

## TECHNICAL DATA SHEET

04.03.2025

Version 1.2

### SULAPAC LUXE – IM1025.2NC

### SULAPAC LUXE FLEX – IM1024.0NC

### SULAPAC LUXE FLEX BLACK – IM1024.0BP

Sulapac Luxe and Luxe Flex materials are a sustainable solution for injection molding. With both Sulapac Luxe and Luxe Flex, shiny and matt surfaces can be achieved depending on your mold selection, making them ideal for fragrance caps, makeup compacts, cosmetic jars, lids, and pencils.

TYPICAL MATERIAL PROPERTIES		
	IM1025.2NC	IM1024.0NC IM1024.0BP
<b>PHYSICAL PROPERTIES</b>		
Hardness (Shore D)	88	89
Material density (g/cm <sup>3</sup> )	1,27	1,27
Shrinkage (%)	0,36	0,36
<b>TENSILE PROPERTIES (ISO 527-1)</b>		
Tensile strength at yield (MPa)	50	53
Tensile modulus (GPa)	3,2	2,3
Tensile strain at yield (%)	2,2	2,8
Tensile strain at break (%)	2,8	30
<b>FLEXURAL PROPERTIES (ISO 178)</b>		
Flexural strength at max load (MPa)	75	83
Flexural modulus (GPa)	3,2	2,5
Flexural strain at max load (%)	3	6,5
<b>IMPACT PROPERTIES (ISO 179-1)</b>		
Charpy impact strength - Unnotched (kJ/m <sup>2</sup> )	16	19
Charpy impact strength - Notched (kJ/m <sup>2</sup> )	2,2	1,6
<b>RHEOLOGICAL PROPERTIES (ISO 1133) (190°C/2,16 kg)</b>		
MFI (g/10min)	14	31

### HEAT RESISTANCE

HDT-B (°C)	54	53
------------	----	----

### BIOBASED CONTENT (ASTM D6866)

Biobased content (%)	87	86
----------------------	----	----

### MATERIAL COLOUR

Sulapac Luxe:

Due to the natural origin of wood, colour variation is possible both between and within material batches.

## DRYING AND MASTERBATCH INSTRUCTIONS

### DRYING

- Before processing, the granules should be dried using a dehumidifying dryer or a vacuum dryer
  - Dehumidifying dryer: the granules should be dried for at least 5-6 hours at 80°C
  - Vacuum dryer: the granules should be first dried for at least 20 minutes at 80°C
- The best end result will be achieved if the residual moisture of the granules is < 0,2 %
- After drying, avoid exposing the material to ambient conditions
- Moisture content can lead to hydrolysis

### MASTERBATCH

- Sulapac materials can be colored in the same way as conventional plastics. With Sulapac materials use color masterbatches with biodegradable carriers; PLA, PHA, PBAT, PBS. For further information, please see Sulapac color masterbatch guide.
- If color masterbatch is added, the granules should be cooled down to 50°C in order to avoid the agglomeration of color masterbatch granules

## PROCESSING CONDITIONS

### GENERAL INSTRUCTIONS

- Typical settings may require optimization
- Both cold and hot runner systems are suitable for these materials
- 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 shall be reduced to minimum in order to lower the risk of thermal degradation

### RECOMMENDED TEMPERATURES

Throat	40 – 60 °C
Feed zone	150 – 170 °C
Compression zone	160 – 180 °C
Homogenizing zone	175 – 190 °C
Machine nozzle	175 – 190 °C
Back pressure	5 – 10 bar

<b>Hot runner nozzle and bushing</b>	175 – 190 °C
<b>Tooling temperature</b>	20 – 40 °C

## PURGING INSTRUCTIONS

### BEFORE PRODUCTION

- Purge the plasticization unit and the hot runner with PP or PE

### DURING PRODUCTION

- The material is heat sensitive. Avoid high processing temperatures and long dwell times
- If an extensive amount of burned material or fumes starts to appear in the products, try lowering processing temperature
- In case of production break flush the plasticization unit with fresh material

### AFTER PRODUCTION

- Purge the plasticization unit and the hot runner with PP or PE
- Clean up the mold after production

## STORAGE, TRANSPORTATION AND SHELF-LIFE

### STORAGE

- In original unopened packaging at temperatures below 45°C
- Once opened, reseal the package after each use
- In dry conditions and avoid exposure to high humidity and rain
- Away from direct sunlight

### TRANSPORTATION

- Temperatures during transportation may not exceed 60°C

### SHELF-LIFE

- Shelf-life is from the date of manufacture, for unopened bags at room temperature (23°C)
- Date of manufacture can be found on the label attached to the original packaging

<b>Sulapac Luxe – IM1025.2NC</b>	12 months
<b>Sulapac Luxe Flex – IM1024.0NC</b>	12 months
<b>Sulapac Luxe Flex – IM1024.0BP</b>	12 months

The information provided in this safety data sheet is based on our current knowledge and experience at the date of its publication and describe the material only with regards to safety requirements. No representation or warranty is made as to the truth or accuracy of any data, information or opinions contained herein or as to their suitability for any purpose, condition, or application. The information relates only to the specific material designated and may not be valid for such material used in combination with any other materials or in any process. It is the responsibility of the recipient of the product to ensure any proprietary rights and existing laws and legislation are observed.



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