Grade: SINOPEC PLA-200 for thermoforming

Applications: This is a general purpose grade for thermoforming process.
Among some applications are:

- Food containers, one time servicewares, refreshment cups,
- agricultural seedling trays, transport trays, etc.

It’s possible to develop OEM compound for specific application. In such case, the technical specifications may be different from the general purpose resin.

Technical specifications:

<table>
<thead>
<tr>
<th>Physical properties</th>
<th>Unit</th>
<th>Value</th>
<th>Test method</th>
</tr>
</thead>
<tbody>
<tr>
<td>Appearance – pellets</td>
<td>mesh</td>
<td>av. 35</td>
<td>seiving</td>
</tr>
<tr>
<td>Density</td>
<td>g/cm3</td>
<td>1.25 +/- .05</td>
<td>ASTM D792</td>
</tr>
<tr>
<td>Melt Index</td>
<td>g/10 min, 190C/2.16 kg</td>
<td>2-10</td>
<td>ASTM D1238</td>
</tr>
<tr>
<td>Melting point</td>
<td>C</td>
<td>170-180</td>
<td></td>
</tr>
<tr>
<td>Glass transition temperature</td>
<td>C</td>
<td>60-63</td>
<td></td>
</tr>
</tbody>
</table>

Mechanical properties:

- Tensile strength          | MPa  | > 50   | ASTM D882  |
- Elongation at break       | 100 %| > 3.0  | ASTM D882  |
- Impact strength           | Kj/m2, Izod 3-5 |

Processing information:

PLA can be processed on petro based plastics extrusion machines.
Resins may require pre-drying before being extruded.

Guideline for extruder settings are:

- Melt temperature 210 C
- Feed temperature 180 C
- Compression section 190 C
- Die temperature 190 C
- Screw speed 20-100 rpm