

**Biolloy KH420**

(PLA+ABS)

Techno-UMG Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	<b>20</b>	g/10min	ISO 1133
Temperature	<b>220</b>	°C	-
Load	<b>10</b>	kg	-
Molding shrinkage, parallel	<b>0.7</b>	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Strength	<b>63</b>	MPa	ISO 527
Flexural modulus, 23°C	<b>2840</b>	MPa	ISO 178
Flexural strength	<b>95</b>	MPa	ISO 178
Charpy impact strength, +23°C	<b>17</b>	kJ/m <sup>2</sup>	ISO 179/1eU
Rockwell hardness	<b>R 118</b>	-	ISO 2039-2

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	<b>78</b>	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	<b>106</b>	°C	ISO 75-1/-2
Burning behav. at thickness h	<b>HB</b>	class	IEC 60695-11-10

Other properties	Value	Unit	Test Standard
Density	<b>1170</b>	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	<b>80</b>	°C	-
Mold temperature	<b>40 - 80</b>	°C	-
Zone 1	<b>190 - 260</b>	°C	-

**Characteristics****Processing**

Injection Molding

**Certifications**

Contains renewable resources

**Special Characteristics**

Heat stabilized or stable to heat

**Regional Availability**

North America, Asia Pacific