GREEN PLASTIC
MADE IN VIETNAM

Technical Data Sheet

Green plastic ABBH-CR02T

Biobased Compound for Injection Moulding

Description:

Green plastic ABBH-CR02T is made from 30-35% bran and rice husk. It is formulated from agricultural by-product. ABBH-CR02T for injection molding process with high flow and good stiffness characteristic. It is suitable for the production of general part, office stationery, household & personal care products etc.

Typical Material Properties:

PROPERTIES	TEST METHOD	UNIT	VALUES
Physical			
Biobased Carbon Content	ASTM D6866	%	30
Color	-	-	Slightly yellow to Beige (Textured)
Specific Gravity	ASTM D792	g/cm^3	1.22
Melt Flow Rate (230°C / 2.16 kg)	ASTM D1238	g/10 min	23
Water Absorption	ASTM D570	%	1.0 – 2.0
Mould Shrinkage (23 °C, 3.20 mm, Pressure Molded)	In-house Method	%	0.5 – 0.8
Mechanical (23 °C, 3.20 mm, Pressure Molded)			
Tensile Strength	ASTM D638	MPa	17
Elongation at Yield	ASTM D638	%	4
Flexural Modulus	ASTM D790	MPa	1520
Flexural Strain at Break	ASTM D790	%	8
Impact			
Izod Impact Strength (Notched) 23 °C, 6.40 mm, Pressure Molded	ASTM D256	J/m	23
Thermal			
Heat Deflection Temperature (1.82 MPa) 23 °C, 6.0 mm, Pressure Molded	ASTM D648	˚C	80

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Processing Technique:

Green plastic ABBH-CR02T in pellet form is recommended to be stored in properly sealed moisture barrier packaging at dry condition and away from sun light.

PARAMETER	UNIT	TYPICAL VALUE
[a] Drying Temperature	°C	80
[a] Drying Time / Moisture Content before moulding	Hours / %	4-6 / 0.02
[b] Melt Temperature during processing	°C	190-230
Mould temperature range	°C	40-70

[a] Preheat **Green plastic** compound preferably in a de-humidifying dryer for at least 4 hrs at 80 ºC or until the moisture content is less than 0.1% prior to molding.

[b] It is recommended to purge the barrel and DO NOT allow **Green plastic** to stay in the barrel for too long to prevent degradation of **Green plastic** in the event that process needs to stop for some time.

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