



Beocycle PE RTM294 Ocean Teal UV

Material Technical Data Sheet

Date of issue: 19/01/2024 Version: 3.5

SECTION 1: Identification of the substance/mixture and of the company/undertaking

1.1. Product identifier

Product form	: Powder
Name	: Beocycle PE RTM294 Ocean Teal UV
Product code	: 9802100293
Application	: Rotomoulding
Composition	: 33% recycled PE + 67% virgin PE and additives
Origin of end-of-use polymers	: This product contains packaging waste - a range of post-consumer recycled (PCR) raw material. The material is collected, cleaned, sorted and re-used by upgrading the material to a higher quality composite.

1.2. Details of the supplier of the material specification sheet

Manufacturer

Beologic
 Jolainstraat 44
 8554 Sint-Denijs
info@beologic.com

SECTION 2: Physical, mechanical and thermal properties

2.1. Information on basic physical, mechanical and thermal properties

Properties ⁽¹⁾	Method	Typical Value	Unit
Physical			
Physical state		Solid	
Recycled content		33	%
Relative density	ISO 1183-1	0,93	g/cm ³
MFI (190°C, 2,16 kg)	ISO 1133-1	4,0	g/10min
Coloured in mass		No	
Colour material		Teal	
UV package		Extra	
Carbon footprint ⁽²⁾	PAS 2050	1,4892*	kg CO ₂ Eq/ kg
Shelf life ⁽³⁾		6-12	Months
Mechanical			
Tensile modulus	ISO 527-1	464	MPa
Tensile strength at yield	ISO 527-1	16	MPa
Break stress	ISO 527-1	15	MPa
Elongation at break	ISO 527-1	>756	%
Flexural modulus	ISO 178	632	MPa
Charpy impact strength (Notched 1eA , 23 °C)	ISO 179-1	11	kJ/m ²

(1) Typical properties; not to be construed as specifications.

(2) Carbon footprint calculated by Neurologic

(3) Only if storage conditions (section 5) were followed

*Due to continuous variation of feedstock this figure reflects value of September 2022. Update latest carbon footprint available on request.

2.2. Product Carbon footprint

The product carbon footprint helps to define the amount of greenhouse gas emissions generated by a product along its life cycle, it quantifies the ghg-emissions related to the production of our products.

Neurologic calculates the carbon footprint of all sales products and this from cradle to gate.

The calculation of the carbon footprint is in accordance with the internationally recognized Greenhouse Gas Protocol Product Standard which is based on the standard ISO-14067 norm and PAS2050.

The carbon footprint is mentioned in our datasheet - by offsetting or compensating the calculated emissions we can present our products as Carbon Neutral compounds. This compensation is according the Verified Carbon Standard – more info via (www.v-c-s.org).



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2.3. Circularity and ecology

Beocycle PE RTM294 Ocean Teal UV is a sustainable compound and it has an impact on our ecology as we avoid plastic pollution of our oceans/ of our seas. We are actively working on circularity as we design this product to be durable and recyclable, depending on the end application you could even further decrease CO2 emissions.

By using **Beocycle PE RTM294 Ocean Teal UV** as raw material choice you directly contribute to further closing the material loops, reducing landfilling, marine pollution and loss of valuable resources.

SECTION 3: Processing conditions-guidelines

3.1. Processing procedure – lab environment:

1. Procedure based on inner mould temperature/inner air temperature (IAT) measured on lab scale.
2. IAT start at 120°C – 130°C and gradually increase with step of 5°C to 185°C – 200°C.
3. PIAT ≤ 200°C.
4. Residence time : depending on application or product fe. 100 gr – 20 minutes.
5. Check energy absorption of the product.

3.2. Processing measurements- lab scale environment

Powder pick-up temperature (°C)	65 - 75
Optimum PIAT (°C)	185-200°C
Demolding temperature (°C)	60 - 70
Thickness distribution	Excellent

SECTION 4: General advice

4.1. General info

Beocycle PE RTM294 Ocean Teal UV is not compatible with a wide variety of polyolefins some special sequences should be followed:

1. Before production, ensure to clean equipment and check oven temperature to a controlled condition.
2. Vacuum out on any hopper/blending or other mixture equipment system to avoid contamination.
3. Introduce **Beocycle PE RTM294 Ocean Teal UV** into the equipment at the operating conditions.
4. Once **Beocycle PE RTM294 Ocean Teal UV** is introduced, check inner air temperature.
5. At shutdown, clean your equipment and remove all remaining residue from the mould.

At higher temperature, the dwell time of the material inside the machine shall be reduced to a minimum in order to lower the risk of degradation. Do not leave the material hot inside the machine for long periods as the material will degrade.

SECTION 5: Drying and storage conditions

Beocycle PE RTM294 Ocean Teal UV is supplied with a low residual moisture content and does not need any drying. If the material needs to be dried, we recommend drying **Beocycle PE RTM294 Ocean Teal UV** max 70°C for 4 hours. Don't overheat or dry it longer than recommended. Residual moisture content (> 0.2%) can result in lower melt stability, surface mark or bubble formation during processing.

We recommend to store the material in dry conditions below 50°C and protected from UV-light. Opened (big)bags should be used immediately or adequately sealed back up after use to avoid moisture uptake and have negative effects on the physical properties of the product. It is recommended to use Beocycle powder within a time period of maximum 6 months.

Finished product made from Beocycle should be stored dry and cold. Storage time and lifetime of finished products depends on processing parameters and on storage conditions (moisture, UV radiation ...).