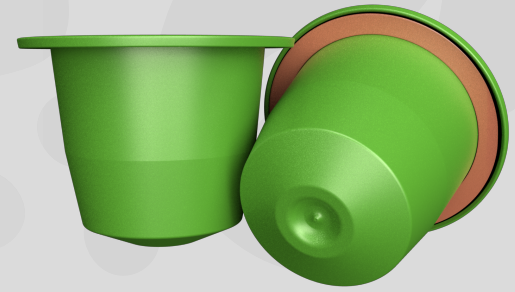




N-POD

HOME COMPOSTABLE



Product:

N-Pod Home compostable capsule: injection moulded home compostable biopolymer capsule with cellulose ring

Capsule Material

- The material of our home compostable capsule is a biopolymer in the sense of the regulation EU 10/2011
- The material is based on 100% renewable raw materials
- All monomers contained in our biopolymer have already been approved by the EFSA (European Food Safety) and are known.
- The material as well as the capsules made from it are free from aluminium
- All materials used are GMO and Pesticide-free
- California Prop 65 compliant

Production

- Country: Germany
- According to quality standard ISO 9001 (2015) and the hygiene regulation DIN EN15593/2008
- From renewable energies

Capsule

OTR	0.0059 cm ³ / capsule / day (0.21bar - @23°C, 50% RH))
WVTR	0.0041 g / capsule / day (@23°C, 85%RH)
Height	28.2 ± 0.2 mm
Outer diameter	37.0 ± 0.2 mm
Weight	1.7 ± 0.2 g
Wall thickness	0.45 ± 0.1 mm
Volume	approx. 13.4 cm ³
Inner surface of the capsule body	approx. 22.2cm ²

Capsule & Ring Colors

Capsule Colors (ring white)

- black
- brown
- red
- orange
- yellow
- dark green
- light green
- bio green
- dark blue
- light blue

Ring Colors (capsule white)

- black
- brown
- red
- orange
- yellow
- dark green
- light green
- dark blue
- light blue
- purple

Storage

- Unfilled: storable for up to 24 months
 - Relative humidity of up to 60%
 - Temperature range: +5 °C to +35° C
- Filled: shelf life of 12 months if using the recommended sealing paper and ensuring a hermetic sealing

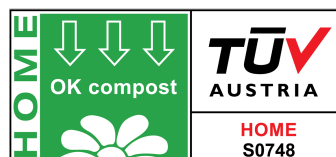
Logistics

- Packaging unit: 40,000 pieces as bulk goods in cardboard box with a protective PE bag
- Pallet: Euro pallet: 120x80cm 1 parking space corresponds to 2 cardboard boxes with 2 pallets on top of each other
- Total weight per storage space approx. 200 kg
- During transportation Max. allowable temperature peek -10°C to 65°C

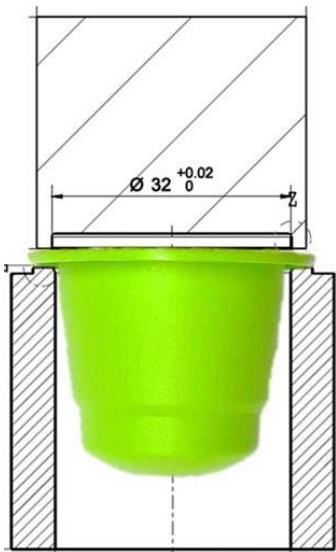
Food Contact

- Global and Specific Migration Analysis made in accordance with EU 10/2011
 - Crotonic acid CAS 3724-65-0 Free
 - PHBH Oligomers3 Free
 - PFAS und PFOA Free
 - Pesticide Free
 - Bisphenol A Free
 - Heavy meatal Free
- FDA for US approved

Environmental Certifications

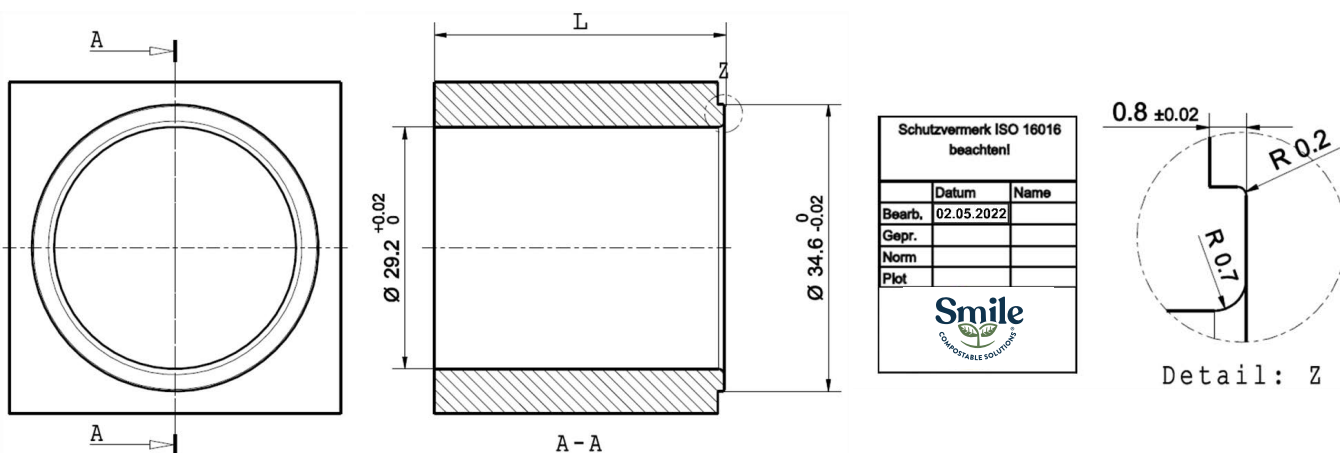


FORMAT PLATES AND SEALING HEAD



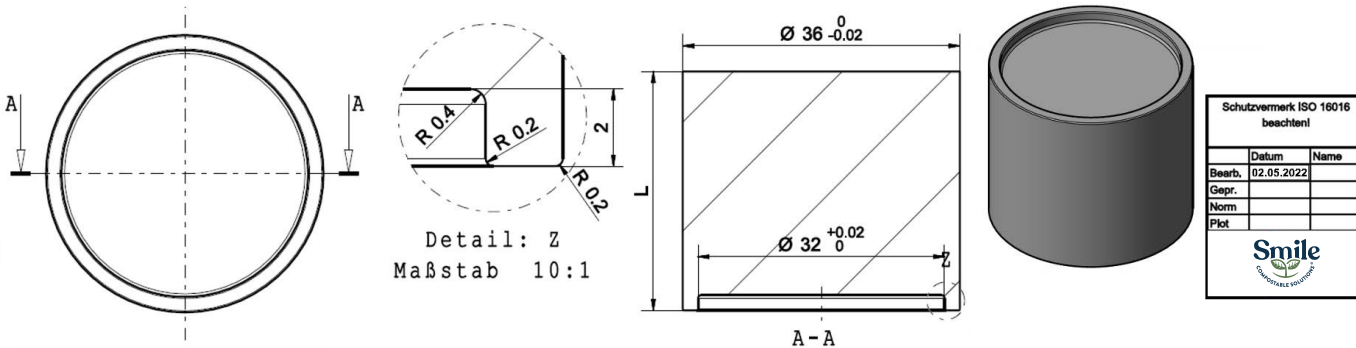
Design of the capsule holder in the format plate

For inclusion of our capsules in the format plates we recommend the geometry according to following drawing. Dimensions given with the value "L" are determined by the machine manufacturer.



Design of the sealing head

To seal the lid on our capsules we recommend the geometry according to the following drawing. Dimensions given with the value "L" are determined by the machine manufacturer.

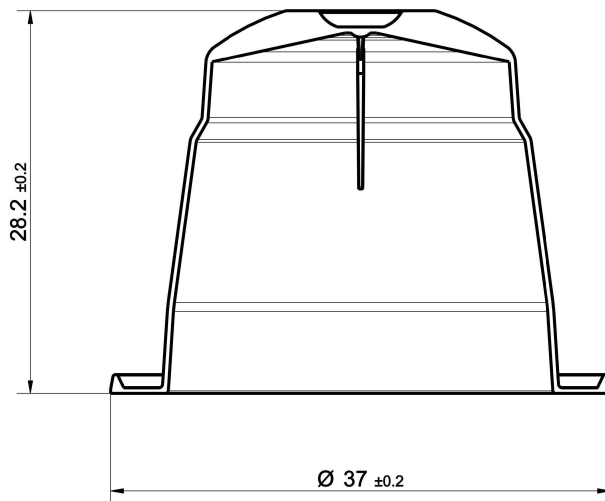


Parameters for the lid sealing (lid paper: Jura-tech JA+H)

Attention, displayed values are laboratory values and must be adapted according to the respective filling machine.

Description	Value	Unit
Temperature (measured directly on the sealing surface)	210-240	[°C]
Force of the pneumatic cylinder	1250	[N]
Sealing duration	400-500	[ms]
Burst pressure	0.6	[bar]

After sealing, care must be taken that the internal pressure in the capsule created by the escaping gases from the coffee does not exceed 0.4 bar relative to the ambient pressure. The coffee has to be degassed sufficiently before filling.



Maximum wall thickness offset = 0,1 mm
Stacking height ≈ 10 mm

Baupennr.:						Projektnr.:	
Baupennname:						Projektname:	
Oberflächen n. DIN 1302						Maßstab	Dosname
Freimaßtoleranzen m. DIN 7168 fein						Format A 4	
Schutzvermerk ISO 16016 beachten!						Positionsnr	
0,5-6	6,0-30	30-120	120-400	400-1000	1000-2000		
±0,05	±0,1	±0,15	±0,2	±0,3	±0,5		
○						Datum	Name
○						Bearb.	24.06.2022
○						Gepr.	
○						Norm	
○						Pict	
○						Home Compostable Capsule	
○							
○						Zeichnungsnummer	Blatt
○						HC - cap V1	
Index	Änderung	Datum	Name				



Capsule Colors (ring white)



Black
Art. -Nr. 15000



Brown
Art. -Nr. 15010



Red
Art. -Nr. 15020



Dark Green
Art. -Nr. 15030



Light Green
Art. -Nr. 15040



Bio Green
Art. -Nr. 15050



Light Blue
Art. -Nr. 15060



Dark Blue
Art. -Nr. 15070



Orange
Art. -Nr. 15080



Yellow
Art. -Nr. 15090

Ring Colors (capsule white)



Black
Art. -Nr. 15600



Brown
Art. -Nr. 15610



Dark Blue
Art. -Nr. 15620



Light Blue
Art. -Nr. 15630



Dark Green
Art. -Nr. 15640



Light Green
Art. -Nr. 15650



Red
Art. -Nr. 15660



Orange
Art. -Nr. 15670



Yellow
Art. -Nr. 15680



Purple
Art. -Nr. 15690