

# LACEA® H-100J (Unstretched)

Polylactic Acid  
Mitsui Chemicals, Inc.

Message:

LACEA®H-100J (Unstretched) is a polylactic acid (PLA) material. This product is available in the Asia-Pacific region and is processed by blow molding or injection molding. LACEA®The main characteristics of H-100J (Unstretched) are: environmental protection/green.  
Typical application areas include:  
bag/lining  
packing  
Movie  
container  
non-woven fabric

General Information			
Features	Biodegradable		
Uses	Packaging		
	Films		
	Bags		
	Container		
	Non-woven fabric		
Appearance	Clear/transparent		
Forms	Particle		
Processing Method	Blow film		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.26	g/cm <sup>3</sup>	ASTM D1505
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			ASTM D785
L scale	84		ASTM D785
Class r	115		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	68.0	MPa	ASTM D638
Tensile Elongation (Yield)	4.0	%	ASTM D638
Flexural Modulus	3700	MPa	ASTM D790
Flexural Strength	98.0	MPa	ASTM D790
Films	Nominal Value	Unit	Test Method
Film Thickness - Tested	250	μm	
Secant Modulus - MD	2000	MPa	ASTM D882
Tensile Strength - MD (Yield)	70.0	MPa	ASTM D882
Tensile Elongation - MD (Break)	5.0	%	ASTM D882

Oxygen Permeability	60	cm <sup>3</sup> ·mm/m <sup>2</sup> /atm/24 hr	ASTM D3985
Water Vapor Transmission	30	g/m <sup>2</sup> /24 hr	ASTM E96
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	29	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed)	55.0	°C	ASTM D648
Vicat Softening Temperature	58.0	°C	ASTM D1525

#### Additional Information

The value listed as Oxygen Permeability, ASTM D3985, was tested in accordance with JIS-K7126. The value listed as Water Vapor Transmission, ASTM E96, was tested in accordance with JIS-K7129. The value listed as Density, ASTM D1505, was tested in accordance with JIS-K6758. The value listed as Tensile Strength @ Yld MD, ASTM D882, was tested in accordance with JIS-C2318. The value listed as Elongation @ Break MD, ASTM D882, was tested in accordance with JIS-C2318. The value listed as Secant Modulus MD, ASTM D882, was tested in accordance with JIS-C2318. Oxygen Permeability, JIS-K7126. 23°C, Method A: 60 cm<sup>3</sup>/m<sup>2</sup>/day/atm Nitrogen Permeability, JIS-K7126. 23°C, Method A: 4 cm<sup>3</sup>/m<sup>2</sup>/day/atm CO<sub>2</sub> Permeability, JIS-K7126. 23°C, Method A: 120 cm<sup>3</sup>/m<sup>2</sup>/day/atm

Injection	Nominal Value	Unit
Rear Temperature	150 - 160	°C
Middle Temperature	160 - 180	°C
Front Temperature	170 - 190	°C
Nozzle Temperature	160 - 180	°C
Mold Temperature	20.0 - 30.0	°C

#### Injection instructions

Cooling Time: 30 to 40 sec

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#### Recommended distributors for this material

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