



Preliminary Data Sheet Witcom PLA-2014/048

Brons filled PLA

Latest revision: May 2014

Properties	Test methods	Units	Witcom PLA-2014/048
------------	--------------	-------	------------------------

Physical properties

Specific gravity	ISO 1183	g/cm ³	3,9
Water absorption at saturation, 23 °C	ISO 62	%	1,8
Humidity absorption, 23 °C/50 % r.h.	ISO 62	%	0,3
Mould shrinkage (flow direction, 3 mm)	ISO 2577	%	0,15 - 0,35

Mechanical properties

Tensile strength (max.)	ISO 527	MPa	30
Elongation at break	ISO 527	%	5 – 10
Flexural strength	ISO 178	MPa	40
Flexural modulus	ISO 178	GPa	9,0
IZOD impact strength, notched	ISO 180/1eA	kJ/m ²	4,5
IZOD impact strength, unnotched	ISO 180/1eU	kJ/m ²	10

Thermal properties

Heat distortion temperature (1,81 MPa)	ISO 75	°C	-
Relative temperature index, 3 mm, with impact	UL 746B	°C	-
Coefficient of linear thermal expansion	ISO 11359	K-1·10 ⁻⁵	-

Flammability

Burning behaviour	IEC 60695-11-10	-	HB @ 3,2 mm
UL recognition	UL94	-	-

Electrical properties

Surface resistivity	ASTM D257	Ω/sq	10 ¹¹
Comparative tracking index	IEC 60112	V	-
Glow wire rating, 1,6 mm	IEC 695-2-1	°C	-

Processing conditions (injection moulding)

Drying conditions (dehumidifying drier)	: 4 Hours @ 60 °C
Maximum allowable moisture content	: 0,05 %
Melt temperature	: 160 - 230 °C
Mould temperature	: 20 - 60 °C
Screw speed	: 0,1 - 0,2 m/s
Back pressure	: 0 - 1,0 MPa
Injection pressure	: Keep to a minimum
Injection speed	: Fast ram speed
Hold pressure	: Keep to a minimum

Witcom Engineering Plastics BV
Penningweg 52
4879 AG Etten-Leur
The Netherlands

Tel.: + 31-(0) 76 - 504 30 80
Fax: + 31-(0) 76 - 504 30 81
Email: info@witcombv.nl
Website: www.witcombv.nl

This information is based on our experience to date and we believe it to be reliable. It is intended as a guide for use at your discretion and risk. We cannot guarantee favourable results and assume no liability in connection with the use of the product described. None of this information is to be taken as a license to operate under, or a recommendation to infringe, any patents.