

TECHNICAL DATA SHEET

BOLE PL-01

Main characteristics

Thermoplastic resin for injection molding consisting of 40% of materials derived from renewable sources.

Pellet shape: cylindrical (diameter and length approx. 3mm).

Appearance: white color.

Properties

Rheological Properties	Test Condition	Unit	Method	Value
Melt Volume Rate	190°C / 2.16 kg	(cm ³ /10min)	ISO 1133 D	15.0
Melt Flow rate	190°C / 2.16 kg	(g/10min)	ISO 1133 D	16.2
Mechanical Properties (23°, 50% r.h.)				
Tensile Modulus	1 mm/min	MPa	ISO 527-1A	2900
Yield stress	50 mm/min	MPa	ISO 527-1A	69
Strain at break	50 mm/min	%	ISO 527-1A	30
Charpy Notched Impact Strength		KJ/m ²	ISO 179-1	9
Thermal Properties				
Heat Deflection Temperature	0.45 MPa	°C	ISO 75-1B	104

Processing Information

Drying: necessary, if exposed to air for a long time, because of moisture absorption.

Use well-dried hot air with a temperature of 50°C for 8 h.

Recommended molding temperature: 230 °C.

Recommended mold temperature: 70 °C.

Shrinkage: well distributed.

In event of prolonged machine downtime, the cylinder must be purged.