


Code	PRO_TDS_33	PRO <b>TECHNICAL DATA SHEET</b> TDS	
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## **SECTION 1: PRODUCT DESCRIPTION**

FC 60025 is made with Earth Renewable Technologies bio-based package developed for extrusion and thermoforming applications.


## **SECTION 2: PHYSICAL PROPERTIES & GUIDELINES FOR USE**

FC 60025 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, °F*	Seetings, °C*
<b>Feed Zone</b>	68-104	20-40
<b>Melt Zone</b>	356-375	170-190
<b>Zone 1</b>	375-410	190-210
<b>Zone 2</b>	375-410	190-210
<b>Zone 3</b>	375-410	190-210
<b>Zone 4</b>	375-410	190-210
<b>Hot Runner</b>	395-410	200-210
<b>Nozzle</b>	395-410	200-210

\*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	45 MPa
Elongation at break	ASTM D638	5%
Notched Izod Impact Resistance	ASTM D256	50 J/m
HDT (before crystallization)	ASTM D648	60°C

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