strength (Kgf)	0.786 \pm 0.034 (seal width: 10mm)0.878 \pm 0.050 (seal width: 2mm)	

Storage

Bags should be stored in dry/closed conditions at temperature below 50°C and protected from UV/direct sunlight. During transportation and storage temperature may no exceed 70°C at anytime.

Shelf-life

- For granules: 12 months from date to loading under proper storage conditions. If customers need to open bags and use them partially, we recommend sealing again properly and using it within 3 months.
- For film: We suggest customers use it within 12 months.

Packaging

In 25kg bag, liner: PE/PWS.

Pre-drying

It is recommended to pre-dry the material prior to getting the best processing performance. If the moisture of the resin is less than 0.05% pre-drying may not be needed. Typical drying conditions 1 hour at 90°C (194°F).

Application

Phimer material is mainly used to make biodegradable materials, which are applicable to blow moulding processing of film products, typical products include but not limited to are supermarket shopping bags, courier bags, clothing bags and industrial packaging.

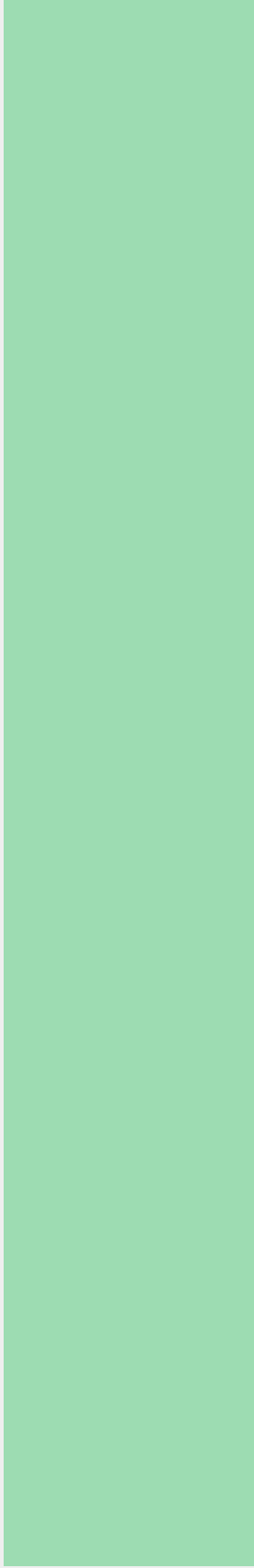
Process data for films

Selection of extruder: Single screw extruder is applicable, length-diameter ratio of film blowing machine should be ≥ 30 .

Barrel zone 1	95°C
Barrel zone 2	105°C
Barrel zone 3	115°C
Candle filter zone	120°C
Rotating body unit	125°C
Die zone 1	120°C
Die zone 2	135°C
Extruder speed	50 RPM
NIP roller speed	25 RPM
Melt pressure	20 bar
Pneumatic pressure	7 bar
Blowing pressure	1 bar
Thickness of film	50 μ to 250 μ

Residence time

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