



FC 10015

Technical Data Sheet (TDS)

Date of issue: 01/18/2022 Version: 1.0

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PLA Compounds

SECTION 1: Product Description

FC 10015 is made with Earth Renewable Technologies’ bio-based microfiber-additive package developed for manufacturing for thermoforming.

SECTION 2: Physical Properties & Guidelines for use

FC 10015 is supplied as off-white pellets. Temperatures during transportation and storage may not exceed 80°C. Storage time of unopened bags may not surpass 24 months at room temperature. Drying prior to processing is essential. A moisture content less than 100ppm is recommended to prevent viscosity 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. In order to achieve high Heat Deflection Temperatures, hot molding or annealing of the part is required.

Drying: dry the material for 4 – 6 hours at 80°C.

	Settings, °F*	Settings, °C*
Feed Throat	70	21
Feed Section	260-300	130-150
Zone 1	375-395	191-200
Zone 2	375-395	191-200
Zone 3	375-395	191-200
Zone 4	375-395	191-200
Hot Runner	375-395	191-200
Nozzle	395-410	200-210
Cold Mold Set up	80-90	27-32
Screw Speed	40 – 100rpm	

*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)	RD – 007	1-3 g/10 min



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Mechanical Properties*		
	Test Method	Value
Notched Izod Impact Strength	ASTM D256:10	13.5KJ/m ²

Mechanical Properties*		
	Test Method	Value
HDT	ISO 75-1/-2	56°C

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