

EcoBlend® HCL7140

Polylactic Acid + PMMA

Shanghai KumhoSunny Plastics Co., Ltd.

Message:

HCL7140 is a kind of appending 40%~50% biological base plastic environmental PLA/PMMA resin.HCL7140 has excellent mechanical properties and super heat stability.HCL7140 is mainly used in ornament & housing of small appliance,etc.

General Information			
Features	Good Thermal Stability		
	Renewable Resource Content		
Uses	Appliances		
	Housings		
UL File Number	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
220°C/10.0 kg	6.6	g/10 min	
240°C/5.0 kg	6.6	g/10 min	
Molding Shrinkage - Flow	0.50 to 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	53.0	MPa	ASTM D638
Tensile Elongation (Break)	12	%	ASTM D638
Flexural Modulus	2250	MPa	ASTM D790
Flexural Strength	76.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	580	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	115	°C	ASTM D648
Vicat Softening Temperature	76.5	°C	ASTM D1525 ¹
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	ohms · cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Additional Information	Nominal Value	Unit	
Biobased Content	40 to 50	%	

CSA File No.	LS 66457	
Injection	Nominal Value	Unit
Drying Temperature	80.0 to 90.0	°C
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	190 to 200	°C
Middle Temperature	210 to 220	°C
Front Temperature	220 to 230	°C
Nozzle Temperature	215 to 225	°C
Processing (Melt) Temp	220 to 230	°C
Mold Temperature	60.0 to 80.0	°C
Back Pressure	1.00 to 5.00	MPa
Screw Speed	30 to 60	rpm
NOTE		
1.	Rate B (120°C/h)	

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