

# Terratek®

## FX1504

### Product Description

Terratek® FX1504 is a unique elastomeric bioplastic with a diverse range of potential applications.

*Preliminary Data- Pending Third-Party Evaluation:*

Property	Test Method	Value
Specific Gravity	ASTM D792	1.23
Izod Impact	ASTM D256	6.06 ft lb/in
Tensile Strength	ASTM D638	1,873 psi
Tensile Modulus	ASTM D638	16,097 psi
Elongation	ASTM D790	400%
Flexural Strength	ASTM D790	762 psi
Flexural Modulus	ASTM D790	16,097 psi
Melt Index (190 C, 2.16 kg)	ASTM D1238	15.0 g/10min
Shrinkage		0.0095 in/in

Sustainability Guide	
Biobased content ASTM 6866	-
Biobased content by weight	-
Recycled content	-
Energy use	-
Compostable	-

### General Processing Recommendations

Green Dot's Terratek® FX1504 resin needs to be dried before processing. If resin is in a sealed box, dry resin at 90°F to 100°F for 2 to 3 hours. If resin is in an open box, dry resin at 100°F to 120°F for 4 to 5 hours.

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	300°F to 330°F
Middle	300°F to 330°F
Front	300°F to 330°F
Nozzle	300°F to 330°F

Processing at temperatures above 350° F and in combination with high shear conditions such as high injection speed may result in thermal degradation of this resin.

Specific recommendation for processing FX1504 can be made based on customer equipment and processes. For further suggestions, please contact Green Dot.

### Packaging and Storing

Terratek® FX1504 resin is typically packaged in a sealed plastic-lined fiber drum of 250 lbs. 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:	1/14/15
	Revised:	8/7/20
	Approved:	R&D/QC