

NonOilen® TF 3066-8

TECHNICAL DATASHEET

Last actualisation: **12/2024**

Basic description

NonOilen® is thermoplastic material based on biodegradable polymer blends made of 100% renewable raw materials. NonOilen®, produced by PANARA a.s., undergoes biodegradation under various natural conditions (e.g. at home compost, industrial compost, soil, seawater) according to material composition.

Application segment

NonOilen® TF 3066-8 is optimised for sheet extrusion for thermoforming and vacuum forming technology.

Certification

OK compost INDUSTRIAL – (EN 13432, certified by TÜV AUSTRIA Belgium)

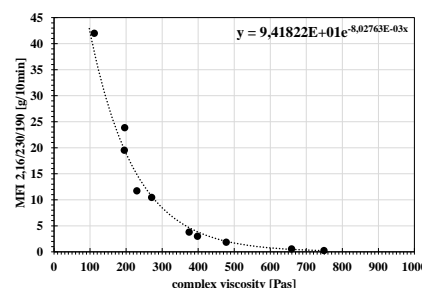


Material properties (typical values, do not perform a specification of given grade)

Parameter	Test method	Unit	Value
Rheological properties			
Complex viscosity (measured using oscillating rheometer)	160°C	Internal method	Pas
	180°C	Internal method	1697
Mechanical properties			
Density at 23°C	ISO 1183	g/cm ³	1,2
Tensile strength	MD	MPa	37
Tensile strength	TD	MPa	24
Elongation at break	MD	%	5
Elongation at break	TD	%	14
Tensile modulus	MD	GPa	2
Tensile modulus	TD	GPa	1,4
Charpy impact strength un-notched	23°C	ISO 179	kJ/m ²
Charpy impact strength un-notched	-30°C		
Flexural strength	ISO178	MPa	56
Flexural deformation		%	4
Flexural modulus		GPa	2

(MD) = Machine direction; (TD) = Transversal direction

MFI is not relevant parameter for NonOilen® materials because measurement system for MFI does not allow to determine true flow properties of NonOilen® blend. The best testing method is represented by oscillating rheometry which give values of complex viscosity. For better understanding relation between complex viscosity and commonly using MFI parameter, correlation curve between both parameters is in Figure on right side. MFI values represent there MFI of LDPE at 190°C or PP at 230°C under 2.16 kg loading. Viscosity was measured at low shear rates (15/s), so at real high shear rate during injection, NonOilen® will flow much easily.



Parameter	Test method	Unit	Value
Thermal properties			
Glass transition temperature	DSC	°C	58
Melting point	DSC	°C	184
Crystallisation temperature	DSC	°C	110
Heat deflection temperature	ISO 75, B	°C	107
Vicat softening point VST	ISO 306, A/50	°C	N/A
Barrier properties			
Permeation of O ₂ (OTR)	23°C, 0 % RH, 1bar, 150 µm	internal	cm ³ /(m ² .day)
Permeation of H ₂ O vapour	23°C, 85 % RH, 150 µm	internal	mg(m ² .day)

Storage and handling

NonOilen® is supplied in 25 kg foil-aluminum bags or 1-ton octabins. The original packaging should be stored in a humidity up to 60% and at a temperature between 10°C - 30°C, protected from heat and direct sunlight. The pellets are pre-dried, but it is recommended to dry them for 2 hours at 60°C before processing. The moisture content should be kept below 1000 ppm (0.1%).

Special additives

PLA color masterbatches can be used during PLA processing. These masterbatches should also be certified in accordance with EN 13432. Please be aware that the use of masterbatches may affect the mechanical and optical properties of the final product.

Start-up and purging

Start by purging the extruder with a suitable polyolefin (e.g., MFR 20-30 g/10 min) for approximately 15-30 minutes to remove any residual material. Adjust the processing temperature to the recommended settings. Once the temperature is within 10°C of the target range, initiate the transition to NonOilen®.

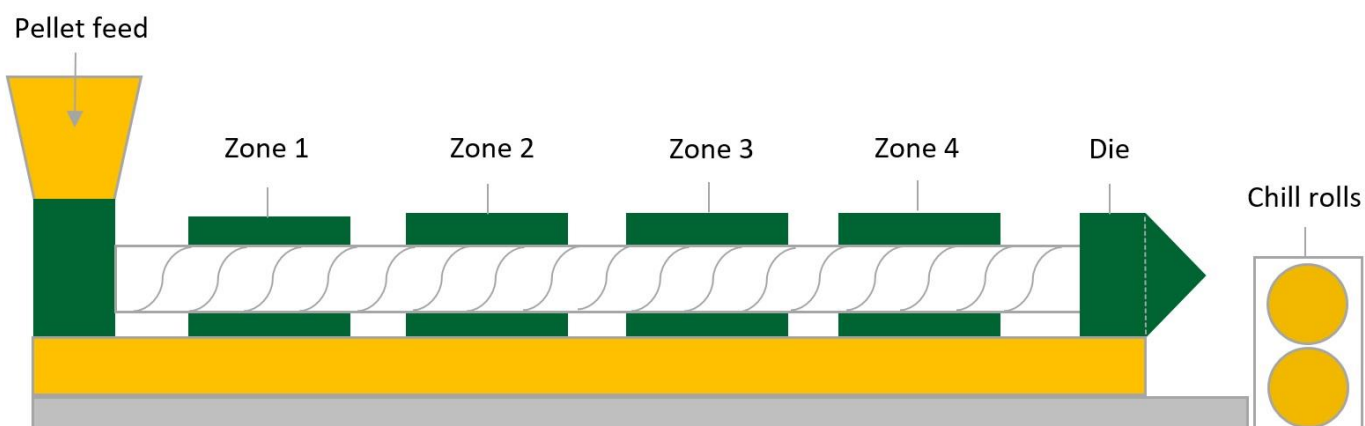
Interruption and shut-down

In case of a prolonged interruption, reduce the screw speed to approximately 10 rpm. For longer period, please purge the extruder with the same polyolefin used in the start-up procedure. Never leave NonOilen® product in the extruder for an extended period, such as overnight.

Processing conditions

Melt temperature should not exceed 200°C, optimally it should range from 160 to 180°C on the die. The feeding zone must be cooled. NonOilen® TF 3066-8 is suitable for cast film (sheet) extrusion in thickness up to 1 mm – semi-product for thermoforming. Thermoforming process parameters have to be adjusted according to specifics of production line and product shape.

Zone 1	Zone 2	Zone 3	Zone 4	Die	Chill rolls
180-190 °C	180-190 °C	180-190 °C	180-190 °C	190°C	25-50°C



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