

ArcBiox™ materials are bio-based and/or biodegradable compounds. These high-performance materials provide sustainable green alternatives for demanding technical applications.

Description

Impact resistant PLA (Polylactic acid) for injection moulding designed also for processing with a cold mould (30-40 °C) with a reduced cycle time

Features

- Good impact resistance also when processed with a cold mould
- Good surface quality and colorability
- Biocontent 90 %

Applications

- Alternative for ABS
- Housings and other technical applications where good impact properties are needed

Property, Test Condition	Standard	Unit	Values
Mechanical Properties			
Flexural Strength, 23 °C	ISO 178	MPa	87 (81)
Flexural Modulus, 23 °C	ISO 178	MPa	3550 (2960)
Izod Notched Impact Strength, 23 °C	ISO 180/A	kJ/m ²	55 (19)
Izod Unnotched, 23 °C	ISO 180/A	kJ/m ²	NB (NB)
Charpy Notched Impact Strength, 23° C	ISO 179/1eA	kJ/m ²	60 (20)
Charpy Unnotched, 23 °C	ISO 179/1eU	kJ/m ²	NB (NB)
Tensile Stress at Yield, 23 °C	ISO 527	MPa	46 (50)
Tensile Strain at Yield, 23 °C	ISO 527	%	2 (2)
Tensile Stress at Break, 23 °C	ISO 527	MPa	37 (10)
Tensile Strain at Break, 23 °C	ISO 527	%	>5 (>5)
Tensile Modulus	ISO 527	MPa	3400 (2950)
Ball Indentation Hardness	ISO 2039-1	N/mm ²	178 (145) (HB 961)
Thermal Properties			
Vicat Softening Temperature VST/B/50 (50N, 50 °C/h)	ISO 306	°C	85 (57)
Heat Deflection Temperature A; (1.8 MPa)	ISO 75	°C	63 (50)
Heat Deflection Temperature B; (0.45 MPa)	ISO 75	°C	80 (53)
Other Properties			
Density	ISO 1183	g/cm ³	1,2
Melt Flow Rate [200 °C/ 5 kg (230 °C/ 2.16 kg)]	ISO 1133	cm ³ /10min	11 (10)

Typical values for uncolored products. The properties stated above are not for specification purposes.
Mold temperature 110°C (30 °C)

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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
Processing			
Linear Mold Shrinkage (Note 3.)	ISO 294-4	%	1,4-1,6
Melt Temperature Range		°C	180-200
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; amorphous, cooling time according to part		°C	20-40
Mold Temperature Range; crystalline, cooling time min. 50s (Note 1.)		°C	100-120
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. Holding pressure time is part of cooling time and can be decreased from this value

Note 2. Moisture content less than 0.025% (250 ppm) is recommended to prevent loss of mechanical properties.

Note 3. Shrinkage value is measured from test part (4x70x150mm) that is moulded at 110°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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