Product Terratek® FX1604

Product Description Proprietary blend of natural and synthetic biodegradable polyesters suitable for injection molding. This resin is made from polymers which pass industry standards for Industrial composting.

Renewable Content	
Biobased content (ASTM D6866)	20%
Biomass content (by weight)	20%

Property	Test Method	Value
Specific Gravity	ASTM D792	1.23
Shrinkage (48 hrs- parallel direction)	ASTM D955	0.0095 in/in
Melt Index (190°C / 2.16 kg)	ASTM D1238	15 g/10 min
Tensile Strength	ASTM D638	1,873 psi
Tensile Modulus	ASTM D638	16,097 psi
Elongation	ASTM D638	>400%
Notched Izod Impact	ASTM D256	6.06 ft-lb/in
Flexural Strength	ASTM D790	762 psi
Flexural Modulus	ASTM D790	16,097 psi

Drying Conditions

Moisture level: at or below 0.04% (400 ppm)
Method: Karl Fischer; if using a loss in weight analyzer, contact Green Dot for more information.
Drying conditions: Desiccant dryer 140°F for 2 to 4 hours or until the recommended moisture level is reached

ATTENTION: Moisture in Terratek® FX resins may result in hydrolysis which can cause brittleness, loss in strength, and reduction in melt strength, in addition to potentially impacting the shelf life of finished parts and films.

Packaging and Storing

This resin is typically packaged in a sealed plastic or foil lined box, drum, or gaylord. The product should be stored in a cool, dry, and sanitary area to achieve maximum stability.

Processing Recommendations

Terratek® resins can be processed on conventional plastics equipment. Follow standard purging process with a polyolefin or purge compound, such as Dyna-Purge, etc. Melt temperature of the resin should remain below 350°F.

Extrusion Recommendations

Feed Zone	270°F to 300°F
Middle Zones	290°F to 320°F
Front Zones	300°F to 330°F
Die Zones	300°F to 330°F
Chill Rolls	40°F to 80°F

Molding Recommendations

Feed Zone	250°F to 300°F
Middle Zones	290°F to 320°F
Front Zones	300°F to 340°F
Nozzle/Die	300°F to 340°F
Mold	40°F to 80°F