

PHACT™ S1000P

PHACT S1000P is an environment-friendly semi-crystalline biopolymer.

It has excellent biodegradability under anaerobic, aerobic, aquatic and compost conditions.

PHACT S1000P is suitable for general compounding with other polymers.

PHACT S1000P can be processed into various conversion technologies such as injection molding, film, sheet and fiber.

PROPERTIES OF PHACT S1000P

Properties	Units	ASTM No	S1000P
Forms	-		Pellet
Specific Gravity	-	D792	1.23
Hardness (Max)	Shore D	D2240	< 90
Tensile Strength at Peak ¹⁾	MPa	D638	30 ~ 35
Elongation at Break ¹⁾	%	D638	< 60
IZOD Impact strenght (notched)	J/M	D256-23e1	28 <
Flexural strength ²⁾	MPa	D790-17	60 ~ 70
Flexural modulus ²⁾	MPa	D790-17	2,000 <
Heat Deflection Temperature / 0.455 Mpa	°C	D648	130 <
Melting Point ³⁾	°C	D3418	150 ~ 170
Glass Transition Temperature ³⁾	°C	D3418	-6 ~ 0
Melt Flow Rate (180°C, 2.16kg)	g/10 min	D1238	< 4

1) Injection specimens conform to ASTM D638. Crosshead speed 50 mm/min.

2) Flexural strength test speed: 2.8mm/min, Flexural modulus test speed: 2mm/min.

3) Differential Scanning Calorimeter(DSC), peak of endotherm. Heating rate 10 °C/min.

PROCESSING CONDITION FOR GENERAL PURPOSES

Dry Temperature	80 °C X 5 hrs	Compression Section	145 ~ 175 °C
Feed Temperature	120 ~ 130 °C	Nozzle	145 ~ 175 °C
Melt Temperature	145 ~ 175 °C	Screw Speed	80 ~ 150 rpm

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GENERAL STORAGE AND DRYING PROCESS CONDITION

Storage Condition

Avoid direct sunlight, heat or fire, and store at a dry ventilated cool place.

Drying Process Condition

PHACT S1000P is supplied in foil-lined boxes or bags dried to < 500 ppm.

Consume all the products with an open bag if possible, and if there is a residual unavoidably, seal them completely and keep them in a dry place, and avoid storing them for a long time.

It is recommended to dry PHACT from packaging for 5 hrs at 80 °C.

It is preferable to dry with air below -40 °C dew point.

In case of resins are exposed to moisture in the air, they must be dried in the dehumidifying dryer before use.

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