

# Terratek®

## WC200360

Wood filled nylon 6

### Product Description

**Terratek® WC200360** is a proprietary blend of wood fiber and nylon for injection molding applications.

<u>Property</u>	<u>Test Method</u>	<u>Value</u>
Specific Gravity	ASTM D792	1.19 g/cm <sup>3</sup>
Shrinkage		0.006 in/in
Melt Index	ASTM D1238	3.2 g/10 min
Flex Strength	ASTM D790	18,035 psi
Flex Modulus	ASTM D790	579,702 psi
Tensile Strength	ASTM D638	10,522 psi
Tensile Modulus	ASTM D638	693,140 psi
Elongation		2.08 %
Notched Izod	ASTM D256	0.67 ft lb/in

### General Processing Conditions

**Green Dot's Terratek® WC200360** 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.

Feed 400F – 420F  
 Zone 2 420F – 440F  
 Zone 3 420F – 440F  
 Nozzle 440F – 450F

Mold 100F – 140F

Processors will need to limit the residence time in the barrel as much as possible to prevent degradation and burning.

Drying: 150F to 180F for 2 to 4 hours. Material moisture should be 0.2% or lower before running.

### Packaging and Storing

**Terratek® WC200360** resin is typically packaged in a sealed plastic-lined Gaylord at 1,100 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:	7/6/2016
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