

**API**TM

A Trinseo company.

TECHNICAL DATA SHEET

PROVISIONAL

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APINAT DP2971/E/FC/ST3**APINATTM**

TPE-E
Biodegradable TPC compounds

Properties	Methods	Units	Results (*)
Density	ASTM D 792	g/cm ³	1,41
Hardness Sh.D (3 sec.)	ASTM D 2240	sh.D	77
Melt Flow Index 190°C 49,05 N	ASTM D 1238	g/10'	55
Tensile strength (type IVB)	ASTM D 638	MPa	45
Elongation at break (type IVB)	ASTM D 638	%	10
Flexural modulus ASTM D 790	ASTM D 790	MPa	2400
Vicat (10N - 120°C/h)	ASTM D 1525	°C	111
HDT/A (Method A - 0.45 MPa)	ASTM D 648	°C	57

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Technology

Injection-Extrusion

Processing

Optimum processing conditions depend on such features as machine size, screw design, mould/extruder head and material residence time.

PRE-DRYING: 2 HR. AT 70÷80 °C. HYGROSCOPIC MATERIAL

It is necessary to store the material in a cool dry place. Exposure to high temperature, high humidity, flames or other heat source has to be avoided.

OPENED PACKAGING SHOULD BE SEALED AFTER USE. SHELF LIFE: SIX MONTHS.

INJECTION PRESSURE: MEDIUM

BACK PRESSURE - MEDIUM - LOW

INJECTION SPEED: MEDIUM - LOW

Temperature settings (°C)

Zone A: 160 : 170

Zone B: 170 : 180

Zone C: 180 : 190

Zone D: 190 : 200

Zone E: 25 : 40

L/D RATIO: 24 (F 30 MM)

COMPRESSION SCREW RATIO: 2,3:1

SCREW SPEED: 50 RPM

Temperature settings (°C)

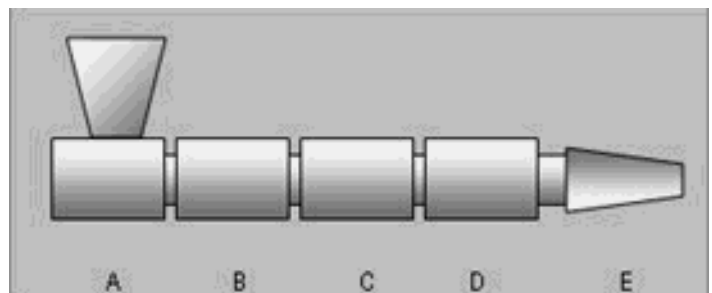
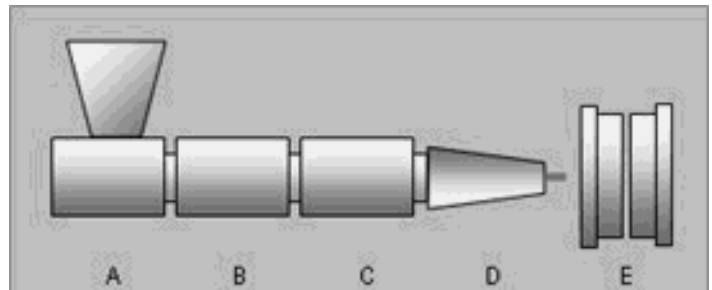
Zone A: 160 : 170

Zone B: 170 : 180

Zone C: 180 : 190

Zone D: 190 : 200

Zone E: 185 : 195

**Recycling**

REGRINDED MATERIAL CAN BE EASILY MIXED WITH VIRGIN PRODUCT.

NOT ALLOWED FOR CRITICAL APPLICATIONS OR THERMOSET MATERIALS.

(*) Typical property values; these are not to be construed as specifications.

The information supplied above is given in good faith and is accurately based on test results. However, we recommend that the procedures suggested, which may be updated from time to time, are tested to ensure that they are suitable for your specific application/production. API Spa does not guarantee results and assumes no obligation or responsibility whatsoever in respect of the information provided, other than those required by applicable Law. Furthermore API Spa will not take any responsibility in case of any use of the products in violation of third party patent and/or right of any kind.