Cereplast Compostables® 6015

Polylactic Acid

Cereplast, Inc.

Message:

Cereplast Compostables® resins are renewable, ecologically sound substitutes for petroleum-based plastic product, replacing nearly 100% of the petroleum-based additives used in traditional plastics. Cereplast Compostables® resins are using polymer and additives derived from starch and other renewable resources chemistry. These components are carefully blended together on state-of-the-art compounding equipments.
All Cereplast Compostables® resins, including Compostable 6015, are certified as biodegradable and compostable in the United States and Europe, meeting BPI (Biodegradable Products Institute www.bpiworld.com) standards for compostability (ASTM6400D99, ASTM6868) and European Bioplastics Standards (EN13432).
Compostable 6015 has been designed to have an excellent balance of strength, toughness and processability. Compostable 6015 can be processed on existing sheet extrusion machines. Please see our processing guide for processing and material drying guidelines. This can be found at www.cereplast.com.
Compostable 6015 is recommended for extrusion applications like gift cards, sheet, printed displays and other sheet applications.⋯

General Information			
Features	Comstable Updatable resources Workability, good Good strength Good toughness Biodegradable		
Uses	Decorative Displays Sheet		
Agency Ratings	ASTM D 6400 ASTM D 6868 EN 13432		
Processing Method	Sheet extrusion molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.39	g/cm³	ASTM D792A
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	20	g/10 min	ASTM D1238
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	4900	MPa	ASTM D638
Tensile Strength (Break)	58.1	MPa	ASTM D638
Tensile Elongation (Break)	8.0	%	ASTM D638
Flexural Modulus	4170	MPa	ASTM D790
Flexural Strength	80.7	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (23°C)	48	J/m	ASTM D256

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed)	45.0	°C	ASTM D648

Extrusion	Nominal Value	Unit
Drying Temperature	71.1 - 82.2	°C
Drying Time	2.0 - 4.0	hr
Cylinder Zone 1 Temp.	154 - 174	°C
Cylinder Zone 2 Temp.	163 - 171	°C
Cylinder Zone 3 Temp.	166 - 174	°C
Adapter Temperature	166 - 174	°C
Melt Temperature	199	°C
Die Temperature	166 - 174	°C

Extrusion instructions

Screw Speed: 20 to100 rpmDrying Temperature (regrind): 100 to120°F

Recommended distributors for this material

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