



GPM Fully Biodegradable Plastics

GPM 8 S802

Starch Filling Series

Blown Film Grade Biodegradable Material

Version: 1.0 Issue Time: May 29, 2023

Product Features:	Biodegradable
	Compostable
Typical application fields:	Packaging film
Form:	Pellets, 25 kg / bag or 800 kg / bag

Film Performance:

Film Thickness 40 um			
Properties ^[1]	Test Method	Units	Values ^[2]
Tensile strength MD/TD	ISO 527-3	MPa	21/22
Elongation at Break MD/TD	ISO 527-3	%	780/700
Tear Strength MD/TD	ASTM D 1922	N/mm	79
Dart Drop	ISO 7765	g	623
Safe Load-Bearing	-	kg	6.5

[1] Not to be construed as specifications.

[2] The listed values are measured by test specification and used for referential purpose only.

Processing and Handling Information:

1. General Requirements:

GPM 8 S802 is a starch-based biodegradable blown film material. Moisture can cause hydrolysis of the material, and residual moisture above 2 ppm can lead to defects such as fish eyes during processing.

2. Transportation and Storage

Transport and storage temperatures should not exceed 70°C. The unopened material can be stored at normal temperature (23°C) for 12 months. The product in complete package can be used directly. If the package is damaged, it needs to be dried before use, because moisture above 1000ppm will affect the blown film process, and the effective drying condition is 90°C for 1 hour. Dried products need to be protected from moisture.

3. Blowing Film Processing Parameters:

Setting		Start Point	Range
Melting Temperature		115°C	100-120°C
Heating Temperature of Blowing Film	Posterior Segment	140°C	135-145°C
	Middle Segment	140°C	135-145°C
	Anterior Segment	150°C	145-155°C
Die Temperature		160°C	150-165°C
Processing Temperature Limit		190°C	
Pre-drying Conditions		90°C, 1 hr	

* The above data are typical values and should not be interpreted as technical indicators for judging quality.



Statement

All test conditions and standards are listed, the dates are for reference only, the test performance will vary with the processing method and conditions. Environmental conditions can affect the performance of the material, and the product needs to be used as soon as possible after opening.

