EcoAllene BA35H

EcoAllene
PROCESSO BREVETTATO | PATENTED PROCESS

The product consists of polymer granules obtained from the recycling of polylaminate waste (polyethylene and aluminum, CER 03.03.07) deriving from tetrapak type beverage cartons.

Product composition per KG of material:

Polyethylene and aluminum waste from the treatment of Post-Consumer packaging waste with the addition of:

- High density polyethylene 35%
- Additives from 1 to 5%

UNI 10667-1 compliant material,
UNI 10667-2 and UNI 10667-16

Percentage of certified recycled material:

- 95% post consumer material

Property

The values in the table were obtained from an average of analyzes and tests carried out during the production of granules deriving from post-consumer and industrial waste.

ANALYSIS	METHOD	Unit of measure	VALUE
Density	ISO 1183	g/cm^3	0,982
Residual (Internal Value)	650°C/1h	%	6,0
Melt Flow Index (230°C/2,16 kg)	ISO 1133	g/10min	1,6
Melt Flow Index (230°C/5 kg)	ISO 1133	g/10min	7,7
VICAT a 49 N (50°C/h)	ISO 306	C°	83,0
Deflection load (3,2 mm)	ISO 527	MPa	20,7
Maximum tensile load	ISO 527	MPa	13,0
Bending yield strength	ISO 178	MPa	12,9
Elongation at break in traction	ISO 527	%	187,0
Impact resistance IZOD c.i.	ISO 180	J/m	139,0
Impact resistance IZOD c.i.	ISO 180	KJ/m2	34,7
Tensile modulus of elasticity	ISO 527	MPa	810
Flexural modulus of elasticity	ISO 178	MPa	704
Longitudinal shrinkage	ISO 294	%	N.D
Cross shrinkage	ISO 294	%	N.D
The analysis parameters can have fluctuations from 3 to 5%			

Storage conditions

The storage in the customer's warehouse in conditions of unknown relative humidity can significantly vary this value and therefore, before using EcoAllene, it is suggested to subject the material to a drying phase with hot air at about 90°/2h for restore the humidity conditions to 100 ppm optimal for processing.

Uses not permitted

The use of food contact and medical material is not allowed.

The information contained in this technical data sheet is believed to be accurate, but all recommendations are made without any guarantee, since the conditions of use are not under the control of the company Ecoplasteam Spa Società Benefit, which declines any responsibility in relation to the use of the information and the use of this mixture in combination with other materials or in other processes.

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ecoplasteam
we care.

Manufacturer Name:

ECOPLASTEAM Spa Benefit Company

Registered office and production site:

Via Gambalera, 180

Spinetta Marengo, 15122 (AL) - Italy

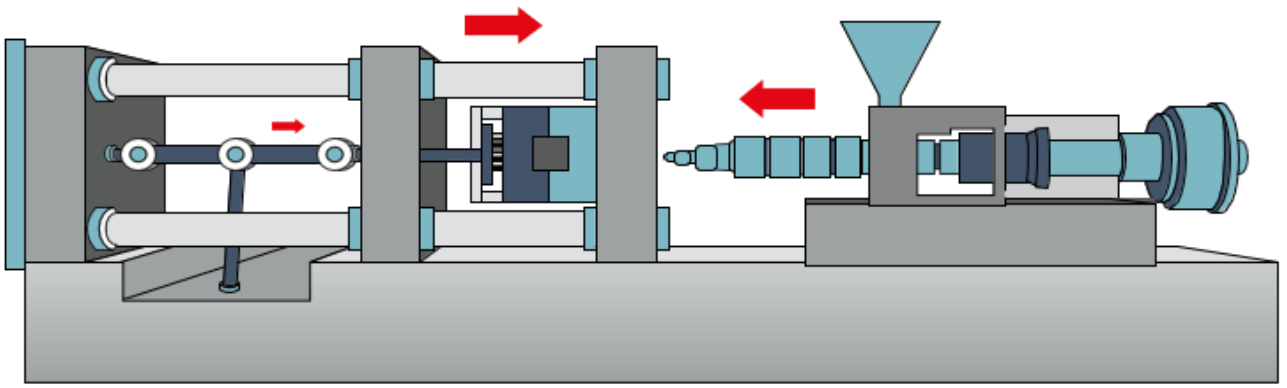
Administrative and Headquarters:

Corso Galileo Ferraris, 110

Turin, 10129 - Italy

EcoAllene

CHARACTERISTICS OF THE TRANSFORMATION PROCESS



ESSICAZIONE
✗ Non richiesta*

TEMPERATURE
✗ Ugello: 190° - 230°
(per compounds PS e Pa 200°-240°)
✗ Cilindro: 200° - 240°
(per compounds PS e Pa 210°-250°)
✗ Stampo: 40°-60° (una T° maggiore favorisce lo scorrimento del flusso)

PRESSIONE E VELOCITÀ
✗ Pressione Specifica: 300 – 500 bar
✗ Iniezione: Medio - Alta
✗ Contro pressione: Bassa - Media
✗ Velocità: Medio - Alta

DRYING
✗ Not required

TEMPERATURES
✗ Nozzle: 190° - 230°
(for compounds PS and Pa 200°-240°)
✗ Cilynder: 200° - 240°
(for compounds PS and Pa 210°-250°)
✗ Mold: 40°-60° (higher T° influence positively the flowabilty)

PRESSURE AND VELOCITY
✗ Specific pressure: 300 – 500 bar
✗ Injection: Medium – High
✗ Back pressure: Low – medium
✗ Velocity: Medium - High

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