

TERRAMAC TP-4000

Polylactic Acid
UNITIKA Plastics Division

Message:

TERRAMAC TP-4000 is a polylactic acid (PLA) material. This product is available in North America, Europe or Asia Pacific. The processing method is extrusion. The main characteristics of TERRAMAC TP-4000 are: environmental protection/green.

Typical application areas include:

Electrical/electronic applications

disc/rack

container

business/office supplies

Consumer goods

General Information			
Features	Updatable resources		
	Biodegradable		
	General		
Uses	Electrical/Electronic Applications		
	Container		
	Stationery		
	Consumer goods application field		
	Bracket tray		
Appearance	Clear/transparent		
Forms	Particle		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Density	1.25	g/cm ³	ISO 1183
Molding Shrinkage	3.0 - 5.0	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	66.0	MPa	ISO 527-2
Tensile Strain (Break)	5.0	%	ISO 527-2
Flexural Modulus	4600	MPa	ISO 178
Flexural Stress	108	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	1.6	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (0.45 MPa, Unannealed)	59.0	°C	ISO 75-2/B
Melting Temperature	170	°C	
Extrusion	Nominal Value	Unit	
Hopper Temperature	150 - 180	°C	

Cylinder Zone 1 Temp.	160 - 200	°C
Cylinder Zone 2 Temp.	160 - 200	°C
Melt Temperature	< 240	°C
Die Temperature	150 - 180	°C

Extrusion instructions

Coolant Temperature: 8 to 15°C Distance between die and sizer: 2 to 5 cm Sizing method: dry vacuum Drawdown rate: 0.87 to 0.92

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