

VG7262

VeryGreen™ VG7262 resin is a PLA compound for injection molding process. With high impact property, VG7262 can be used on general purpose applications.

PLA (polylactic acid) is a biodegradable thermoplastic aliphatic polyester derived from renewable resources. Using PLA can reduce the amount of energy and natural resources (such as water, petroleum and natural) needed to create virgin plastic.

| Property | Test Method | Unit | Value | Test Method | Unit | Value |
|-------------------------------|-------------|--------------------|-------|------------------|-------------------|-------|
| MECHANICAL | | | | | | |
| Tensile Strength | ASTM D638 | kg/cm ² | 350 | GB/T1040-1992 | MPa | 35 |
| Tensile Modulus | ASTM D638 | kg/cm ² | 26000 | GB/T1040-1992 | GPa | 2.6 |
| Elongation (at break) | ASTM D638 | % | 40 | GB/T1040-1992 | % | 40 |
| Flexure Modulus | ASTM D790 | kg/cm ² | 43000 | GB/T9341-2000 | GPa | 4.3 |
| Flexure Strength | ASTM D790 | kg/cm ² | 630 | GB/T9341-2000 | MPa | 63 |
| IZOD Impact / Notched (23°C) | ASTM D256 | kg-cm/cm | 22 | GB/T1043-1992 | KJ/m ² | 22 |
| THERMAL | | | | | | |
| Heat Deflection Temperature | ASTM D648 | °C | 95 | GB/1634-2004 | °C | 95 |
| Melting Point (DSC) | | | | GB/T19466.3-2004 | °C | 174 |
| PHYSICAL | | | | | | |
| Density | | | | GB/T1033-1986 | g/cm ³ | 1.26 |
| Specific Gravity | ASTM D792 | - | 1.26 | | | |
| Melt Flow Rate (210°C/2.16Kg) | ASTM D1238 | g/10min | 4 | GB/T3682-2000 | g/10min | 4 |
| Hardness | ASTM D2240 | Shore-D | 81 | GB/T2411-1980 | Shore-D | 81 |
| Mold Shrinkage | ASTM D955 | % | 0.5 | GB/T17037.4-2003 | % | 0.5 |

(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

Drying of crystalline PLA compounds can be performed in a desiccant hot air dryer, preferably with a dew point of less than -40°C. It is recommended to dry for 2 to 4 hours at 80°C. 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.

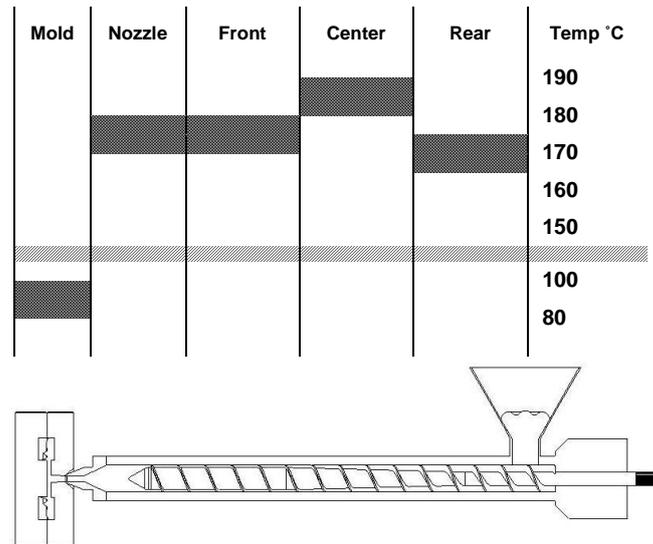
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Regrind

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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