

TRANSMARE® BIO 35MI-10-0.001

Polylactic Acid

Transmare Compounding B.V.

Message:

TRANSMARE® BIO 35MI-10-0.001 is a PLA INGEO™ based impact modified biopolymer with good flow and impact properties.

General Information			
Additive	Impact modifier		
Features	Impact modification		
	Rigidity, high		
	Impact resistance, good		
	Updatable resources		
	Recyclable materials		
	Good liquidity		
Forms	Particles		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.25	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	30	g/10 min	ISO 1133
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D, Injection Molded)	73		ISO 868
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C, 4.00 mm, Injection Molded)	2370	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/50
Yield, 4.00mm, injection molding	42.0	MPa	ISO 527-2/50
Fracture, 4.00mm, injection molding	20.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2/50
Yield, 4.00mm, injection molding	2.4	%	ISO 527-2/50
Fracture, 4.00mm, injection molding	6.0	%	ISO 527-2/50
Flexural Modulus (Injection Molded)	2380	MPa	ISO 178
Flexural Stress (Injection Molded)	60.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1A
-40°C, injection molding	1.5	kJ/m²	ISO 179/1A
-20°C, injection molding	3.5	kJ/m²	ISO 179/1A
0°C, injection molding	4.2	kJ/m²	ISO 179/1A
23°C, injection molding	5.3	kJ/m²	ISO 179/1A

Charpy Unnotched Impact Strength			ISO 179/1U
-40°C, injection molding	54	kJ/m ²	ISO 179/1U
23°C, injection molding	No Break		ISO 179/1U
Notched Izod Impact (23°C, Injection Molded)			
	5.9	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C, Injection Molded)			
	No Break		ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	51.0	°C	ISO 75-2/B
1.8 MPa, not annealed	49.0	°C	ISO 75-2/A
Vicat Softening Temperature	59.0	°C	ISO 306/A
Injection	Nominal Value	Unit	
Rear Temperature	165	°C	
Middle Temperature	185	°C	
Front Temperature	195	°C	
Nozzle Temperature	205	°C	
Mold Temperature	25.0	°C	
Injection Rate	Moderate		
Injection instructions			

In specific cases pre-drying of this material might be required.

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