

**FC/AD1 Series**
**THERMOLAST® K**

The FC/AD1 Series is your material solution for applications with food contact providing excellent adhesion to polar thermoplastics such as PC, ABS and PETG.

**Typical applications**

- Function and design elements
- Grip applications
- Household articles
- Packaging (for food and careproducts)
- Razors
- Seals
- Toothbrushes
- Toys

**Material advantages**

- Applications with food contact
- Code of Federal Regulations, Title 21 (CFR 21) "FDA"
- Easy coloring (compounds in natural colors)
- EN71/3
- Excellent adhesion
- Excellent processing behavior
- Halogen-free
- Regulation (EU) No. 10/2011

**Processing Method:** Injection Molding

	Color / RAL DESIGN	Hardness DIN ISO 7619 ShoreA	Density DIN EN ISO 1183-1 g/cm <sup>3</sup>	Tensile Strength <sup>1</sup> DIN 53504/ISO 37 MPa	Elongation at Break <sup>1</sup> DIN 53504/ISO 37 %	Tear Resistance ISO 34-1 Methode B (b)(Graves) N/mm	Adhesion to ABS VDI 2019 N/mm	Adhesion to PC VDI 2019 N/mm
<b>TF3FMS</b>	natural	34	1.100	2.0	550	10.0	2.0 (A)	2.0 (A)
<b>TF4FMS</b>	natural	39	1.100	2.5	650	10.5	2.0 (A)	2.0 (A)
<b>TF5FMA</b>	natural	50	1.100	3.5	600	14.0	2.5 (A)	3.0 (A)
<b>TF6FMA</b>	natural	60	1.100	4.5	600	16.0	4.5 (A)	3.5 (A)
<b>TF7FMA</b>	natural	67	1.100	4.5	480	18.0	6.0 (D)	4.5 (B)
<b>TF8FMA</b>	natural	77	1.100	5.5	450	21.0	7.5 (D)	9.0 (D)
<b>TF9FMA</b>	natural	87	1.100	11.5	750	40.0	9.0 (A)	16.0 (D)

<sup>1</sup> Deviating from ISO 37 standard test piece S2 is tested with a traverse speed of 200 mm/min.

This datasheet is an extract of the KRAIBURG TPE program. Please contact KRAIBURG TPE to select the compound suitable for the requirements.

Disclaimer: The information provided in this documentation corresponds to our knowledge on the subject at the date of its publication and may be subject to revision as new knowledge and data becomes available. All values reported are typical values based on sample test results and are not a guarantee of performance. The responsibility to conduct testing to determine suitability of use for the particular process or end-use application remains with the customer. KRAIBURG TPE does not warrant or assume any liability with regards to the use of the information presented in this document.

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Specification limits are based on three-fold standard deviation from the average value.

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2016-04-18

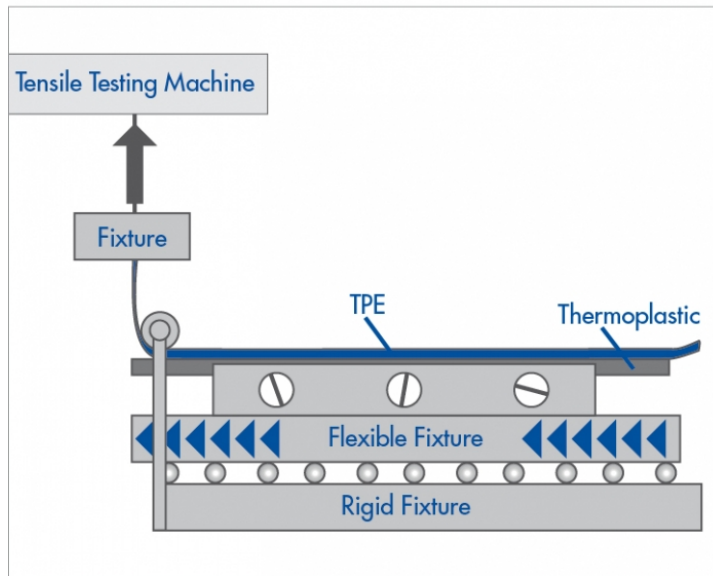
*CUSTOM-ENGINEERED TPE AND MORE*

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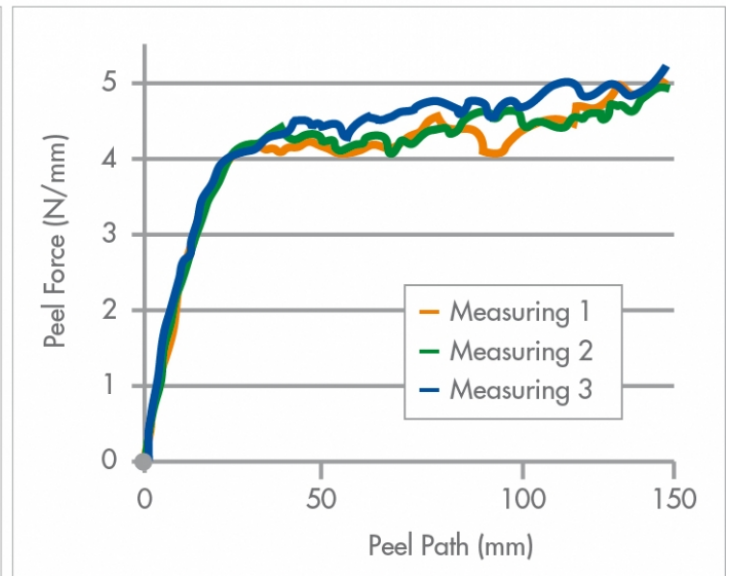
Description peel test

# Peel test according to VDI guide line 2019

Test Setup



Example diagram for results of a peel test



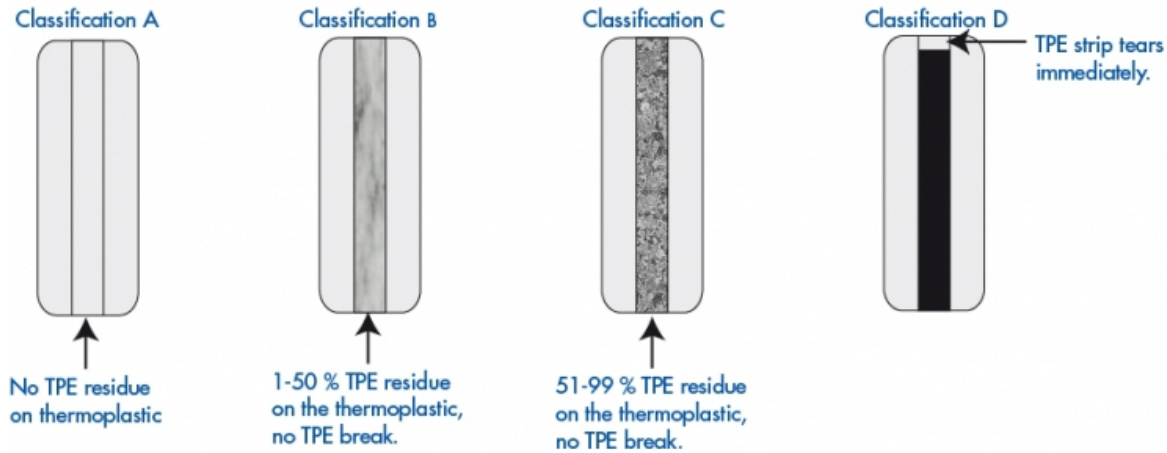
Classification

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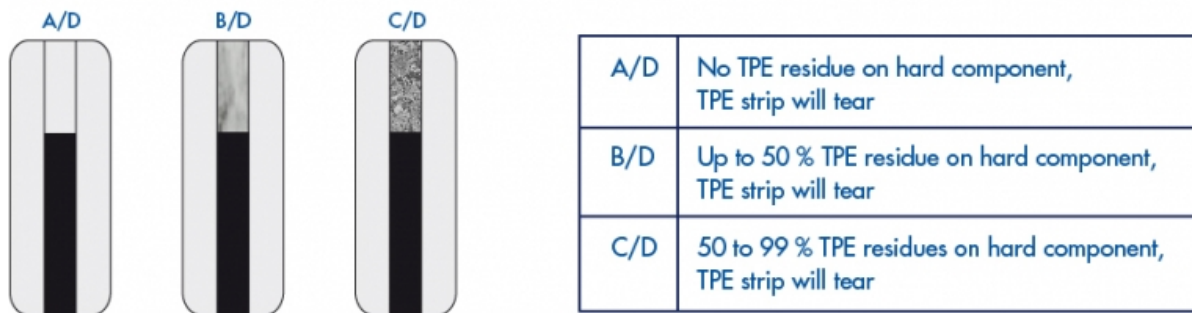
## Peel test according to VDI Guideline 2019

For the VDI peel test we add two characters to the peel force value.  
The first character describes the TPE residue on the hard component.



A	No TPE residue on hard component
B	Up to 50 % TPE residue on hard component
C	50 to 99 % TPE residue on hard component
D	TPE strip tears immediately

The second character describes if the TPE strip will tear during the measurement at any position on the peel path.



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**Processing Guideline Injection Molding**

Cylinder temperature	180 - 210 - 240 °C, max. 250 °C (360 - 410 - 460 °F, max. 480 °F)
Hotrunner	Hot runner temperatures: 200 -250 °C (390 - 480 °F). The runner should be empty after a maximum of 2 - 3 shots.
Injection pressure	200 - 1000 bar (2900 - 14504 psi) (depending on the size and weight of the part).
Injection rate	In general, the fill time should not be more than 1–2 seconds.
Hold pressure	We recommend to derive the optimum hold pressure from determining the solidification point, starting with 40 % - 60 % of the required injection pressure.
Back pressure	20 - 100 bar; if colour batches are used, higher back pressure is necessary.
Screw retraction	If an open nozzle is used processing with screw retraction is advisable.
Mold temperature	The mold temperature depends on the hard component. A temperature exceeding 80 °C (175 °F) should be avoided. The common temperature is 40 - 60 °C (105 - 140° F).
Pre drying	To achieve optimum mechanical values, drying the material for 2 - 4 hours at 60 - 80 °C (140 - 175 °F) is recommended.
Needle valve	With materials < 50 Shore A the use of a needle valve is advisable.
Screw geometry	Standard 3-zone polyolefine screw.
Residence time	The residence time is to be set as short as possible with a maximum of 10 minutes.
Cleaning recommendation	For cleaning and purging of the machine it is appropriate to use polypropylene or polyethylene. Machine must be PVC-free.

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