



BioLogiQ creates plastics from polysaccharides found in plants. These plastics are designed to enhance both the functional and environmental performance of the packages and products produced with them.

All BioLogiQ compounded plastics start with **NuPlastiQ** BioPolymer, a 100% natural, renewably sourced, plant-based biopolymer.

## Description

- One of the BioBlend® XP family of high performance BioPolymers designed for blown film applications.
- BioBlend® XP 24875 is a masterbatch that contains 50% NuPlastiQ GP BioPolymer compounded with 20% HDPE and 30% LLDPE.
- Made from 50% annually renewable agricultural resources.
- Supplied in pellet form.

## Applications

- T-shirt bags, carryout bags, shipping sacks.

## Properties

PHYSICAL	TEST METHOD	NOMINAL VALUE	UNITS
Density:	ASTM D792	1.17	g/cm <sup>3</sup>
<b>THERMAL</b>			
Melt Flow Index	ASTM D1238	0.7	g/10 min (190 °C/10 kg)
Melting Temperature Range:	ASTM D3418	122 - 136	° C
<b>ADDITIONAL INFORMATION</b>			
Moisture Content: <sup>(1)</sup>	ASTM D6980	1.0	%
<b>MECHANICAL PROPERTIES <sup>(2)</sup></b>			
<b>Tensile Properties</b>			
Secant Modulus @ 1%	ASTM D638	568	MPa
Tensile Strength at Break	ASTM D638	19	MPa
Elongation at Break	ASTM D638	12	%
<b>Flexural Properties</b>			
Flexural Modulus	ASTM D790	708	MPa
<b>Notched Impact Strength</b>			
Izod - Notched	ASTM D256	47	J/m
<b>FILM PROPERTIES <sup>(3)</sup></b>			
<b>Tensile Strength</b>			
MD	ASTM D882	2958	psi
TD	ASTM D882	2475	psi
<b>Elongation at Break</b>			
MD	ASTM D882	518	%
TD	ASTM D882	657	%
<b>Elmendorf Tear</b>			
MD	ASTM D1922	287	g
TD	ASTM D1922	567	g
<b>Dart Drop Test</b>			
	ASTM D1709	84	g

Table Notes:

- 1) Moisture content was measured with an infrared moisture analyzer at 110°C for 10 minutes.
- 2) Mechanical properties were measured on injection molded parts made directly from the 50% NuPlastiQ / 50% polyethylene masterbatch.
- 3) The reported film properties are for a monolayer blown film that was let-down with 50% additional LLDPE to a concentration of 25% NuPlastiQ. The thickness was 1.0 mil, and the blow-up ratio was 2.5:1.
- 4) These values are typical properties only and should not be used for specification purposes. End users should confirm results with their own tests.

## Processing Considerations

- XP 24875 is designed to be diluted with polyethylene to a final NuPlastiQ® content between 10% and 40%.
- XP 24875 can be run on existing process equipment with a few adjustments.
- Films made with NuPlastiQ are more sensitive to processing conditions such as temperature profile, residence time, die gap, and blow-up ratio. See the NuPlastiQ Film Processing Guide for additional information.
  - A typical recommended temperature profile will be in the 160°C – 190°C range.
  - Depending on equipment, process conditions, and residence time, as temperatures increase in this range the glycerin plasticizer may experience some volatilization. This may cause a slight odor and/or smoke and is expected under normal processing conditions. Always use proper ventilation. See the BioBlend® XP 24875 SDS for details.
- Some equipment (multi-layer, higher output, lower residence time) may allow for higher processing temperatures (190°C - 200°C).
- Melt temperatures above 205°C may cause material degradation, lensing and fish-eyes in the film.
- When extruder operation has to be stopped temporarily, it is recommended to purge the material in the barrel before resuming film processing.

## Packaging

- XD 24875 can be shipped in the following formats:
  - 25kg moisture barrier bags.
  - 1000kg gaylord boxes with a moisture barrier bag.

## Storage

- XD 24875 should be stored in a dry location away from heat and direct sunlight. Material must remain sealed in moisture barrier bag until used. Material should be stored under normal warehouse conditions (typical max temperature of 80°F/26°C.)

## Drying

- BioLogiQ BioBlends are dried after production and shipped in sealed moisture-proof bags that are ready to use as supplied. They should be stored indoors in the sealed container away from heat until used.
- If pellets are exposed to a humid environment, they will absorb moisture from the air. If needed, dry pellets by introducing warm dry air at no more than 80°C for 1-4 hours.
- The estimated moisture content of a BioLogiQ BioBlend can be measured with an infrared moisture analyzer at 110°C for 10 minutes. The result of the measurement will not perfectly equal the moisture content, due to possible partial evaporation of plasticizer.