
	Synterra® IM Version: 2012-05	
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Datasheet : Injection molding compound.

Typical properties : Short cycle times (fast crystallization) - Good Impact – High temperature resistance – Good surface finish.

PHYSICAL PROPERTIES	TEST METHOD	UNITS	SPECIFICATION
Appearance			round pellets
Colour			Off white
Melt Flow Rate (MFI)	ISO 1133 (190 °C/2,16kg)	g/600s	6 (+- 2)
Polymer Density	ISO 1183	g/cm ³	1,27
E-Modulus	ISO 527	MPa	3900-4200
Tensile strength	ISO 527	MPa	45-50
Tensile strain at break	ISO 527	%	2-3
Vicat A (10N-50 °C/h)	ISO 306/A	°C	160
Vicat B (50N-50 °C/h)	ISO 306/B	°C	100
Heat Distortion Temp. B	0,9 MPa edge / ISO 075	°C	123
Heat Distortion Temp. B	0,45 MPa flat / ISO 075	°C	100
Charpy Impact (notched)	ISO 179/1eA	kJ/m ²	4,6
Impact (unnotched)	ISO 179/1eU	kJ/m ²	>89

Processing

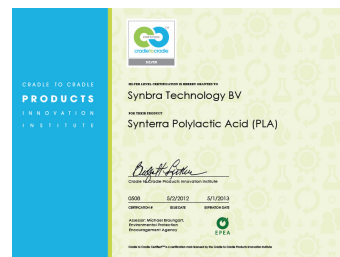
Temp. profile : feed (150 °C) – compression (180 °C) - metering (200 °C) - nozzle (190 °C)
 Mould Temp. **100-110 °C.(obligatory for high temperature performance)**
 Screw speed : 0,2 – 0,4 m/sec. - Back pressure : 10 – 15 Bar
 Drying of the Synterra® PLA is recommended prior to processing at a temperature of 90-110 °C for 4-6 hours using dehumidified air with a dew point of -40 °C.

C2C Certified and GMO free.

Synterra®, PLA made from Puralact® Lactide, was certified by MBDC EPEA on March 25th 2011 to meet the stringent requirements of Cradle to Cradle

SILVERSM  product certification.

In addition to the use of inherent benign ingredients in the polymer recipe, the certification was only possible as the feedstock for Synterra® PLA is not originating from any Genetically Modified Organisms and is therefore a true GMO free product.



N.B. Information contained in this data-sheet is given in good faith and to the best of the knowledge and belief of Synbra Technology bv (The Company) is accurate. The properties of plastics set out herein are typical values and do not constitute a specification. It is at all times the responsibility of the customer to ensure that materials supplied by the Company are suitable for the purpose for which they are intended. The Company accepts no liability whatsoever arising out of the use of the information herein contained or the use, application, adaptation or processing of the products herein described.