

# TERRAMAC HV-6250H

Polylactic Acid  
UNITIKA Plastics Division

Message:

TERRAMAC HV-6250H is a polylactic acid (PLA) material. This product is available in North America, Europe or Asia Pacific. The processing methods are: compression molding, foam processing or vacuum molding. The main characteristics of TERRAMAC HV-6250H are: environmental protection/green. Typical application areas include:  
Electrical/electronic applications  
disc/rack  
Foam  
container  
business/office supplies

General Information	
Features	Foamable property Updatable resources Biodegradable
Uses	Electrical/Electronic Applications Foam Container Stationery Consumer goods application field Bracket tray
Appearance	Opacity
Forms	Particle
Processing Method	Molding Foam treatment Vacuum forming

Physical	Nominal Value	Unit	Test Method
Density	1.27	g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage	1.0 - 3.0	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	69.0	MPa	ISO 527-2
Tensile Strain (Break)	2.0	%	ISO 527-2
Flexural Modulus	4700	MPa	ISO 178
Flexural Stress	111	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	1.9	kJ/m <sup>2</sup>	ISO 179
Thermal	Nominal Value	Unit	Test Method

Heat Deflection Temperature (0.45 MPa, Unannealed)	120	°C	ISO 75-2/B
Melting Temperature	170	°C	
Extrusion	Nominal Value	Unit	
Cylinder Zone 1 Temp.	180 - 200	°C	
Cylinder Zone 2 Temp.	190 - 230	°C	
Cylinder Zone 3 Temp.	190 - 220	°C	
Die Temperature	150 - 180	°C	
Extrusion instructions			

Cooling zone temperature: 170 to 200°C Vacuum and pressure molding conditions: Pre-heater temp: 150 to 280°C Sheet temp: 80 to 140°C Pre-heating time: 4 to 16 sec Pressing time: 4 to 16 sec Die temp: 20 to 120°C

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#### Recommended distributors for this material

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