



FC 10130

Technical Data Sheet (TDS)

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

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PLA Compounds

SECTION 1: Product Description

FC 10130 is made with Earth Renewable Technologies bio-based microfiber-additive package developed for manufacturing extrusion products.

SECTION 2: Physical Properties & Guidelines for use

FC 10130 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 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
Cold Mold Set up	212-230	100-110

*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)	ASTM D1238:2013	9 - 11 g/10 min



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Mechanical Properties*		
	Test Method	Value
Tensile Strength	ASTM D638:2014	52 MPa
		53 MPa*
Elongation at Break	ASTM D638:2014	66%
		86%*
Flexural Modulus	ASTM D790:2017	3150 MPa
		3280 MPa*
Notched Izod Impact Strength	ASTM D256:10(2018)	45 J/m
		51 J/m*
HDT (before crystallization)	ISO 75-1/-2	55°C
HDT (after crystallization)	ISO 75-1/-2	95°C

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

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