# HiTerra® Brewed PLA

## Techmer Polymer Modifiers - *Polylactic Acid*

| General | |
|---|---|
| Material Status | • Commercial: Active |
| Availability | • North America |
| Filler / Reinforcement | • Organic |
| Features | • Renewable Resource Content |
| Appearance | • Natural Color |
| Processing Method | • Injection Molding |

### Properties [1]

| Physical | Nominal Value | Unit | Test Method |
|---|---|---|---|
| Density / Specific Gravity | 0.970 | | ASTM D792 |
| **Mechanical** | **Nominal Value** | **Unit** | **Test Method** |
| Tensile Modulus | 500000 | psi | ASTM D638 |
| Tensile Strength (Yield) | 4400 | psi | ASTM D638 |
| Tensile Elongation (Break) | 30 | % | ASTM D638 |
| Flexural Modulus | 500000 | psi | ASTM D790 |
| Flexural Strength | 7500 | psi | ASTM D790 |
| **Impact** | **Nominal Value** | **Unit** | **Test Method** |
| Notched Izod Impact (0.125 in) | 0.50 | ft·lb/in | ASTM D256 |
| **Thermal** | **Nominal Value** | **Unit** | **Test Method** |
| Deflection Temperature Under Load (66 psi, Unannealed) | 120 | °F | ASTM D648 |
| Deflection Temperature Under Load (264 psi, Unannealed) | 110 | °F | ASTM D648 |

### Processing Information

| Injection | Nominal Value | Unit |
|---|---|---|
| Drying Temperature | 130 | °F |
| Drying Time | 1.0 to 2.0 | hr |
| Rear Temperature | 340 to 380 | °F |
| Middle Temperature | 340 to 380 | °F |
| Front Temperature | 340 to 380 | °F |
| Nozzle Temperature | 340 to 380 | °F |
| Processing (Melt) Temp | 350 to 380 | °F |
| Mold Temperature | 50 to 125 | °F |
| Injection Rate | Moderate | |
| Back Pressure | 50.0 to 100 | psi |
| Screw Speed | Slow-Moderate | |

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