

## VG7231U

VeryGreen™ VG7231U resin is a PLA compound for injection molding process. The end product can be used on disposable items. The item made by VG7231U can take over 120°C at regular applications. The products made by VG7231U will be 100% biodegraded under certain conditions.

Property	Test Method	Unit	Value	Test Method	Unit	Value
<b>MECHANICAL</b>						
Tensile Strength	ASTM D638	kg/cm <sup>2</sup>	650	GB/T1040-1992	MPa	65
Tensile Modulus	ASTM D638	kg/cm <sup>2</sup>	43500	GB/T1040-1992	GPa	4.3
Elongation (at break)	ASTM D638	%	2.5	GB/T1040-1992	%	2.5
Flexure Modulus	ASTM D790	kg/cm <sup>2</sup>	83000	GB/T9341-2000	GPa	8.3
Flexure Strength	ASTM D790	kg/cm <sup>2</sup>	1100	GB/T9341-2000	MPa	110
IZOD Impact / Notched (23°C)	ASTM D256	kg-cm/cm	2.5	GB/T1043-1992	KJ/m <sup>2</sup>	2.5
<b>THERMAL</b>						
Heat Deflection Temperature	ASTM D648	°C	153	GB/1634-2004	°C	153
Melting Point (DSC)				GB/T19466.3-2004	°C	178
<b>PHYSICAL</b>						
Density				GB/T1033-1986	g/cm <sup>3</sup>	1.45
Specific Gravity	ASTM D792	-	1.45			
Melt Flow Rate (190°C/2.16Kg)	ASTM D1238	g/10min	9	GB/T3682-2000	g/10min	9
Hardness	ASTM D2240	Shore-D	84	GB/T2411-1980	Shore-D	84

(1) Values shown are based upon specific condition. Variations within normal tolerances are possible for various colors. Actual properties of individual batches will vary within specification limits.

Reported values are only as guidelines for designers and processors of modified thermoplastics. Data are obtained from specimens molded under carefully controlled conditions from representative samples of the compound described herein. Properties may be materially affected by pellet cut, size, color, molding techniques applied, and shape of the item molded. No assurance can be implied that all molded articles will have the same properties as those listed. The values of specification listed were collected and shown to the best of our knowledge. However, we ask for understanding that we can not take over liability for the results in individual cases and for the suitability and completeness of our recommendations, and can not guarantee that no third-party patent rights are restricted. It is the responsibility of the customer to determine that the product is safe, lawful and technically suitable for the intended use.

**Packaging and Drying**

Water contain of VeryGreen™ will affect the molding process and the mechanical properties of end products. The moisture level of each VeryGreen™ resin is controlled under 0.1% (1000 ppm) before packaging. Drying of VeryGreen™ before process is necessary.

The available packages of VeryGreen™ resins are shown in the following table. Special package can supplied upon request. Each package will be attached tag which shows the product grade, the lot number, the net weight. The products will be stacked on pallet. Maximum weight of each pallet is 1,000 kg.

	25	500	750	1,000
Paper bag *1				
Aluminum foil	●			
Bulk bag *2				●
Paper box				

(1) Polyethylene laminated for interior layer.  
 (2) Polypropylene woven bag

The drying condition is recommended by 100°C for 4 to 6 hours. Insufficient drying will cause die drool, rough surface appearance, reduced output, and low mechanical properties. Streaks can be caused by overheating of the material or long time remaining in the barrel.

**Storage**

Please store VeryGreen™ resins indoor with room temperature. Avoid to be in touched with water, oil or solvent. Some high purity grades of VeryGreen™ must be stored under low dusty environment. The dust of package may cause contamination when it be opened.

Although VeryGreen™ resins are thermoplastic polymer, long term storage is not recommended. The normal storage warranty will be 2 years.

**Product Safety**

For the safety properties of the material, we refer to our MSDS which can be requested from our sales offices.

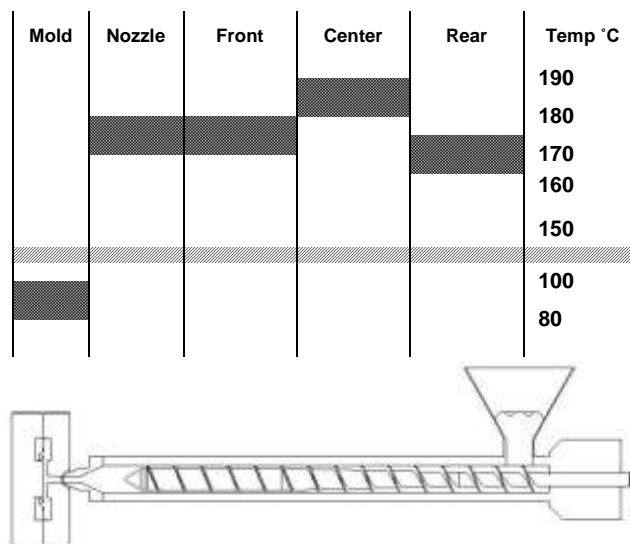
During practical operation we advise to wear personal safety protections for hand, eye, and body. Caution! Handling or processing the resins may generate a dust which can cause irritation of the eye, skin, nose and throat.

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**Regrind**

VeryGreen™ resins are thermoplastic materials. Sprues, runners or side sheets are possible to be reprocessed. The regrinds must be clean, low thermally degraded and well dried. The acceptable level of regrind depends on the application. Be aware that regrind of purify grades is not recommended for original application.

**Molding Condition**



The recommendations and data given are based on our experience to date, however, no liability can be assumed in connection with their usage and processing.

**For Additional Information**

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Customer service

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