



ALMABLEND® 300

Technical Data Sheet (2020-06)

General information

Product description

Almablend® 300 is a bioplastic from renewable, biodegradable and compostable raw materials, designed for injection molding processes. Almablend® 300 and all ingredients used to produce it do not contain genetically modified organisms (GMOs).

Physical form

Pellets

Main characteristics

- 60% of Poly-lactic acid
- >95% of biobased and inert materials
- Compostable and biobased polymer
- Suitable for injection molding applications
- Low Oxygen Transmission Rate
- Suitable for direct food contact

Application

Injection Moulding

Complies with

- Plastics Regulation n. 10/2011
- Food Contact Material Regulation (EC) n. 1935/2004

Designed in accordance with

European Standard EN 13432



Physical properties	Test Method	
Density	ISO 1183	1,68 g/cm ³
Melt Flow Rate	g/10 min (230°C / 2.16 Kg)	30-40 g/10min
Melting Temperature	Differential scanning calorimetry	172-178 °C
Glass Transition Temperature	Differential scanning calorimetry	58°C

Mechanical properties	Test Method	
Tensile Modulus	ISO 527-1	2940-3250 MPa
Elongation at break	ISO 527-1	17-23%
Tensile Strength	ISO 527-1	48 MPa
Heat deflection temperature (amorphous)	ISO 75	63-67°C
Heat deflection temperature (crystalline)	ISO 75	>90°C
Charpy Impact Strength	ISO 179	3,8 kJ/m ²

Drying and storage recommendations

Temperature during transportation and storage must not exceed 50 °C. Storage in direct sunlight should be avoided and time in an open bag may not surpass 12 month at room temperature (23 °C). Pre-drying of the resin is strongly recommended before processing. Pre-drying conditions 50 °C for at least 5 h.



Recommended processing temperatures:

Feed Zone: 190 °C – 200 °C

Plastification-Conveying Zone: 200 °C – 210 °C

Injection Zone: 210 °C – 225 °C

The information contained in this technical data sheet have only informative purpose and are provided as a guide for the processing and storage of the material. Values listed are referred to the polymer in semi-crystalline state. Such information may not be applicable if the material is incorrect handling and/or storage.