

## Biodegradable Polymers

### Product Information

**Version 1.0**

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G-PM/PB

# ecovio<sup>®</sup> F2223

## Biodegradable compound for compostable film

® = ecovio and ecoflex are registered trademarks of BASF SE

### Product Description

ecovio<sup>®</sup> F2223 is one of our biodegradable film products partly based on renewable resources. It is basically a compound of our biodegradable, aliphatic-aromatic copolyester ecoflex<sup>®</sup> F and polylactic acid (PLA). ecovio<sup>®</sup> F2223 already contains a slip agent required for easy processing on film extrusion and film conversion equipment. ecoflex<sup>®</sup> F is the continuous phase in the structure of ecovio<sup>®</sup> F2223 transferring the beneficial film properties of ecoflex<sup>®</sup> F into the product.

ecovio® F2223 exhibits the following properties:


- High melt strength
- Good thermostability up to 230°C
- Excellent processability on conventional LDPE blown film lines
- High strength, stiffness and failure energy (dart drop)
- Typical thicknesses: 20-120 µm
- Good processability on bag making equipment
- Wet strength (e.g. needed in organic waste bag applications)
- Nice white translucent color
- Excellent welding properties
- Printable in 8 colors by flexo printing

ecovio® F2223 exhibits excellent compatibility to ecoflex®, polylactic acid and other biodegradable polymers. According to our experience pre-drying of ecovio® F2223 is not required if the granules are taken from an unopened bag.


The processing of ecovio® F2223 on extrusion lines depends on the formulation, the extrusion technology and processing conditions. Trials are always recommended to assess the quality of the final product. ecoflex® masterbatches are available to tailor the slip and anti-bloc properties of the final product. Detailed information concerning our ecoflex® masterbatches will be sent upon request.

Certification of Compostability and Biodegradability


ecovio® F2223 is a biodegradable & compostable compound. Available certificates:



European standard  
EN 13432  
Australian standard  
AS 4736



American standard  
ASTM 6400



European standard  
EN 13432

Norm	EN 13432 (EU)		ASTM D 6400 (USA)
Certification Body	DIN Certco	TÜV Austria	BPI
Certification Number	7W0085	TA8011702346	890989-3

Food Contact Regulation

Food contact certificates for ecoflex® and ecovio® grades including information about specific limitations and details concerning the food contact status for different regions can be obtained upon request via a local BASF representative or by contacting [plastics.safety@basf.com](mailto:plastics.safety@basf.com). The suitability of the article for the application concerned must be ensured in each case by the person who places any finished food contact article on the market.

Form Supplied and Storage

ecovio® F2223 is supplied as lenticular shaped pellets in 1 t big bags. Temperatures during transportation and storage may not exceed 60°C at any time. Storage time in an unopened bag may not surpass 12 month at room temperature (23°C).

## Quality Control

ecovio® F2223 is produced as a standard material in a continuous production process according to DIN EN ISO 9001. The melt volume rate, MVR, at 190°C, 5 kg, according to ISO 1133 has been defined as specified parameter for quality control. A certificate can be provided with each lot number upon request. The ecovio® granules have to be pre-dried (6 hours at 70 °C) before MVR measurement in order to obtain accurate values. Other data given in our literature are typical values, which are not part of our product specification for ecovio® F2223.

## Applications

ecovio® F2223 has been developed for the conversion to flexible films using a blown film process. Typical applications are packaging films, hygienic films, carrier bags. In view of numerous factors influencing functionality and shelf life of ecovio® films and finished articles made thereof the production parameters have to be tested by the converters before utilisation. Additionally sufficient field tests are required to ensure the right functionality of the articles made from ecovio® F2223.

We supply technical service information concerning the blown film process with ecovio® F2223 on demand.

## Typical Basic Material Properties of ecovio® F2223

\*see Quality Control

Property	Unit	Test Method	ecovio® F2223
Mass Density	g/cm³	ISO 1183	1.24 - 1.26
Bulk Density	kg/m³	DIN EN ISO 60	770
Melt Volume Rate MVR 190°C, 5 kg*	ml/10 min.	ISO 1133	3.5 - 7.5
Melting Points	°C °C	DSC DSC	110 -120 140 -155

## Typical Properties\* of ecovio® F2223 Blown Film, 30 µm

\*not to be construed as specifications

Property	Unit	Test Method	ecovio® F2223
Tensile Modulus MD/TD	MPa	ISO 527	760/350
Tensile Strength MD/TD	MPa	ISO 527	47/43
Ultimate Elongation MD/TD	%	ISO 527	450/600
Dart Drop	g	ASTM D 1709-04 Method A	450
Tear Resistance	mN	DIN EN ISO 6383-2	500/450

## Note

The information submitted in this document is based on our current knowledge and experience. In view of the many factors that may affect processing and application, these data do not relieve processors of the responsibility of carrying out their own tests and experiments; neither do they imply any legally binding assurance for a special purpose. It is the responsibility of those to whom we supply our products to ensure that any proprietary rights and existing laws and legislation are observed. (January 2023)