

Terratek[®] WC

Product Description

Terratek[®] WC100299

<u>Property</u>	<u>Value</u>
Density	1.45 g/cm ³
Moisture	<1%
Tensile Stress (maximum)	5,500 psi
Tensile Modulus	824,000 psi
Flexural Modulus	683,000 psi
Impact Strength (notched)	1.1 ft-lb/in

General Processing Conditions

Green Dot's Terratek[®] WC100299 resin needs to be dried before processing if the moisture is above 0.5%. Resin will dry quickly at 220°F in a desiccant dryer. Avoid prolonged resin exposure to air during molding or storage as the material can pick up moisture.

For best molding results, larger gates and runners are recommended. The injection pressure required to fill the mold is much higher than typical injection molding grade plastics. Typical injection molding temperatures are listed below, these are only a guide and may need to be changed based on the particular application:

Rear	350°F to 360°F
Middle	350°F to 360°F
Front	360°F to 375°F
Nozzle	360°F to 375°F
Mold	60°F to 170°F

The melt temperature of the resin should remain below 400°F to prevent the material from discoloring and having a burnt odor.

Packaging and Storing

Terratek[®] WC100299 resin is typically packaged in a sealed plastic-lined Gaylord at 1,500 lbs/Gaylord. The product should be stored in a cool, dry, and sanitary area to achieve maximum stability.

The information and recommendations in this sheet are based on our experience and analysis using standard procedures, and are believed to be accurate and reliable. However, they serve merely as typical guides, and are presented in good faith for the benefit of our customers. No guarantee, expressed or implied, is made regarding accuracy of the analysis, patent infringement, liabilities, or risks involved from the application of our products.	Issued:	3/11/10
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