

FC/ht Series
THERMOLAST® K

The FC/ht Series is your highly transparent material solution for applications with food contact. The series is characterized, among other things, by its excellent adhesion to PP.

Typical applications

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

Material advantages

- Adhesion to PP
- EN71/3
- Excellent processing behavior
- Excellent transparency
- FDA compliant
- Regulation (EU) 10/2011
- Smooth, non-tacky feel
- Various color options and effects available (incl. transparent colors, metallic & pearlescent effect)

Processing Method: Injection Molding

	Color	Hardness Shore A DIN ISO 7619 ShoreA	Density DIN EN ISO 1183-1 g/cm ³	Tensile Strength ¹ DIN 53504/ISO 37 MPa	Elong. at Break S2 ¹ DIN 53504 / ISO 37 %	Tear Resistance DIN ISO 34-1 N/mm	Haze Value on 2mm Plaque ASTM D 1003 ² %
TF3THT	transparent	30	0.880	2.5	550	6.5	11.00
TF4THT	transparent	38	0.880	4.5	600	9.0	11.00
TF5THT	transparent	47	0.880	5.5	600	12.0	11.00
TF6THT	transparent	59	0.890	10.0	650	17.5	9.00
TF7THT	transparent	68	0.890	15.0	600	24.5	9.00
TF8THT	transparent	77	0.890	23.5	600	27.0	11.00

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

² Values measured according to ASTM D 1003 with a specimen thickness of 2 mm and the transmission tester Haze-Gard plus (BYK).

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

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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Processing Guideline Injection Molding

Cylinder temperature	220 - 200 - 180 °C max. 250 °C (428 - 392 - 356 °F, max. 482 °F)
Hotrunner	Hot runner temperatures: 180 - 220 °C (356 - 428 °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 - 50 bar (285 - 710 psi); 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	50 - 60 °C (120 - 140 °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°C (140° F).
Needle shut-off	With materials < 50 Shore the use of a needle seal nozzle 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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