

# Ecovio® IS 1335

Polybutylene Adipate-Co-Terephthalate

BASF Corporation

## Message:

Mineral filled injection molding grade, bio-degradable according to DIN EN 13432, e.g. for stiff packaging applications in food contact. BASF ecovio® IS (Injection Specialty) grade are plastics for articles intended to come onto contact with foodstuffs. These plastics fulfill different food regulatory norms like e.g. FDA, European Food Contact n°2002/72/EC and/or GMP (EC) n°2023/2006.

General Information			
Filler / Reinforcement	Mineral filler, 30% filler by weight		
Features	Biodegradable		
	Compliance of Food Exposure		
Uses	Food packaging		
Agency Ratings	DIN EN 13432		
	EC 1907/2006 (REACH)		
	EC 2023/2006		
	FDA Food Exposure, Not Rated		
	European 2002/72/EC		
RoHS Compliance	RoHS compliance		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.47	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	9.00	cm³/10min	ISO 1133
Molding Shrinkage			ISO 294-4
Vertical flow direction	0.20	%	ISO 294-4
Flow direction	0.10	%	ISO 294-4
Mold Shrinkage <sup>1</sup> (1.00 mm)	0.14	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3600	MPa	ISO 527-2
Tensile Strain (Break)	4.0	%	ISO 527-2/50
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (0.45 MPa, Annealed)	55.0	°C	ISO 75-2/B
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	5.0	hr	
Suggested Max Moisture	0.080	%	

Hopper Temperature	25.0	°C
Rear Temperature	180	°C
Middle Temperature	185	°C
Front Temperature	190	°C
Nozzle Temperature	195	°C
Processing (Melt) Temp	180 - 205	°C
Mold Temperature	10.0 - 40.0	°C

#### Injection instructions

Residence Time: <2 min.

#### NOTE

1. Test box with central gating,  
dimensions of base (107\*47\*1,0)  
mm, processing condition: TM =  
195°C, TW = 40°C

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#### Recommended distributors for this material

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