

Futerro® Extrusion

Polylactic Acid

Futerro

Message:

Futerro® PLA polymer extrusion grade is a thermoplastic resin derived from annually renewable resources and is specifically designed for extrusion & thermoforming applications as, dairy containers, food service ware, transparent food containers, blister packaging, cold drink cups. Candy twist wrap, salad and Vegetable bags, window Envelope film, lidding film - Label film, Injection Stretch Blow Molded, or ISBM Bottles for 1:2 stage operations. Ideal for applications such as, Fresh Dairy, Edible Oils, Fresh Water

Futerro® PLA polymer is a clear extrusion sheet grade and is easily processed on conventional extrusion and thermoforming equipment. The material is stable in the molten state, provided that the drying procedures are followed.

General Information			
Features	Updatable resources		
Uses	Packaging		
	Films		
	Cup		
	Label		
	Bags		
	Cover		
	Sheet		
	Bottle		
	Container		
	Food service sector		
	Food container		
Appearance	Clear/transparent		
Processing Method	Injection Stretch Blow Molding		
	Extrusion		
	Thermoforming		
Physical	Nominal Value	Unit	Test Method
Density (25°C)	1.24	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)			ISO 1133
190°C/2.16 kg	2.0 - 4.0	g/10 min	ISO 1133
210°C/2.16 kg	5.0 - 7.0	g/10 min	ISO 1133
Free Lactide Content		%	
L-poly-Lactide Content	> 99	%	
Moisture Content		ppm	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3500	MPa	ISO 527-2
Tensile Stress			ISO 527-2
Yield	60.0	MPa	ISO 527-2

Fracture	55.0	MPa	ISO 527-2
Tensile Strain (Break)	6.0	%	ISO 527-2
Flexural Stress	90.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	3.5	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Glass Transition Temperature	52.0 - 60.0	°C	ISO 11357-2
Melting Temperature	145 - 175	°C	ISO 11357-3
Optical	Nominal Value	Unit	Test Method
Transmittance (2000 μm)	> 90.0	%	ISO 14782
Haze (2000 μm)	< 5.0	%	ISO 14782
Fill Analysis	Nominal Value	Unit	
Melt Density (230°C)	1.08 - 1.12	g/cm ³	
Extrusion	Nominal Value	Unit	
Drying Temperature	90.0	°C	
Drying Time	2.0	hr	
Suggested Max Moisture	0.025	%	
Cylinder Zone 1 Temp.	180	°C	
Cylinder Zone 2 Temp.	190	°C	
Cylinder Zone 3 Temp.	200	°C	
Adapter Temperature	200	°C	
Melt Temperature	210	°C	
Die Temperature	190	°C	
Extrusion instructions			

Feed Throat Temperature: 45°C Screw Speed: 20 to 100 rpm

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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