

## Technical datasheet

# PHAx 11284 MFT10



Date of issue: May 31, 2022  
Measured batch: HP-202205-003  
Version: v1.0

PHA polymers are a thermoplastic resin that can be used in injection molding, thermoforming and extrusion. PHA is made by bacterial fermentation and is 100% biobased and 100% biodegradable. They have a potentially large design space and resulting application options, if properly applied. And this is where PHARadox comes in. By blending different PHA polymers, and by possibly adding some sustainable fillers or fibers, PHARadox finetunes its PHA formulations to match perfectly with the customer needs.

### MATERIAL PROPERTIES

| Physical properties              | Unit              | Value | Method         |
|----------------------------------|-------------------|-------|----------------|
| Tensile modulus                  | MPa               | 1965  | ISO 527        |
| Tensile strength                 | MPa               | 25    | ISO 527        |
| Tensile strain at break          | %                 | 10,4  | ISO 527        |
| Flexural modulus                 | MPa               | 1760  | ISO 178        |
| Flexural strength                | MPa               | 41    | ISO 178        |
| Charpy notched impact strength   | kJ/m <sup>2</sup> | 5,9   | ISO 179-1/1 eA |
| Charpy unnotched impact strength | kJ/m <sup>2</sup> | 84,8  | ISO 179-1/1 eU |
| HDT (0,45 N/mm <sup>2</sup> )    | °C                | 130   | ISO 75         |

### Processing settings

| Sections | Temperature | Notes  |
|----------|-------------|--|
| Drying   | 80 - 90 °C  | 2 - 3 hours  |
| Zone 1   | 150 °C      | Please try to stick to these temperatures (or lower) as the materials starts chain-scission (degradation) at higher temperatures.  |
| Zone 2   | 155 °C      |  |
| Zone 3   | 155 °C      |  |
| Zone 4   | 160 °C      |  |
| Zone 5   | 165 °C      |  |
| Mold     | 60 - 70 °C  | Mold temperature is very important to initiate crystallization of the material. Without increased mold temperature, the material won't crystallize and will probably stay stuck in the mold. |

Keep residence time in barrel as short as possible, and shear as low as possible, to prevent degradation.

#### Disclaimer

The product- and technical information provided in this datasheet is correct to the best of our knowledge. The information given is provided as a guidance for good use, handling and processing and is not to be considered as a quality specification. The information only relates to the specific product and the material properties.