

futeon™

TECHNICAL DATA SHEET

FUTEON™ 804

For further information about PLA:
www.futerro.com / info@futerro.com

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DESCRIPTION

Poly(lactic acid) (PLA) is a biobased and biodegradable thermoplastic polymer derived from natural resources. Futeon™ 804 is an amorphous, high viscosity PLA designed for extrusion thermoforming, general-purpose fibers applications and 3D-printing.

TYPICAL PROPERTIES¹

PHYSICAL PROPERTIES	METHOD	TYPICAL VALUE
Clarity	/	Cristalline white pellets
Density (g/cm ³)	Literature data	1,24
Moisture content (ppm)	Karl-Fischer	≤ 400
Residual monomer (%)	Futerro method	≤ 0,3
Melt flow index (g/10min)	ISO 1133-A (190°C/2,16 kg)	4
D-isomer content (%)	Futerro method	4
Melting temperature (°C)	DSC	155
Glass transition temperature (°C)	DSC	60
PHYSICAL PROPERTIES	NORM	TYPICAL VALUE
Tensile modulus (MPa)	ISO-527	3500
Tensile strength (MPa)	ISO-527	45
Elongation at break (%)	ISO-527	≤ 5
Charpy, notched (kJ/m ²)	ISO-179-1eA	≤ 5
HDT-B, amorphous (°C)	ISO-75	55

¹Typical properties - not to be considered as product specifications

PROCESSING RECOMMENDATIONS

PRE-DRYING	To prevent PLA degradation through hydrolysis during melt processing, we recommend to pre-dry Futeon™ 804 to reach moisture content below 200 ppm (and preferably less than 100 ppm). Typical drying condition for crystallized pellets are 4-6 hours at 85°C. The resin should not be exposed to atmospheric conditions after drying to prevent moisture uptake. Keep the package sealed until ready to use and promptly reseal any unused material.
EQUIPMENT CONFIGURATION	Futeon™ 804 can be processed on a conventional extrusion equipment and can be used as neat resin or as part of a compound to optimize product properties. General purpose screw with L/D ratio between 24 and 32 are recommended.
START-UP & SHUTDOWN	PLA is not compatible with most of the thermoplastic resins, so purging is an important step to reach the full benefits of the mechanical and optical PLA properties. Following steps are recommended:

FUTERRO S.A.

info@futerro.com • www.futerro.com • +32 (0) 26 16 23 00

Headquarters:
 Rue du Renouveau 1 • B-7760 Escanaffles, Belgium
 Sales & Administrative Offices:
 Allée de la Recherche 4 • B-1070 Bruxelles, Belgium

RPM Tournai n° 0892 199 070
 Bank / Swift / IBAN / VAT:
 BNP Paribas Fortis 001-5324540-92 / GEBABEBB36A /
 BE12 0015 3245 4092 / BE 0892 199 070

1. Use a commercial purging compound or high-viscosity stable resin. Adapt the processing conditions according to that resin and start purging.
2. Continue purging until material is clear of black spots and residue.
3. Load PLA polymer and follow recommended operating conditions.
4. Begin production once PLA extrudes cleanly with no contamination.
5. After production, purge with a commercial compound, adjusting conditions as necessary to fully remove PLA.

Note: During PLA processing, not exceed 230°C.

EXTRUSION PROCESSING TEMPERATURE RECOMMENDATIONS	UNIT	TYPICAL VALUE
Melt temperature	°C	210
Feed throat	°C	45
Feed temperature	°C	180-190
Compression zone	°C	190-200
Metering zone	°C	200-210
Adapter	°C	200-210
Die	°C	190-210
Screw speed	RPM	20-100

Typical settings may require optimization

PACKAGING & STORAGE CONDITIONS

Futeon™ 804 is available in 25 kg aluminum bags and in 850 kg big bags, filled with nitrogen for protection. It is recommended to store PLA granules in its closed original packaging at atmospheric pressure and below 50°C (ideally at ambient temperature). Prolonged storage under extreme temperatures and in direct sunlight should be prevented.

CERTIFICATIONS

Futeon™ 804 is REACH compliant and can be used in Europe.

COMPOSTABILITY



One way to recycle biodegradable materials is through organic recycling, which includes industrial composting and anaerobic digestion. Industrial composting is one recycling method for PLA. Industrial composting process takes place in controlled conditions. The composting period is governed by several factors including temperature (close to 65°C), moisture, amount of oxygen, particle size, the carbon-to-nitrogen ratio, and the degree of turning involved. Generally, effective management of these factors will accelerate the composting process. The outcomes of industrial composting process are CO₂, water, and compost. The compost includes nutrients, and can be used, for example, in agriculture to enhance the soil quality. Futeon™ 804 is certified compostable following DIN EN 13432:2000-12 (max. layer thickness during test : 1030 µm).

BIOBASED

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Futeon™ 804 is made from renewable biobased raw materials. Our products are compliant with ISO 16620-2:2015 and 16785-1 (biobased carbon content: 100%; Volatile solids (organic matter): 100%). By using Futeon™ 804, you can be sure that you are using a biobased product made from renewable raw materials.

FOOD CONTACT STATUS



In the United States of America, Futeon™ 804 has been evaluated and was found to be suitable for food-contact applications. The test was performed by SGS Group in January 2021 and the product was stated compliant with 175.300 Resinous and Polymeric coatings.



In Europe, Futeon™ 804 has been evaluated and was found to be suitable for food-contact applications. The test was performed by SGS Group in January 2021 and Futeon™ 804 was stated compliant with EU commission regulation 10/2011 of 14 January 2011 (and amendment) on plastic materials and articles intended to come in contact with food. There are no SMLs or SML(T)s for the ingredients used to produce Futeon™ PLA; the regulation in place includes a limit of 10 mg/dm² on the overall migration from finished plastic articles into food. It is the responsibility of the final product manufacturer to determine that the use of the product is safe and also suitable for the intended application when it comes to food contact product.

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All product specifications are subject to change without notice. Futeon™ is a trademark of Futerro, registered in Belgium and other countries and regions.

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