Terratek® Flex

FX2217

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

Product Description

Terratek® FX2217 is a unique elastomeric bioplastic with a diverse range of potential applications. This material is suitable for injection molding, profile extrusion, and sheet extrusion.

Property	Test Method	Value
Specific Gravity	ASTM D792	1.2243
Shrinkage (48 hrs)	ASTM D955	0.004312 in/in (parallel)
Shrinkage (48 hrs)	ASTM D955	0.0154 in/in (perpendicular)
Melt Index (190°C/ 2.16 kg)	ASTM D1238	13.97 g/10 min
Tensile Strength (at Break)	ASTM D638	2,078.6 psi
Tensile Modulus	ASTM D638	2,026.6 psi
Elongation		658.2 %
Notched Izod	ASTM D256	No break
Flex Strength	ASTM D790	251.4 psi
Flex Modulus	ASTM D790	4,641.8 psi
Hardness (Shore A)	ASTM 2240	A84

General Processing Recommendations

Green Dot's Terratek® FX2217 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 FX2217 can be made based on customer equipment and processes. For further suggestions, please contact Green Dot.

Packaging and Storing

Terratek® FX2217 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.

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