

ECO PELLET® LA13A

Polylactic Acid + ABS

UMG ABS, Ltd.

Message:

ECO PELLET® LA13A is a Polylactic Acid + ABS (PLA+ABS) material. It is available in Asia Pacific or North America for injection molding.

Important attributes of ECO PELLET® LA13A are:

RoHS Compliant

Eco-Friendly/Green

General Information			
Features	Renewable Resource Content		
RoHS Compliance	RoHS Compliant		
UL File Number	E47016		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.12	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (200°C/10.0 kg)	15.0	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (23°C)	0.50 to 0.80	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 23°C)	105		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (23°C)	48.0	MPa	ISO 527-2
Flexural Modulus ¹ (23°C)	2400	MPa	ISO 178
Flexural Stress ² (23°C)	72.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	27	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	92.0	°C	ISO 75-2/Af
Injection	Nominal Value	Unit	
Drying Temperature	85.0 to 90.0	°C	
Drying Time	3.0 to 4.0	hr	
Rear Temperature	190 to 210	°C	
Middle Temperature	210 to 230	°C	
Front Temperature	220 to 250	°C	
Nozzle Temperature	200 to 230	°C	
Processing (Melt) Temp	220 to 260	°C	
Mold Temperature	50.0 to 60.0	°C	
Injection Pressure	70.0 to 140	MPa	
Injection Rate	Moderate		

Back Pressure	5.00 to 15.0	MPa
Screw Speed	50 to 100	rpm
NOTE		
1.	2.0 mm/min	
2.	2.0 mm/min	

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Recommended distributors for this material

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