

Product technical instructions

Product brand: Piocreat_PLA PRO

Material No.: D3305050007

Revision date: 2020-10

Version: V1.0

FEATURES

Completely biodegradable
Food Contact

APPLICATIONS

Excellent performance

Project	Test standards	PLA PRO
Mechanical Properties		
Tensile Strength (MPa)	ASTM D638 (50mm/min)	68
Elongation (%)	ASTM D638 (50mm/min)	4.0
Flexural Strength (MPa)	ASTM D790 (2mm/min)	75
Flexural Modulus (MPa)	ASTM D790 (2mm/min)	3500
Impact Strength, IZOD notched (J/m)	ASTM D256 (3.2mm, 23°C)	55
Thermal		
Heat Distortion Temp (°C)	ASTM D648(0.45MPa, 6.4mm)	60
Melting Temperature (°C)	(DSC)	165
Others		
Melt Flow Rate (g/10min)	ASTM D1238(190°C,2.16kg)	3~9
Specific Gravity (g/cm ³)	ASTM D792(23°C)	1.22~1.34
Mold Shrinkage (%)	ASTM D955(23°C)	0.1-0.5

[1]The performance of dyestuffs may differ from the above values.

[2] Typical values refer to laboratory average data, which are only used as a reference during use and are not used as product standards.

[3] The heat distortion temperature test specimen is a cold mold injection molded specimen without post-processing.

Package

Product brand	Package
Piocreat_PLA PRO	25kg/bag

Processing Conditions

Project		Start Point	Range
Melt Temp.		190°C	170-215°C
Barrel Zone Temp.	Rear	185°C	160-215°C
	Center	185°C	170-215°C
	Front	185°C	170-215°C
Processing Temp. Limit		235°C	
Pre-Dry Requirements		80°C,4h	

[1]The above values are for reference only. The above process can be adjusted appropriately according to the machine model, mold and product requirements.

QC

The melt index is an important indicator for quality control of this product. The melt index of this product was tested according to ASTM D1238. The test conditions are 190°C, 2.16kg. We can provide melt index data for each batch if required. In order to test the melt index of the product more accurately, the product needs to be dried at 80°C for 4 hours. The data given in the product information are typical values and are only for reference during use and are not used as product standards.

Store

During transportation and storage of this product, the temperature should not exceed 60°C. This product should not be stored for more than 12 months at room temperature (23°C) with the packaging bag sealed.

Shenzhen Piocreat 3D Technology Co.,Ltd.

📍 19F, JinXiuHongDu Building, Meilong Blvd, Longhua Dist, Shenzhen, China 518131

☎ Tel: +86 0755-2103-9743 / +86 199 2521 7796

✉ Technical support: after@piocreat3d.com

🌐 www.piocreat3d.com

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