SECTION 1: PRODUCT DESCRIPTION

FC 10030 is made with Earth Renewable Technologies bio-based package developed for manufacturing extrusion products.

SECTION 2: PHYSICAL PROPERTIES & GUIDELINES FOR USE

FC 10030 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.

	Seetings, ºF*	**Seetings, ºC***
Feed Throat	70	21
Feed Section	311-347	155-175
Zone 1	356-428	180-220
Zone 2	356-428	180-220
Zone 3	356-428	180-220
Zone 4	356-428	180-220
Hot Runner	374-428	190-220
Nozzle	374-428	190-220
Hot Mold Set up	194-212	90-100

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

Physical Properties*	**Test Method**	**Value**
Melt Flow Rate (190°C, 2.16 kg)	ISO 1133-A	9 - 11 g/10 min

Mechanical Properties*	Test Method	Value
Tensile modulus	ISO 75-1/-2	3500 MPa
Tensile strength	ISO 75-1/-2	50 MPa
Elongation at break	ISO 75-1/-2	5%
Impact Resistance	ISO 179-1eA	5 kJ/m²
HDT (before crystallization)	ISO 75-1	60°C
HDT (after crystallization)	ISO 75-1	105°C

No freedom of infringement of any patent owned or pending by Earth Renewable Technologies LLC or others is to be inferred.