


Code	PRO_TDS_14	PRO TECHNICAL DATA SHEET TDS	
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SECTION 1: PRODUCT DESCRIPTION

FC 60020 is made with Earth Renewable Technologies bio-based package developed for thermoforming applications.


SECTION 2: PHYSICAL PROPERTIES & GUIDELINES FOR USE

FC 60020 is supplied as off-white pellets. Temperatures during transportation and storage may not exceed 50°C. Storage time of unopened bags may not surpass 24 months at room temperature. Drying prior to processing is essential. A moisture content less degradation. The property values listed below should be viewed as guidelines only and may vary based on processing conditions. No warranties of any kind, either expressed or implied are made regarding products described or regarding designs, data or information set forth. Process temperatures must not exceed 230°C. To achieve high Heat Deflection Temperatures, hot molding or annealing of the part is required.

Drying: dry the material for 4 – 6 hours at 100°C.

	Settings, °F*	Settings, °C*
Feed Zone	68-104	20-40
Melt Zone	356-375	180-190
Zone 1	375-410	190-210
Zone 2	375-410	190-210
Zone 3	375-410	190-210
Zone 4	375-410	190-210
Hot Runner	395-410	200-210
Nozzle	395-410	200-210
Hot Mold Set up	212-230	100-110

*These settings are intended as a starting point. Optimization may be required

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Physical Properties*	Test Method	Value
Melt Flow Rate (190°C, 2.16 kg)	ASTM D1238:2013	1 - 3 g/10 min

Mechanical Properties*	Test Method	Value
Tensile strength	ASTM D638	62 MPa
Elongation at break	ASTM D638	10%
Notched Izod Impact Resistance	ASTM D256	49 J/m
HDT (before crystallization)	ASTM D648	60°C
HDT (after crystallization)	ASTM D648	105°C

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