

## Description

PLA-based compound with degradable short glass fiber reinforcement for injection moulding.

Property, Test Condition	Standard	Unit	Values
<b>Mechanical Properties</b>			
Flexural Strength, 23 °C	ISO 178	MPa	120
Flexural Modulus, 23 °C	ISO 178	MPa	5000
Izod Notched Impact Strength, 23 °C	ISO 180/A	kJ/m <sup>2</sup>	10
Izod Unnotched, 23 °C	ISO 180/U	kJ/m <sup>2</sup>	38
Charpy Notched Impact Strength, 23° C	ISO 179/1eA	kJ/m <sup>2</sup>	
Charpy Unnotched, 23 °C	ISO 179/1eU	kJ/m <sup>2</sup>	
Tensile Strength at Yield, 23 °C	ISO 527	MPa	
Tensile Strain at Yield, 23 °C	ISO 527	%	
Tensile Strength at Break, 23 °C	ISO 527	MPa	73
Tensile Strain at Break, 23 °C	ISO 527	%	3
Tensile Modulus	ISO 527	MPa	5400
Ball Indentation Hardness	ISO 2039-1	N/mm <sup>2</sup>	
<b>Thermal Properties</b>			
Vicat Softening Temperature VST/B/50 (50N, 50 °C/h)	ISO 306	°C	
Heat Deflection Temperature A; (1.8 MPa) *	ISO 75	°C	62
Heat Deflection Temperature B; (0.45 MPa)	ISO 75	°C	107
<b>Other Properties</b>			
Density	ISO 1183	g/cm <sup>3</sup>	1,4
Melt Flow Rate [200 °C/ 5 kg]	ISO 1133	g/10 min	30

The properties stated above are not for specification purposes.

\* Mold temperature 30°C

**Processing**

ArcBiox™ materials must be always dried before processing with dehumidifying dryer, due to fact that insufficient drying before processing will cause loss of mechanical properties. Please note that a combination of a very long drying time and high temperature may cause degradation and agglomeration of pellets and may cause yellowing.

Property, Test Condition	Standard	Unit	Values
<b>Processing</b>			
Linear Mold Shrinkage (Note 2.)	ISO 294-4	%	0,1-0,3
Melt Temperature Range		°C	180-210
Feed Throat		°C	30-50
Feed Temperature		°C	170-190
Compression Section		°C	180-200
Metering Section		°C	180-200
Nozzle		°C	180-200
Mold Temperature Range		°C	20-40
Injection Velocity		mm/s	medium
Back Pressure		bar	10-20
Drying Temperature, Dew point -40°C (Note 2.)		°C	80
Drying Time		h	5

Note 1. Moisture content less than 0.025% (250 ppm) is recommended to prevent loss of mechanical properties.

Note 2. Shrinkage value is measured from test part (4x70x150mm) that is moulded at 30°C mould temperature.

Change-over point should be always checked visually by setting holding pressure to 0 bar/MPa to avoid over filling and flashes. Part should be 95 – 98% filled before changing to holding pressure.

Use low MFR Polypropylene to clean the screw and barrel.

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