

FC/CS Series

THERMOLAST® K

The FC/CS Series is your material solution for applications with food contact providing an excellent compression set. The series is available in translucent colors.

**Typical applications**

- Closures
- Flexible Connections
- Household articles
- Membranes
- Packaging (for food and careproducts)
- Seals
- Valves

**Material advantages**

- Adhesion to PP
- Applications with food contact
- Code of Federal Regulations, Title 21 (CFR 21) "FDA"
- Easy coloring (compounds in natural colors)
- EN71/3
- Excellent mechanical properties
- For injection molding and extrusion
- High elasticity
- Perfect surface finish
- Recyclable
- Regulation (EU) No. 10/2011
- Service temperature: -40 °C to +120 °C (dynamic stress: up to 100 °C)

**Processing Method:** Extrusion, 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	CS 72 h/23 °C DIN ISO 815-1 Method A %	CS 24 h/70 °C DIN ISO 815-1 Method A %	CS 24 h/100 °C DIN ISO 815-1 Method A %
<b>TF3STE</b>	translucent	33	0.890	7.0	800	10.5	15	26	42
<b>TF4STE</b>	translucent	44	0.890	9.0	850	13.5	20	30	45
<b>TF5STE</b>	translucent	54	0.890	11.0	850	17.0	23	38	48
<b>TF6STE</b>	translucent	65	0.890	12.5	800	21.5	27	40	53
<b>TF7STE</b>	translucent	75	0.890	13.0	750	27.5	35	50	60
<b>TF8STE</b>	translucent	83	0.890	14.5	700	35.0	44	66	75

<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.

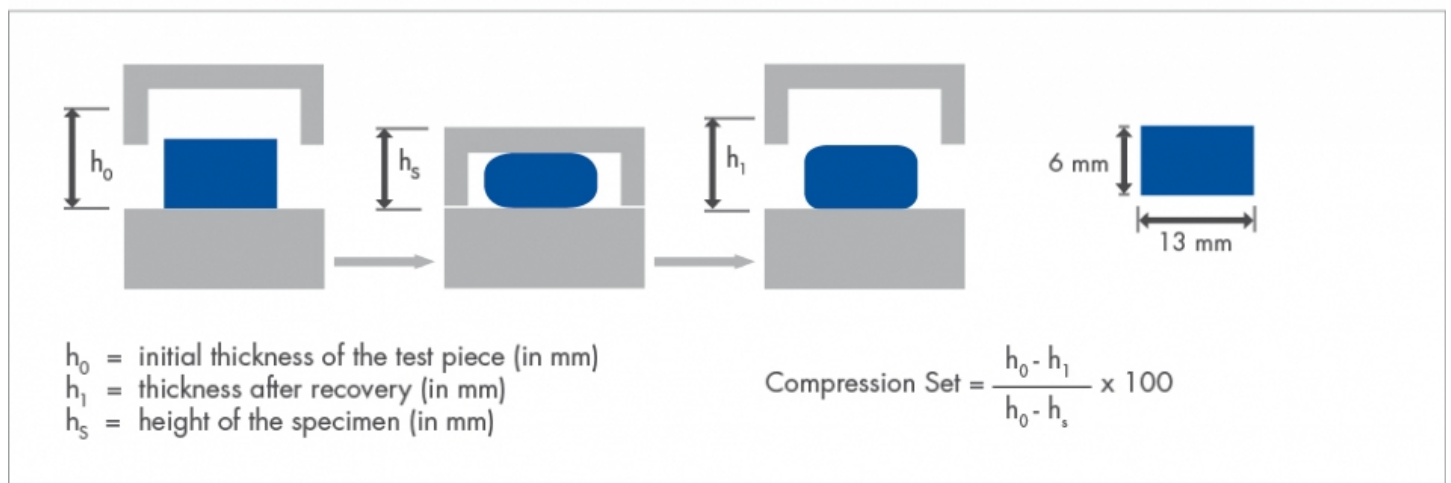
Disclaimer: The information provided in this documentation corresponds to our knowledge on the subject at the date of its publication and may be subject to revision as new knowledge and data becomes available. All values reported are typical values based on sample test results and are not a guarantee 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.

All values published in this data sheet are rounded average values.  
Specification limits are based on three-fold standard deviation from the average value.

**Compression Set**

# Compression Set (acc. DIN ISO 815)

For the compression set testing the following specimen is used:  
The specimen is a cylindrical disk shaped 6 mm thick and 13 mm in diameter.



The specimen is compressed by 25%. The compressed specimen is heated to the test temperature. DIN ISO 815 describes two methods.

**Method A:** The specimen is allowed to recover immediately after its aging in the oven and then cooled down to room temperature. After 30 minutes the thickness of the specimen is measured and the compression set calculated.

**Method B:** The specimen is cooled down to room temperature after its aging in the oven and then allowed to recover.

Test results gained from method B are in general higher than from method A.

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**Processing Guideline Injection Molding**

Cylinder temperature	180 - 200 - 220 °C, max. 250 °C (360 - 390 - 430 °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	25 - 40 °C (77 - 104 °F)
Pre drying	Pre drying of the material is not necessary; if surface moisture forms as a result of changes in temperature, the material should be dried for 2 - 4 hours at 60 - 80 °C (140° F).
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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**Processing Guideline Extrusion**

Cylinder temperature	160 - 180 - 200 °C, max. 250 °C (320 - 360 - 390 °F; max. 480 °F)
Screw geometry	Standard three-zone screw (e.g. polyolefin screw). The screw must be able to provide sufficient shearing.
L/D ratio	At least 25
Compression ratio	At least 3.5 : 1
Screens / breaker plate	A breaker plate and a screen pack are generally recommended in the extruder configuration in order to increase pressure.
Die land	<= 3 mm ( <= 0,12 in.)
Extruder Head	Ca. 200 °C (390 °F)
Die temperature	Ca. 200 - 230 °C (390 - 450 °F)
Pre drying	Pre drying of the material is not necessary; if surface moisture forms as a result of changes in temperature, the material should be dried for 2 - 4 hours at 60 - 80 °C (140 - 175 °F).
Calibration	Generally not necessary; support elements may be required when extruding THERMOLAST® compounds with high hardness or when coextruding with standard thermoplastics.
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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