# Ingeo™ 3100HP

### Polylactic Acid

NatureWorks® LLC

#### Message:

Ingeo 3100HP is a medium viscosity product from NatureWorks LLC, designed for medium flow injection molding applications. It is designed to crystallize during processing, leading to higher heat deflection temperatures in opaque applications.

The variety of products made with 3100HP is widely varied and growing. Applications include disposables such as cutlery, cups, plates, cosmetic packaging, and durables such as electronics housings and semi-durable building materials.

General Information			
Features	Updatable resources		
	Medium liquidity		
	Compliance of Food Exposure		
	Medium viscosity		
Uses	Cosmetic Packaging		
	Cup		
	Electrical housing		
	Building materials		
	General		
Agency Ratings	EEC 94/62/EC Article 11		
	FDA Food Exposure, Not Rated		
	Europe 10/1/2011 12:00:00 AM		
Drogossing Mathed	Injection molding		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
-	· · ·	Unit g/cm <sup>3</sup>	Test Method ASTM D792
Physical Specific Gravity Melt Mass-Flow Rate (MFR) (210°C/2.16	Nominal Value	g/cm <sup>3</sup>	ASTM D792
Physical Specific Gravity Melt Mass-Flow Rate (MFR) (210°C/2.16 kg)	Nominal Value		
Physical         Specific Gravity         Melt Mass-Flow Rate (MFR) (210°C/2.16 kg)         Molding Shrinkage - Flow	Nominal Value 1.24 24	g/cm³ g/10 min	ASTM D792
Physical         Specific Gravity         Melt Mass-Flow Rate (MFR) (210°C/2.16 kg)         Molding Shrinkage - Flow         1	Nominal Value           1.24           24           1.7 - 1.8	g/cm³ g/10 min %	ASTM D792
Physical         Specific Gravity         Melt Mass-Flow Rate (MFR) (210°C/2.16 kg)         Molding Shrinkage - Flow         1         2	Nominal Value 1.24 24	g/cm³ g/10 min	ASTM D792
Physical         Specific Gravity         Melt Mass-Flow Rate (MFR) (210°C/2.16 kg)         Molding Shrinkage - Flow         1	Nominal Value           1.24           24           1.7 - 1.8           0.20 - 0.40           3.1	g/cm <sup>3</sup> g/10 min % %	ASTM D792
Physical         Specific Gravity         Melt Mass-Flow Rate (MFR) (210°C/2.16 kg)         Molding Shrinkage - Flow        1        2         Relative Viscosity <sup>3</sup> Mechanical	Nominal Value           1.24           24           1.7 - 1.8           0.20 - 0.40	g/cm³ g/10 min %	ASTM D792 ASTM D1238
Physical         Specific Gravity         Melt Mass-Flow Rate (MFR) (210°C/2.16 kg)         Molding Shrinkage - Flow         1         2         Relative Viscosity <sup>3</sup> Mechanical         Tensile Strength	Nominal Value           1.24           24           1.7 - 1.8           0.20 - 0.40           3.1	g/cm <sup>3</sup> g/10 min % %	ASTM D792 ASTM D1238 ASTM D5225
Physical         Specific Gravity         Melt Mass-Flow Rate (MFR) (210°C/2.16 kg)         Molding Shrinkage - Flow         1         2         Relative Viscosity <sup>3</sup> Mechanical         Tensile Strength         Yield <sup>4</sup>	Nominal Value           1.24           24           1.7 - 1.8           0.20 - 0.40           3.1	g/cm <sup>3</sup> g/10 min % %	ASTM D792 ASTM D1238 ASTM D5225 Test Method
Physical         Specific Gravity         Melt Mass-Flow Rate (MFR) (210°C/2.16 kg)         Molding Shrinkage - Flow         1         2         Relative Viscosity <sup>3</sup> Mechanical         Tensile Strength	Nominal Value           1.24           24           1.7 - 1.8           0.20 - 0.40           3.1           Nominal Value	g/cm <sup>3</sup> g/10 min % % Unit	ASTM D792 ASTM D1238 ASTM D5225 Test Method ASTM D638
PhysicalSpecific GravityMelt Mass-Flow Rate (MFR) (210°C/2.16 kg)Molding Shrinkage - Flow 1 2Relative Viscosity 3MechanicalTensile Strength Yield 5Yield 5Tensile Elongation	Nominal Value         1.24         24         1.7 - 1.8         0.20 - 0.40         3.1         Nominal Value         64.1	g/cm <sup>3</sup> g/10 min % % Unit MPa	ASTM D792 ASTM D1238 ASTM D5225 Test Method ASTM D638 ASTM D638
Physical         Specific Gravity         Melt Mass-Flow Rate (MFR) (210°C/2.16 kg)         Molding Shrinkage - Flow         1         2         Relative Viscosity <sup>3</sup> Mechanical         Tensile Strength         Yield <sup>4</sup> Yield <sup>5</sup>	Nominal Value         1.24         24         1.7 - 1.8         0.20 - 0.40         3.1         Nominal Value         64.1	g/cm <sup>3</sup> g/10 min % % Unit MPa	ASTM D792 ASTM D1238 ASTM D1238 ASTM D5225 Test Method ASTM D638 ASTM D638

Hexal ModulusASTM 0790-1°3630MPaASTM 0790-1°3500MPaASTM 0790Feural Stereigh12MPaASTM 0790-1°12MPaASTM 0790Inpat12MPaASTM 0790Inpat12MPaASTM 0790Inpat12MPaASTM 0790Inpat12MPaASTM 0250Indat12MPaASTM 0250Indat12MPaASTM 0250Indat13MPaASTM 0250Indat13MPaASTM 0250Indat14MPaASTM 0250Indat14MPaMPaIndat14MPaMPaIndat14MPaMPaIndat14MPaMPaIndat14MPaMPaIndat14MPaMPaIndatMPaMPaMPaIndat14MPaMPaIndatMPaMPaMPaIndatMPaMPaMPaIndatMPaMPaMPaIndatMPaMPaMPaIndatMPaMPaMPaIndatMPaMPaMPaIndatMPaMPaMPaIndatMPaMPaMPaIndatMPaMPaMPaIndatMPaMPaMPaIndatMPaMPaMPaIndatMPaM				
	Flexural Modulus			ASTM D790
Inscription         Inscription         Inscription           -1°         188         MPa         ASTM D780           -1°         122         MPa         ASTM D780           Impact         122         MPa         ASTM D780           Impact         122         MPa         ASTM D780           Nothed Impact         323         I/n         ASTM D256           -1°         18         J/m         ASTM D256           -1°         18         J/m         ASTM D256           -1°         18         J/m         ASTM D256           -1°         Nominal Value         Unit         Test MathD25           Deflection Temperature Under Load         540         C         ASTM 2026           -0.45 MPa, not anneidel <sup>16</sup> 540         C         ASTM 2026           -0.45 MPa, not anneidel <sup>16</sup> 540         C         C         ASTM 2026           -0.45 MPa, not anneidel <sup>16</sup> 180         C         C         C           -1°         Carice         ASTM 2026         S         C         C           -1°         MathD3         MathD3         C         C         C         C         C         C         C	8	4360	MPa	ASTM D790
-1°108MPaASTM D730-1°112MPaASTM D730ImpactNorminal ValueUnitTest MethodNotched izod Inpact-3J/mASTM D256-1°18J/mASTM D256-1°18J/mASTM D256-1°18J/mASTM D256Definition Temperature Under LoadValueTest MethodDefinition Temperature Under Load16°CASTM 20320.45 MPa, not annealed <sup>19</sup> 49°CASTM 20320.45 MPa, not annealed <sup>19</sup> 180°CSTM 20320.45 MPa, not annealed <sup>19</sup> 180°CSTM 20320.45 MPa, not annealed <sup>19</sup> 60°CSTM 20320.45 MPa, not annealed <sup>19</sup> 60°CSTM 20320.45 MPa, not annealed <sup>19</sup> 180°CSTM 20320.45 MPa, not annealed <sup>19</sup> 180°CSTM 20320.45 MPa, not annealed <sup>19</sup> 60°CSTM 20320.45 MPa, not annealed <sup>19</sup> 180°CSTM 20320.45 MPa, not annealed <sup>19</sup> 180°CSTM 20321°0paque°CSTM 2032STM 20321°10°CSTM 2032STM 2032101010°CSTM 2032101010°CSTM 2032101010°CSTM 2032101010°CSTM 2032101010°CSTM 20321010	9	3590	MPa	ASTM D790
100         Mode         Mode         Mode         ASTM 0799           Impact         Nominal Value         Unit         Test Method           Nothed Izod Impact         32         //m         ASTM 0796 <sup>12</sup> 32         //m         ASTM 0256 <sup>13</sup> 18         //m         ASTM 0256 <sup>13</sup> 18         //m         ASTM 0256           Thermal         Nominal Value         Test Method         Test Method           Defection Temperature Under Load         54.0         "C         ASTM 2002           0.45 MPa, not annealed <sup>14</sup> 149         "C         ASTM 2002           0.45 MPa, not annealed <sup>15</sup> 54.0         "C         ASTM 2002           0.45 MPa, not annealed <sup>15</sup> 109         "C         STM 2002           0.45 MPa, not annealed <sup>15</sup> 64.0         "C         STM 2002	Flexural Strength			ASTM D790
Impact         India         Optional Value         India         Test Method           Netched Izod Impact         32         J/m         ASTM D256          1 <sup>3</sup> 18         J/m         ASTM D256          1 <sup>3</sup> 18         J/m         ASTM D256          1 <sup>3</sup> 18         J/m         ASTM D256           Thermal         Nominal Value         Test Method         Test Method           Deflection Temperature Under Load         54.0         C         ASTM E2092           0.45 MPa, not annealed <sup>15</sup> 54.0         "C         ASTM E2092           0.45 MPa, not annealed <sup>15</sup> 54.0         "C         ASTM E2092           0.45 MPa, not annealed <sup>15</sup> 54.0         "C         Test Method           0.45 MPa, not annealed <sup>15</sup> 54.0         "C         Test Method           0.45 MPa, not annealed <sup>15</sup> 180         "C         Test Method           0.45 MPa, not annealed <sup>15</sup> Nominal Value         Unit         Test Method           0.46 Creptarture (DSC)         "C         Test Method         Test Method           Suggested Max Moisture         0.025         %         Test Method         Test Method           Nolded Temperature	10	108	MPa	ASTM D790
Notched lood impactASTM D256-1 <sup>2</sup> 32J/mASTM D256-1 <sup>3</sup> 18J/mASTM D256ThermalNominal ValueUntTest MethodDeflection Temperature Under Load149"CASTM E20920.65 MPa, not annealed <sup>16</sup> 149"CASTM E20920.65 MPa, not annealed <sup>15</sup> 54.0"CASTM E2092Peak Crystallization Temperature (DSC) <sup>16</sup> 180"CTermeOpticalNominal Value"CTerme1'Opaque"CTerme1'Tarsparent%TermeSuggested Max Moisture< 0.025	11	112	MPa	ASTM D790
-12J22J/mASTM D256-1318J/mASTM D256ThernalNominal ValueUnitTest MethodDeflection Temperature Under Load149°CASTM E20920.45 MPa, not annealed <sup>16</sup> 199°CASTM E20920.45 MPa, not annealed <sup>15</sup> 54.0°CASTM E2092Deflection Temperature (DSC) <sup>10</sup> 18.0°C*********************************	Impact	Nominal Value	Unit	Test Method
Image: Constraint of the second sec	Notched Izod Impact			ASTM D256
Termal         Nominal Value         Init         Test Method           Deflection Temperature Under Load         -         ASTM E2092           0.45 MPa, not annealed <sup>14</sup> 149         *C         ASTM E2092           0.45 MPa, not annealed <sup>15</sup> 54.0         *C         ASTM E2092           Peak Crystallization Temperature (DSC) <sup>16</sup> 180         *C         ASTM E2092           Optical         Nominal Value         -         -         -           Clarity         -         -         -         -         -         -           Clarity         -	12	32	J/m	ASTM D256
Deflection Temperature Under LoadASTM E20920.45 MPa, not annealed 14149°CASTM E20920.45 MPa, not annealed 1554.0°CASTM E2092Peak Crystallization Temperature (DSC) 16180°C*********************************	13	18	J/m	ASTM D256
0.45 MPa, not annealed <sup>14</sup> 149°CASTM E20920.45 MPa, not annealed <sup>15</sup> 54.0°CASTM E2092Peak Crystallization Temperature (DSC) <sup>16</sup> 180°C·COpticalNominal Value·C·CClarity- 17Opaque·C·C- 17Opaque·C·C·C- 18or minal ValueUnit·C·CSuggested Max Moisture< 0.025	Thermal	Nominal Value	Unit	Test Method
0.45 MPa, not annealed 1554.0°CASTM E2092Peak Crystallization Temperature (DSC) 16180°C'COpticalNominal Value	Deflection Temperature Under Load			ASTM E2092
Peak Crystallization Temperature (DSC) <sup>16</sup> 180         "C           Optical         Nominal Value         Clarity           - <sup>17</sup> Opaque	0.45 MPa, not annealed <sup>14</sup>	149	°C	ASTM E2092
OpticalNominal ValueClarity- 17Opaque- 18TransparentInjectionNominal ValueSuggested Max Moisture< 0.025	0.45 MPa, not annealed <sup>15</sup>	54.0	°C	ASTM E2092
Clarity         - 17       Opaque         - 18       Transparent         Injection       Nominal Value       Unit         Suggested Max Moisture       < 0.025	Peak Crystallization Temperature (DSC) <sup>16</sup>	180	°C	
<ul> <li>-<sup>17</sup></li> <li>Opaque</li> <li>-<sup>18</sup></li> <li>Transparent</li> <li>Injection</li> <li>Nominal Value</li> <li>Unit</li> <li>Suggested Max Moisture</li> <li>&lt; 0.025</li> <li>%</li> <li>Hopper Temperature</li> <li>21.1</li> <li>°C</li> <li>Rear Temperature</li> <li>185</li> <li>°C</li> <li>Middle Temperature</li> <li>195</li> <li>°C</li> <li>Nozel Temperature</li> <li>200</li> <li>°C</li> <li>Nold Temperature</li> <li>Verew Speed</li> <li>200</li> <li>rpmerature</li> <li>Note: Anorphous polymer must be dried bet/stalline with 120°C mold temperature where formula included tw% nucleating agent included tw% nucleating a</li></ul>	Optical	Nominal Value		
Injection         Transparent           Injection         Nominal Value         Unit           Suggested Max Moisture         < 0.025	Clarity			
InjectionNominal ValueUnitSuggested Max Moisture< 0.025	17	Opaque		
Suggested Max Moisture< 0.025%Hopper Temperature21.1°CRear Temperature185°CMiddle Temperature195°CFront Temperature200°CNozzle Temperature200°CNozzle Temperature200°CModdl Temperature199°CMold Temperature120°CMold Temperature200°CMold Temperature172MPaScrew Speed200rpmInjection instructionsrpmNote: Amorphous polymer must be dried betw120°C mold temperatureNote: Amorphous polymer must be dried betw120°C mold temperatureNote: Amorphous polymer formulaincluded 1wt% nucleating agent1.Molded crystalline with 120°C mold temperature where formula included 1wt% nucleating agent2.Molded amorphous with 26°C2.Molded amorphous with 26°C3.Measured at 1.0 g/dL in chloroform at 30°C3.Molded rystalline with 120°C mold temperature where formula included 110 % nucleating agent	18	Transparent		
Hopper Temperature         21.1         "C           Rear Temperature         185         "C           Middle Temperature         195         "C           Front Temperature         200         "C           Nozzle Temperature         200         "C           Nozzle Temperature         200         "C           Nozzle Temperature         200         "C           Notzle Temperature         200         "C           Mold Temperature         120         "C           Mold Temperature         120         "C           Back Pressure         1.72         MPa           Screw Speed         200         rpm           Note: Amorphous polymer must be dried betreperature         rpm           Note: Amorphous polymer must be dried betreperature where formula included 1wt% nucleating agent         remerature where formula included 1wt% nucleating agent           1.         (LAK-301 from Takemoto Oil & Fat)         Screw Speed           2.         Molded amorphous with 26°C         mold temperature           3.         Measured at 1.0 g/dL in chloroform at 30°C         Molded crystalline with 120°C           mold temperature         Molded crystalline with 120°C         Screw Speed	Injection	Nominal Value	Unit	
Rear Temperature         185         "C           Middle Temperature         195         "C           Front Temperature         200         "C           Nozzle Temperature         200         "C           Nozzle Temperature         200         "C           Nozzle Temperature         200         "C           Nozzle Temperature         199         "C           Mold Temperature         120         "C           Back Pressure         1.72         MPa           Screw Speed         200         rpm           Injection instructions         rpm           Note: Amorphous polymer must be dried be/"SOC/"         rpm           Note	Suggested Max Moisture	< 0.025	%	
Middle Temperature195°CFront Temperature200°CNozzle Temperature200°CProcessing (Melt) Temp199°CMold Temperature120°CBack Pressure1.72MPaScrew Speed200rpmInjection instructionsvNote: Amorphous polymer must be dried believevNote: Amorphous with 20°C mold temperature where formula included 1wt% nucleating agent1.(LAK-301 from Takemoto Oil & Fat)2.Molede amorphous with 26°C3.Moleded crystalline with 120°C mold temperature where formula included 1wt% nucleating agent3.Moleded crystalline with 120°C mold temperature where formula included 1wt% nucleating agent	Hopper Temperature	21.1	°C	
Front Temperature200°CNozzle Temperature200°CProcessing (Melt) Temp199°CMold Temperature120°CBack Pressure1.72MPaScrew Speed200rpmInjection instructionsvvNote: Amorphous polymer must be dried betw 120F (50C).vNote: Amorphous polymer must be drived betweet pormula included 100% (120°C) mold temperature where formula included 100% di mograture where formula included 100% mograture wh	Rear Temperature	185	°C	
Nozzle Temperature200°CProcessing (Melt) Temp199°CMold Temperature120°CBack Pressure1.72MPaScrew Speed200rpmInjection instructionsVVNote: Amorphous polymer must be dried betw 120F (50C).VNOTEMolded crystalline with 120°C mold temperature where formula included 1wt% nucleating agentV1.Molded amorphous with 26°C mold temperatureMolded amorphous with 26°C2.Molded amorphous with 120°C mold temperatureMolded crystalline with 120°C mold temperature3.Molded crystalline with 120°C mold temperature where formula included 1 wt% nucleating agentScrew Speed1.Molded amorphous with 26°C mold temperature where formula included 1 wt% nucleating agentScrew Speed2.Molded amorphous with 26°C mold temperature where formula included 1 wt% nucleating agentScrew Speed3.Molded amorphous with 26°C mold temperature where formula included 1 wt% nucleating agentScrew Speed3.Molded crystalline with 120°C mold temperature where formula included 1 wt% nucleating agentScrew Speed3.Molded crystalline with 120°C mold temperature where formula included 1 wt% nucleating agentScrew Speed3.Molded crystalline with 120°C mold temperature where formula included 1 wt% nucleating agentScrew Speed3.Molded crystalline with 120°C mold temperature where formula included 1 wt% nucleating agentScrew Speed	Middle Temperature	195	°C	
Processing (Melt) Temp199°CMold Temperature120°CBack Pressure1.72MPaScrew Speed200rpmInjection instructionsVVNote: Amorphous polymer must be dried be/be/be/be/be/be/be/be/be/be/be/be/be/b	Front Temperature	200	°C	
Mold Temperature120°CBack Pressure1.72MPaScrew Speed200rpmInjection instructionsVNote: Amorphous polymer must be dried below 120F (50C).VNOTEMolded crystalline with 120°C mold temperature where formula included 1wt% nucleating agentV1.(LAK-301 from Takemoto Oil & Fat)2.Molded amorphous with 26°C mold temperature3.Measured at 1.0 g/dL in choroform at 30°C3.Molded crystalline with 120°C mold temperature where formula included 10000 in the section of the se	Nozzle Temperature	200	°C	
Back Pressure1.72MPaScrew Speed200rpmInjection instructionsrpmNote: Amorphous polymer must be dried betor 120F (50C).remove the second se	Processing (Melt) Temp	199	°C	
Screw Speed       200       rpm         Injection instructions       Note: Amorphous polymer must be dried be/seleccond       120F (50C).         NOTE         Molded crystalline with 120°C mold temperature where formula included 1wt% nucleating agent       1.         1.       (LAK-301 from Takemoto Oil & Fat)         2.       Molded amorphous with 26°C mold temperature         3.       Measured at 1.0 g/dL in chloroform at 30°C         Molded crystalline with 120°C mold temperature       Molded remperature where formula included 1wt% nucleating agent	Mold Temperature	120	°C	
Injection instructions         Note: Amorphous polymer must be dried below 120F (50C).         NOTE         Molded crystalline with 120°C mold temperature where formula included 1wt% nucleating agent         1.       (LAK-301 from Takemoto Oil & Fat)         2.       Molded amorphous with 26°C mold temperature         3.       Measured at 1.0 g/dL in chloroform at 30°C         Molded crystalline with 120°C mold temperature where formula included 1wt% nucleating agent	Back Pressure	1.72	MPa	
Note: Amorphous polymer must be dried below 120F (50C).         NOTE         Image: Molded crystalline with 120°C mold temperature where formula included 1wt% nucleating agent         1.       (LAK-301 from Takemoto Oil & Fat)         2.       Molded amorphous with 26°C mold temperature         3.       Measured at 1.0 g/dL in chloroform at 30°C         Molded crystalline with 120°C mold temperature where formula included 1wt% nucleating agent	Screw Speed	200	rpm	
NOTE         Molded crystalline with 120°C mold temperature where formula included 1wt% nucleating agent         1.       (LAK-301 from Takemoto Oil & Fat)         Molded amorphous with 26°C         2.       mold temperature         3.       Measured at 1.0 g/dL in chloroform at 30°C         Molded crystalline with 120°C mold temperature where formula included 1wt% nucleating agent	Injection instructions			
Molded crystalline with 120°C mold temperature where formula included 1wt% nucleating agent (LAK-301 from Takemoto Oil & Fat)         1.       Molded amorphous with 26°C mold temperature         2.       Molded amorphous with 26°C mold temperature         3.       Measured at 1.0 g/dL in chloroform at 30°C         Molded crystalline with 120°C mold temperature where formula included 1wt% nucleating agent	Note: Amorphous polymer must be dried be	elow 120F (50C).		
mold temperature where formula included 1wt% nucleating agent (LAK-301 from Takemoto Oil & Fat)1.Molded amorphous with 26°C mold temperature2.Molded amorphous with 26°C mold temperature3.Measured at 1.0 g/dL in chloroform at 30°CMolded crystalline with 120°C mold temperature where formula included 1wt% nucleating agent	NOTE			
2.       Molded amorphous with 26°C mold temperature         3.       Measured at 1.0 g/dL in chloroform at 30°C         Molded crystalline with 120°C mold temperature where formula included 1wt% nucleating agent	1	mold temperature where formula included 1wt% nucleating agent		
3.       Measured at 1.0 g/dL in chloroform at 30°C         Molded crystalline with 120°C mold temperature where formula included 1wt% nucleating agent		Molded amorphous with 26°C		
mold temperature where formula included 1wt% nucleating agent		Measured at 1.0 g/dL in		
· · · · · · · · · · · · · · · · · · ·	4.	mold temperature where formula		

	Molded amorphous with 26°C
5.	mold temperature
	Molded crystalline with 120°C
	mold temperature where formula
	included 1wt% nucleating agent
6.	(LAK-301 from Takemoto Oil & Fat)
	Molded amorphous with 26°C
7.	mold temperature
	Molded crystalline with 120°C
	mold temperature where formula
	included 1wt% nucleating agent
8.	(LAK-301 from Takemoto Oil & Fat)
	Molded amorphous with 26°C
9.	mold temperature
	Molded crystalline with 120°C
	mold temperature where formula
	included 1wt% nucleating agent
10.	(LAK-301 from Takemoto Oil & Fat)
	Molded amorphous with 26°C
11.	mold temperature
	Molded crystalline with 120°C
	mold temperature where formula
	included 1wt% nucleating agent
12.	(LAK-301 from Takemoto Oil & Fat)
	Molded amorphous with 26°C
13.	mold temperature
	Molded crystalline with 120°C
	mold temperature where formula
	included 1wt% nucleating agent
14.	(LAK-301 from Takemoto Oil & Fat)
	Molded amorphous with 26°C
15.	mold temperature
	Molded crystalline with 120°C
	mold temperature where formula
	included 1wt% nucleating agent
16.	(LAK-301 from Takemoto Oil & Fat)
	Molded crystalline with 120°C
	mold temperature where formula
	included 1wt% nucleating agent
17.	(LAK-301 from Takemoto Oil & Fat)
	Molded amorphous with 26°C
18.	mold temperature

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