



TRANSMARE® BIO 35LA-0.001

TRANSMARE® BIO 35LA-0.001 is a PLA INGEO™ based biopolymer with good flow.

Density:	ISO 1183	kg/m ³	1250
Melt Flow Index:	ISO 1133		
at 190°C and 2,16 kg		g/10 min	35
at 210°C and 2.16 kg		g/10 min	81

Charpy impact strength:			
unnotched, at +23 °C	ISO 179/1U	kJ/m ²	17.6
unnotched, at -40 °C	ISO 179/1U	kJ/m ²	25.1
notched, at +23 °C	ISO 179/1A	kJ/m ²	1.5
notched, at 0 °C	ISO 179/1A	kJ/m ²	1.6
notched, at -20 °C	ISO 179/1A	kJ/m ²	-
notched, at -40 °C	ISO 179/1A	kJ/m ²	1.6
Izod impact strength:			
unnotched, at +23 °C	ISO 180/1U	kJ/m ²	16.3
unnotched, at -40 °C	ISO 180/1U	kJ/m ²	-
notched, at +23 °C	ISO 180/1A	kJ/m ²	2.7
notched, at 0 °C	ISO 180/1A	kJ/m ²	-
notched, at -20 °C	ISO 180/1A	kJ/m ²	-
notched, at -40 °C	ISO 180/1A	kJ/m ²	-
Tensile test: ISO 527-2			
tensile modulus 2)		MPa	3415
tensile stress at yield 3)		MPa	72
tensile stress at break 3)		MPa	70
elongation at yield 3)		%	2.8
elongation at break 3)		%	3
Flexural test: ISO 178			
flexural modulus		MPa	3460
maximum flexural stress		MPa	100
Hardness	ISO 868		
Shore D		-	82

Heat deflection temperature:			
at 1.80 MPa (HDT/A)	ISO 75/A	°C	48
at 0.45 MPa (HDT/B)	ISO 75/B	°C	51
Vicat softening point: ISO 306			
at 10 N (VST/A)		°C	62.5

1) Determined at injection molded test specimen
2) Test speed 1 mm/min, test specimen 4 mm thick

3) Test speed 50 mm/min, test specimen 4 mm thick
4) Three point bending; test speed 2mm/min

Immer eine gute Idee!



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PROCESSING GUIDELINES

Pre-drying
In specific cases pre-drying of this material might be required.

Injection moulding parameters
The following injection moulding parameters should be used as a guideline:

Temperature profile: 165 - 185 - 195 - 205°C
Mould temperature: 25 °C
Injection speed: Medium

STORAGE AND HANDLING

This material should be stored in a dry place and should be protected from moisture and direct UV light. Do not stack pallets.



Improper storage can cause degradation of the material, which results in colour changes and odour generation. It can have negative effects on the physical properties of the material.

SAFETY

This material is not classified as a dangerous preparation. Visit our website (www.compounding.nl) for the latest version of this materials Safety Data Sheet (MSDS/SDS), or contact your representative at Transmare Compounding BV.

RECYCLING



Recyclable: Yes
Remark: -

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