

HiFill® PLA WF230

 Techmer Polymer Modifiers - *Polylactic Acid*
General Information
Product Description

PLAM115346

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Wood Flour, 30% Filler by Weight
Features	• Biodegradable
Appearance	• Brown
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.29		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	20	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	860000	psi	ASTM D638
Tensile Strength (Yield)	10200	psi	ASTM D638
Tensile Strength (Break)	9800	psi	ASTM D638
Tensile Elongation (Break)	1.9	%	ASTM D638
Flexural Modulus	820000	psi	ASTM D790
Flexural Strength	14500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	0.50	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	127	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	123	°F	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	> 1.0E+14	ohms·cm	ASTM D257

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	130	°F
Drying Time	1.0 to 2.0	hr
Suggested Max Moisture	0.050	%
Rear Temperature	360 to 390	°F
Middle Temperature	370 to 400	°F
Front Temperature	380 to 410	°F
Nozzle Temperature	385 to 420	°F
Processing (Melt) Temp	370 to 415	°F
Mold Temperature	50 to 125	°F
Back Pressure ²	50.0 to 100	psi

Notes
¹ Typical properties: these are not to be construed as specifications.

² Minimize to maintain fiber integrity
