



ecovio® IS1335

BASF Corporation - Copolyester

Sunday, November 3, 2019

General Information

Product Description

Mineral filled injection molding grade, bio-degradable according to DIN EN 13432, e. g. for stiff packaging applications in food contact. BASF ecovio® IS (Injection Specialty) grade are plastics for articles intended to come onto contact with foodstuffs. These plastics fulfill different food regulatory norms like e. g. FDA, European Food Contact n°2002/72/EC and/or GMP (EC) n°2023/2006.

General

Material Status	• Commercial: Active
Availability	• Europe • North America
Filler / Reinforcement	• Mineral, 30% Filler by Weight
Features	• Biodegradable • Compostable • Food Contact Acceptable
Uses	• Food Packaging
Agency Ratings	• ASTM D6400 • EC 2023/2006 • FDA FCN 475 • DIN EN 13432 • EU 2002/72/EC • FDA FCN 907 • EC 1907/2006 (REACH) • FDA FCN 178 • FDA Food Contact, Unspecified Rating
RoHS Compliance	• RoHS Compliant
Forms	• Pellets
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.47	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	9.00	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	0.20	%	
Flow	0.10	%	
Mold Shrinkage ² (39.4 mil)	0.14	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	522000	psi	ISO 527-2
Tensile Strain (Break)	4.0	%	ISO 527-2/50
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (66 psi, Annealed)	131	°F	ISO 75-2/B

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	176	°F
Drying Time	5.0	hr
Suggested Max Moisture	0.080	%
Hopper Temperature	77	°F
Rear Temperature	356	°F
Middle Temperature	365	°F
Front Temperature	374	°F
Nozzle Temperature	383	°F
Processing (Melt) Temp	356 to 401	°F
Mold Temperature	50 to 104	°F

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Injection	Nominal Value	Unit
Residence Time	< 2.0	min

Notes

- ¹ Typical properties: these are not to be construed as specifications.
- ² test box