

EcoVid 43IMH

Polylactic Acid

Greener Polymers Inc.

Message:

EcoVid-43IMH is a General Purpose Ingeo PLA and bio-composite material blend suitable for Thermoforming processes 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.

Applications: EcoVid-43IMH Ingeo PLA composite may be used in a variety of applications involving heat resistant injection moulding products such as spoons, knives and forks, hot coffee cups, soup bowls, pre-cooked food trays, single use trays and disposable food platters.

General Information			
Features	Updatable resources		
	Heat resistance, high		
Uses	Beverage Containers		
	Cup		
	Non-specific food applications		
	Container		
	Food service sector		
	Food container		
	General		
	Disposable wine set		
Processing Method	Thermoforming		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.27	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
190°C/2.16 kg	22	g/10 min	ASTM D1238
210°C/2.16 kg	80	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.30 - 0.50	%	
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	130	°C	ASTM D1525
Melting Temperature	130 - 180	°C	ASTM D3418
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	85 - 185	rpm

Injection instructions

Mould Cycle Time: 19-35 secs

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