



TECHNICAL DATA SHEET  
**MADE FROM STONE™ BC05**  
BOARD SUBSTRATE HDPE



04/26 REVISION

# MADE FROM STONE™ BC05

BOARD SUBSTRATE HDPE

## PRODUCT DESCRIPTION

BC05 is a patented ecological mineral compound tailored for sheet extrusion with adequate back pressure capability for viscous molten material. BC05 is specially developed to produce paper replacement board substrate (hot & cold beverage cups, food trays, takeaway containers, fast-food packaging, etc.)

This grade is based on treated calcium carbonate (CaCO<sub>3</sub> 65%) with excellent dispersion rate, combined with high molecular weight HDPE enhances mechanical properties, and is easy to process. It brings stiffness and strength allowing to downgauge without impairing original key mechanical properties. Furthermore, BC05 brings additional process advantages, improves printability and allows processing speed to increase by decreasing drive amps and back pressure resulting in increased extruder thru-put. The thermal conductivity of BC05 promotes higher volumetric output and cools faster as the material exits the die. BC05 can be processed at 100% without additional resin. Other functional materials can be co-blended during extrusion to enhance desired properties.

PROPERTIES	TARGET VALUE	METHOD
Calcium Carbonate Content (%)	65	-
Polymer (%)	34.8%	-
Moisture (%)	≤ 0.05	ASTM D6980
Ash (%)	63 - 65	ASTMD 5630
Density (g/cm <sup>3</sup> )	1.60 - 1.65	ASTM D792-07
MFI (g/ 10 min @190°C/ 2.16kg)	0.35-0.75	ASTM D1238
Dispersion (FPV bar/g)	≤3	INTERNAL

## CODE & PACKAGING

Code Number: BC05  
25kg bags, available in one ton supersacks in selected market.

## MAIN APPLICATIONS

Hot & cold beverage cups, corrugation.

## ADDITIONAL PROPERTIES

Ideal for faster degradation by using our Bioterra™ and Hydroterra™ additives.

## PROCESSING STATEMENT

Extrusion temperature: 170-200°C.

## AVAILABILITY

This product is available worldwide, currently being produced in Ecuador and India.



## FOOD REGULATIONS

BC05 is suitable for food contact application. Upon request, detailed information can be provided in relevant Okeanos Regulatory Statements. For additional specific information, please contact Okeanos' compliance representative at [legal@madefromstone.com](mailto:legal@madefromstone.com)

## STORAGE & HANDLING

This product should be stored in a manner to prevent a direct exposure to sunlight and/ or heat. The storage area should also be dry and preferably don't exceed 50°C. Okeanos would not give warranty to bad storage conditions which may lead to quality deterioration such as color change, bad smell and inadequate product performance. It is advisable to process this compound within 12 months after delivery.

## SUSTAINABILITY & COMPLIANCE

Okeanos offers comparative LCA reports (Life Cycle Analysis) customized for the country of origin and manufacturing, versus the baseline original product. Other tools like a consumer drive QR Code are also available.

## BRANDING

Okeanos provides our brand partners with a suite of tools used to amplify messaging around your new product Made From Stone! Please note that the use of this compound does not grant automatic permission to use these branding tools. Please contact your local representative or Okeanos support. To learn more visit [okeanos.global/brand-guidelines](https://okeanos.global/brand-guidelines)

## CONTACT INFORMATION

Contact your local representative, or reach us at [support@madefromstone.com](mailto:support@madefromstone.com) if you have any questions, or need additional documentation on this product, or visit [okeanos.global](https://okeanos.global)

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This product is not intended for the use in medical applications and should not be used in any such applications.  
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