

# EcoVid 80TFH

Polylactic Acid  
Greener Polymers Inc.

Message:

EcoVid-80TFH is a blend for thermoforming processes involving thin walled material with a High Heat resistance index. The material, rated for 178F/80°C and could be frozen to -32°C. Mould crystallization will increase the heat deflection from 80°C to 110°C+ depending on the application.  
Composition: Ingeo PLA content with bio-degradable and compostable HDT additives.  
Applications: EcoVid-80TFH is a Thermoforming blend suitable lids for hot coffee cups.

General Information			
Additive	Unspecified additive		
Features	Updatable resources		
	Heat resistance, high		
	Biodegradable		
Uses	Thermoforming Applications		
	Non-specific food applications		
	Food service sector		
	Beverage lid		
Processing Method	Thermoforming		
Physical	Nominal Value	Unit	Test Method
Density	1.27	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
190°C/2.16 kg	6.0	g/10 min	ASTM D1238
210°C/2.16 kg	6.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.30 - 0.50	%	
Relative Viscosity	2.5		
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	62.1	MPa	ASTM D638
Tensile Elongation (Break)	3.5	%	ASTM D638
Flexural Strength	108	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	16	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Glass Transition Temperature	55.0 - 60.0	°C	ASTM D3418
Vicat Softening Temperature	130	°C	ASTM D1525
Melting Temperature	130 - 180	°C	ASTM D3418
Peak Crystallization Temperature (DSC)	155 - 170	°C	ASTM D3418
Heat Distortion	80 - 110	°C	ASTM E2092
Clarity	NIL		

#### Additional Information

Vapour Barrier Transmission Rate (ASTM E380): 20.1636 (sd +/- 0.3537)Oxygen Permeability (ASTM E380): 53.481 (sd +/- 0.249)

Injection	Nominal Value	Unit
Hopper Temperature	145 - 155	°C
Rear Temperature	145 - 165	°C
Middle Temperature	165 - 195	°C
Front Temperature	165 - 195	°C
Nozzle Temperature	165 - 180	°C
Back Pressure	1.03 - 2.76	MPa
Screw Speed	35 - 65	rpm

#### Injection instructions

Mould Cycle Time: 19-35 secs

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#### Recommended distributors for this material

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