

Sughera PLA 20-05

Biocomposite with Cork fiber on PLA base

Product Composition			
Sughera PLA 20-05	80% Carrier	20% Cork	*by weight
Cork	0.5-1mm	60kg/m ³	

Mechanical Properties				
Tensile modulus	1mm/min	ISO 527-1/-2	MPa	1300
Tensile yield strength	5mm/min	ISO 527-1/-2	MPa	-
Tensile strength at break	5mm/min	ISO 527-2/1B/50	MPa	20
Tensile elongation at break	5mm/min	ISO 527-2/1B/50	%	4.4
Flexural modulus	2mm/min	ISO 178	MPa	1500
Flexural strength	2mm/min	ISO 178	MPa	-
Flexural strain at break	2mm/min	ISO 178	%	-
Flexural stress at 3.5% strain	2mm/min	ISO 178	MPa	40
Notched Izod impact strength	23°C; 50% RH	ISO 180/1A	KJ/m ²	4
Unnotched Izod impact strength	23°C; 50% RH	ISO 180/1U	KJ/m ²	11
Notched Izod impact strength	-30°C	ISO 180/1A	KJ/m ²	-
Unnotched Izod impact strength	-30°C	ISO 180/1U	KJ/m ²	-
Notched Charpy impact strength	23°C; 50% RH	ISO 180/1eA	KJ/m ²	-
Unnotched Charpy impact strength	23°C; 50% RH	ISO 180/1eU	KJ/m ²	-
SHORE hardness A	23°C			-

Processing parameters	Testing conditions	Norm	Unit	Dam/Cond
Drying temperature	desiccator		°C	60 - 70
Drying time	desiccator		h	5 - 6
Process temperatures			°C	180 - 190
Mould temperature			°C	30 - 40

MIXCYCLING S.r.l. Via dell'Artigianato, 10 - 36042 Breganze (VI) ITALY

T: +39 0445.1735050 - E. info@mixcycling.com - W. mixcycling.com

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END OF LIFE

The material is 100% recyclable because, if collected separately, it can be used to produce the same products. In municipal collection it should be disposed of in the plastic bin.



USE

Moulding temperatures can go from 180°C to 190°C. Higher temperatures tend to result in deterioration of the fiber contained in the material. Sughera PLA 20-05 is sensitive to air humidity and tends to absorb (or disperse) water vapour if exposed for long periods to humid (or dry) environments. Before processing, desiccating at a 60-70°C for 5-6 hours is recommended.



STOCKING

Keep Mixcycling[®] material in a cold and dry place, in the original closed packaging. In order to best preserve the material it is highly recommended to open the packaging just before starting processing and to close it as soon as finished. The same process is recommended with the finished product too.

COLOURING

Mixcycling[®] materials contain natural fibers with naturally-occurring colours. Therefore they may have slight colour variations and potentially different textures in the final product.

ENVIRONMENTAL IMPACT

Mixcycling[®] materials allow to optimize the management of organic waste and to reduce environmental impacts with significant advantages during the production-consumption-disposal cycle.

PACKAGING

Sughera PLA 20-05 appears as pellets and is packaged in hermetically sealed bags which are ready to use with no initial processing required. The material is supplied in 25 kg bags.

EXTRA

See processing parameters.

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