

Material Data Sheet

GC green BIO 601

PLA based material for injection moulding applications

GC green BIO 601 is a 100 % biobased material that can degrade under industrial conditions. It is formulated to meet the needs of injection moulding applications, especially for thin-walled parts.

Mechanical Properties

<i>Property</i>	<i>Norm</i>	<i>Units</i>	<i>Value</i>
Density	ISO 1183	g/cm ³	1.24
MFR	ISO 1133 (190°C/2.16kg)	g/10min	30
Flexural Modulus	ISO 178	MPa	3500
Tensile Strength	ISO 527	MPa	50
Elongation at break	ISO 527	%	5

Thermal Properties

HDT B	ISO 75-1 (0,45 MPa)	°C	60
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Processing Guidelines

Melt Temperature	°C	190-220
Mold Temperature	°C	25
Drying Temperatur	°C	80
Drying Time	h	4
Moisture Content	%	0.04

The processing guidelines are just typical values and just be adjusted in the actual process

