



Density ( )	1.492 g/cm <sup>3</sup>	ASTM D792	ISO 1183
Melt Flow Rate (190°C/2.16kg)	*** see note above *** g/10 min	ASTM D1238	ISO 1133

Thermal	Nominal Values	Test Method(s)	
Melting Point (Biomax(R) TPS is an amorphous polymer. Glass Transition Temperature (T <sub>g</sub> ) by DMA is reported here for reference.)	-3°C (27°F)		
Vicat Softening Point ( )	70°C (158°F)	ASTM D1525	ISO 306

## Processing Information

### General

Maximum Processing Temperature	200°C (392°F)
General Processing Information	<p>DRYING:</p> <p>The resin should be dried at 70C. The length of time depends on the initial moisture content of the resin. Ideal injection molding processing moisture level is 2% to 3%. If you need additional information on drying technology, and / or appropriate methods and equipment for measuring moisture content of the polymer, please contact your DuPont Technical representative,</p> <p>INJECTION MOLDING:</p> <p>Best processing has been determined with a 3 zone screw used for polyolefins with a compression ratio of 2.3 to 1 or lower, ideally lower than 2 to 1.</p>

### Injection Molding Processing

Injection Processing Information	Nominal Values
Injection Processing Information	The mold temperature is recommended to be set initially at approximately 40C.
Feed Zone	130°C (266°F)
Second Zone	160°C (320°F)
Third Zone	160°C (320°F)
Fourth Zone	165°C (329°F)
Fifth Zone	165°C (329°F)
Adapter Zone	175°C (347°F)
Die Zone	175°C (347°F)

### Regulatory Information

For information on regulatory compliance, consult your local DuPont representative.

### Safety & Handling

Pellets become slippery when wet. Carefully wipe up pellets that have spilled onto wet floors to prevent slipping hazards. Avoid processing temperatures in excess of 200 deg. C (392 deg.F)

Biomax(R) TPS resins as supplied by DuPont are not considered hazardous materials. As with any hot material, care should be taken to protect the hands and other exposed parts of the body when handling molten polymer. At recommended processing temperatures, small amounts of fumes may evolve from the resins. When resins are overheated, more extensive decomposition may occur. Adequate ventilation should be provided to remove fumes from the work area. Disposal of scrap presents no special problems and can be by landfill or incineration in a properly operated incinerator. Disposal should comply with local, state, and federal regulations. Resin pellets can be a slipping hazard. Loose pellets should be swept up promptly to prevent falls. For more detailed information on the safe handling and disposal of DuPont resins, a Material Safety Data Sheet can be obtained from the DuPont Packaging and Industrial Polymers website or by contacting your sales representative.

**Read and Understand the Material Safety Data Sheet (MSDS) before using this product**

## Regional Centres

DuPont operates in more than 70 countries. For help finding a local representative, please contact one of the following regional customer contact centers:

### Americas

DuPont Company, BMP26-2363  
Lancaster Pike & Route 141  
Wilmington, DE 19805 U.S.A.  
Telephone +1 302-774-1161  
Toll-free (USA) 800-628-6208  
Fax +1 302-999-4399

DuPont do Brasil, S.A.  
Alameda Itapecuru, 506  
06454-080 Barueri, SP Brasil  
Telephone +55 11 4166 8122  
Fax +55 11 4166 8720

### Asia Pacific

DuPont China Holding Co., Ltd.  
Shanghai Branch  
399 Keyuan Road, Bldg. 11  
Zhangjiang Hi-Tech Park  
Pudong New District, Shanghai  
P.R. China (Postcode: 201203)  
Telephone +86 21 3862 2888  
Fax +86-21-3862-2889

### Europe / Middle East / Africa

DuPont de Nemours Int'l. S.A.  
2, Chemin du Pavillon Box 50  
CH-1218 Le Grand Saconnex  
Geneva, Switzerland  
Telephone +41 22 717 51 11  
Fax +41 22 717 55 00

<http://biomax.dupont.com>

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