


Code	PRO_TDS_14	PRO <b>TECHNICAL DATA SHEET</b> TDS	
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<b>Responsible:</b> Pedro Lutz		<b>Approval:</b> Emanuel Martins	<b>Date:</b> 04/28/2022

### SECTION 1: Product Description

FC 10075 is made with Earth Renewable Technologies bio-based package developed for manufacturing thermoforming products.


### SECTION 2: Physical Properties & Guidelines for use

FC 10075 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*
<b>Feed Throat</b>	70	21
<b>Feed Section</b>	260-300	130-150
<b>Zone 1</b>	375-395	191-200
<b>Zone 2</b>	375-395	191-200
<b>Zone 3</b>	375-395	191-200
<b>Zone 4</b>	375-395	191-200
<b>Hot Runner</b>	375-395	191-200
<b>Nozzle</b>	395-410	200-210
<b>Cold Mold Set up</b>	80-90	27-32
<b>Hot Mold Set up</b>	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	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/m <sup>2</sup>
HDT (before crystallization)	ISO 75-1	95°C
HDT (after crystallization)	ISO 75-1	95°C

\*Data obtained from hot molded ASTM standard test bars. Results obtained at 100% add in.

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