Product Terratek® HC200610

Product Description This resin is a combination of hemp and injection molding grade polypropylene (PP).

Renewable Content	
Biobased content (ASTM D6866)	13%
Biomass content (by weight)	30%

Property	Test Method	Value
Specific Gravity	ASTM D792	0.91
Shrinkage	ASTM D955	0.013 in/in
Melt Index (230°C / 2.16 kg)	ASTM D1238	17 g/10 min
Tensile Strength	ASTM D638	4,293 psi
Tensile Modulus	ASTM D638	326,983 psi
Elongation	ASTM D638	3.2%
Notched Izod Impact	ASTM D256	0.78 ft-lb/in
Flexural Strength	ASTM D790	6,797 psi
Flexural Modulus	ASTM D790	243,384 psi

Drying Conditions

Moisture level: at or below 0.25% (2500 ppm)

Method: as measured by a loss in weight analyzer 270°F for 15 minutes

Drying conditions: Desiccant dryer 150°F until the recommended moisture level is reached

ATTENTION: Moisture in Terratek® WC resins may result in splay, drool at the nozzle, foaming or other processing concerns.

Molding Recommendations

Terratek® resins can be processed on conventional molding equipment. Follow standard purging process with a polyolefin or purge compound, such as Dyna-Purge, etc. Melt temperature of the resin should remain below 400°F. If thermal degradation occurs, the operator will see dark streaks in the parts or purge, off-gassing, and drool at the nozzle or in the mold.

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.

Feed Zone	300°F to 360°F
Middle Zones	330°F to 360°F
Front Zones	360°F to 380°F
Nozzle/Die	360°F to 380°F
Mold	40°F to 100°F