

TECHNICAL DATA SHEET

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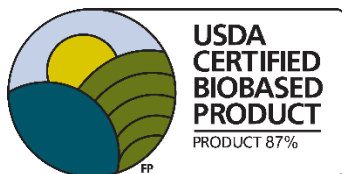
SULAPAC UNIVERSAL FLEX 35 – IM1012

MATERIAL FEATURES

Sulapac Universal Flex 35 is a sustainable, beautiful, and functional injection molding material which contains 87 % USDA certified bio-based content. The material is designed for thin-walled structures with good impact strength and is easy to process with minimal, if any adjustments needed for the existing machinery.

Sulapac Universal Flex 35 is safe for both people and the planet: the material is certified as industrially compostable by BPI¹ and leaves no microplastic² or toxic load behind. Universal Flex 35 meets the EU and US FDA requirements for food contact materials for dry food³.

For more details, visit www.sulapac.com/key-features



1 The compostability has been tested up to the thickness of 1,48 mm. As the compostability of an end product is also dependent on the geometry of product, it is the responsibility of the manufacturer of the end product to ensure compliance with the regulations.

2 Biodegradation of 79% in 308 days in the marine environment (30 °C / 86 °F) (ASTM D6691). Tested according to ASTM 5511 (accelerated biodegradation in the landfill 37 °C / 99 °F): 52% relative biodegradation in 210 d. Not considered biodegradable in California.

3 Restrictions and specifications of use apply, please refer to relevant Declaration of Compliance for further information.



TECHNICAL DATA

MECHANICAL PROPERTIES	
MATERIAL	SULAPAC UNIVERSAL FLEX 35
PHYSICAL PROPERTIES	
Hardness (Shore D)	76
Material density (g/cm ³)	1.27
Shrinkage (%)	0.3
TENSILE PROPERTIES (ISO 527-1)	
Tensile strength (MPa)	40
Tensile modulus (GPa)	3.5
Tensile strain @brk (%)	2.5
FLEXURAL PROPERTIES (ISO 178)	
Flexural strength (MPa)	79
Flexural modulus (GPa)	4.0
Flexural strain (%)	2.6
IMPACT PROPERTIES (Unnotched, ISO 179-1)	
Charpy impact strength (kJ/m ²)	10
RHEOLOGICAL PROPERTIES (ISO 1133)	
MFI (g/10 min) (190°C/2.16 kg)	8-15

PROCESSING INSTRUCTIONS FOR INJECTION MOLDING

MOISTURE AND DRYING
INSTRUCTIONS
<ul style="list-style-type: none">• Before processing, the granules should be dried using a dehumidifying or vacuum dryer.• If a dehumidifying dryer is used, the granules should be dried for at least 4 hours at 100°C.• If a vacuum drying system is used, the granules should be first dried for at least 20 minutes at 100°C and then kept in the vacuum for at least 40 minutes.• Avoid exposing the material to ambient conditions after drying.• Moisture content can lead to hydrolysis.• Dried granules should be mixed with the color masterbatch after the granules have cooled down in order to avoid the agglomeration of color masterbatch granules.

PROCESSING INSTRUCTIONS

TEMPERATURE		GENERAL INSTRUCTIONS
Throat	40 – 60 °C	<ul style="list-style-type: none"> Typical settings may require optimization. Both cold and hot runner systems are suitable for this material. Valve gate systems can be used. Avoid using temperatures above 200°C in order to lower the risk of wood and polymer degradation. The dwell time of the material inside the machine shall be reduced to minimum in order to lower the risk of thermal degradation.
Feed zone	150 – 165 °C	
Compression zone	160 – 175 °C	
Homogenizing zone	175 – 190 °C	
Machine nozzle	175 – 190 °C	
Back pressure	5 – 10 bar	
Screw Speed, max	< 0,25 m/s	
Hot runner nozzle and bushing	180 – 200 °C	
Tooling temperature T_{mold}	20 – 40 °C	

PURGING INSTRUCTIONS

BEFORE PRODUCTION	DURING PRODUCTION	AFTER PRODUCTION
<ul style="list-style-type: none"> Purge the plasticization unit and the hot runner with PE (or PP). To purge the plasticization unit and hot runner from residual PE (or PP) or previous production recipes, at least 10 cycles should be produced from Sulapac material before starting the actual production. 	<ul style="list-style-type: none"> The material has a tendency to degrade and therefore needs a constant melt flow. The condition of the mold should be regularly monitored and, if necessary, the mold should be cleaned using e.g. a glass fiber brush or mold cleaning agents. If an extensive amount of burned material starts to appear in the products, try lowering processing temperature 	<ul style="list-style-type: none"> Purge the plasticization unit and the hot runner with PE (or PP). Clean up the mold after production. The temperature of the mold is recommended to be elevated to 70 °C. Generally used mold cleaning agents can be utilized.

STORAGE AND TRANSPORTATION INSTRUCTIONS

STORAGE AND TRANSPORTATION CONDITIONS

INSRUCTIONS

- It is recommended to store granules in their closed, original moisture barrier packaging at temperatures below 45 °C.
- Storage in dry conditions
- Storage in direct sunlight should be avoided.
- Temperatures during transportation and storage may not exceed 60 °C at any time.
- Material shelf-life is 24 months from the manufacturing date when stored at room temperatures (23 °C). Manufacturing date can be found on the label on material packaging.



**Sulapac
is proud
to be an
ISO 9001
and
ISO 14001
certified
company**

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