

# Terratek® Flex

## FX1515

**Product Description**

Terratek® FX1515 is a unique elastomeric bioplastic with a diverse range of potential applications.

*Preliminary Data- Pending Third-Party Evaluation*

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

<u>Property</u>	<u>Test Method</u>	<u>Value</u>
Specific Gravity	ASTM D792	1.22
Shrinkage	ASTM D955	0.003 in/in
Melt Index (190°C/ 2.16 kg)	ASTM D1238	14.0 g/10 min
Tensile Strength (at Break)	ASTM D638	1,300 psi
Tensile Modulus	ASTM D638	7,122 psi
Elongation		400 %
Notched Izod	ASTM D256	No break
Flex Strength	ASTM D790	251.4 psi
Flex Modulus	ASTM D790	7,000 psi
Hardness (Shore A)	ASTM 2240	A85

**General Processing Recommendations**

Green Dot’s Terratek® FX1515 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 FX1515 can be made based on customer equipment and processes. For further suggestions, please contact Green Dot.

**Packaging and Storing**

Terratek® FX1515 resin is typically packaged in a sealed plastic-lined 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:	2/1/2018
	Revised:	02/11/21
	Approved:	R&D/QC