

# H25CPLA3

## TECHNICAL DATA SHEET

### PRODUCT: HEMP PLA 25%

**Description:** H25CPLA3 is a 25% hemp filled polylactic acid (PLA). This product is generally used in injection molding, but may be used for other forming methods as developed by individual users. HEMP PLA is designed to be a drop-in replacement for virgin PLA injection molding applications.

Natural color is medium brown; pelletized. Refer to molding recommendations below; limiting back pressure and injection speed as much as process will allow is optimal for working with this material.

Property	Typical Value	Units	Test Method:
Specific Gravity	1.27	g/cc	ASTM D 792
Tensile Strength @ Break	4,068	psi	ASTM D 638
Tensile Elongation @ Break	4.135	%	ASTM D 638
Flexural Modulus (2% secant)	434,000	psi	ASTM D 790
Melt Flow Index, 230C/2.16Kg	23	g/10 min	ASTM D 1238
Izod Impact	.63	ft. lbs/in	ASTM D 256
Gardner Impact	25	ft*lbs	ASTM D 5420

### GENERAL RECOMMENDATIONS

#### TEMPERATURES (F)

Back	260 – 300
Middle	310 – 350
Front	350 – 400
Nozzle	350 – 400
Mold	190 - 210

#### PRESSURES

Injection	Moderate
Hold	Moderate – High
Back	Moderate

#### OTHER

Injection Rate:	Slow -Moderate
Screw Speed:	Slow
Pre-drying is recommended before molding to avoid potential for splay 4-6 hours @ 200 (F) recommended pre-drying	

Data are obtained from tests performed under carefully controlled conditions from representative samples of the compound described herein. Properties may be materially affected by molding techniques applied and by the size and shape of the item molded. No assurance can be implied that all molded articles will have the same properties as those listed.

This information serves only as a guideline for processors, users and manufacturers. Due to the complex nature of design and processing, observation on a "trial and error" basis may be required to achieve desired results.

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