

1. Description

Greemas® 80104 is a PLA (Poly lactide) based alloy and with biobased content over 85% according to ASTM D6866. Greemas® 80104 is especially suitable for the production of general purpose items, such as packaging. Not only bio-sourced, but also biodegradable, Greemas® 80104 is definitely a cradle-to-cradle green material.

2. Properties

General Properties

Item		Test Method	Unit	State	Data
Density	-	ISO 1183	g/cm ³	dry	1.26
Mass flow rate	(190°C,2.16kg)	ISO 1133	g/10min	dry	15
Mold shrinkage	-	ISO 294	%	dry	0.10~0.35

Mechanical Properties

Item		Test Method	Unit	State	Data
Tensile strength at break	(10mm/min)	ISO 527	MPa	cond.	45
Nominal tensile strain at break	(10mm/min)	ISO 527	%	cond.	530
Flexural strength at break	(2mm/min)	ISO 178	MPa	cond.	74
Flexural modulus	(2mm/min)	ISO 178	MPa	cond.	3800
Izod notched impact strength	(4mm, 23°℃)	ISO 179/1eA	KJ/m ²	cond.	17

Thermal Properties

Item	Test Method	Unit	State	Data	
Melting point	(DSC)	ISO 11357	$^{\circ}\! \mathbb{C}$	dry	165
Heat deflection temperature HDT	(0.45 MPa)	ISO 75	$^{\circ}\! \mathbb{C}$	dry	61
Heat deflection temperature HDT	(1.80 MPa)	ISO 75	$^{\circ}\!\mathbb{C}$	dry	56

^{*} These property data are believed to be representative under specific test conditions and are not intended to serve as product specifications.

3. Applications

✓ Stationery

✓ Packaging

✓ Card applications

4. Drying Conditions

The drying temperature at $75 - 85^{\circ}$ C with a duration 3 - 4 hrs is recommended.

To obtain better product performance, a desiccant dryer is also recommended.



5. Recommended Processing Conditions

The following is the recommended injection molding conditions for the first trial:

Condition	Barrel	Nozzle	Mold	Screw	Injection	Injection	Holding
Condition	Temp.	Temp.	Temp.	Speed	Pressure	Rate	Pressure
Value	190 – 210	200 – 210	< 40	50 – 100	85 – 100	80 – 90	85 – 100
Unit	$^{\circ}\!\mathbb{C}$	$^{\circ}\!\mathbb{C}$	$^{\circ}\!\mathbb{C}$	rpm	kg/cm ²	%	kg/cm ²

^{*} For extrusion sheeting process, the barrel temperature between 180 and 210 C is recommended, with configuring general purpose screws with L/D ratios from 24 to 30 and compression ratios between 2.5:1 and 3:1.

6. Recommended Storage Conditions

Store Greemas® 80104 in cool and dry place. Protect from direct sunlight, rain and violent temperature fluctuation. Fire is inhibited around storage area. No special restrictions on storage with other products. The recommended storage duration is five years.

7. Appearance and Packaging

Greemas® 80104 is in pellet form with a package of 25 Kg net weight per paper bag.