



Preliminary Datasheet
Product Data & Processing Conditions
deTerra™ Bio-Based Polymer
XP404 Non-Halogenated Flame Retardant Grade

Material Property	Value	Units	ASTM TEST
Specific Gravity *	1.32	g/cm ³	
Melt Flow Rate * @ 190 °C, / 2.16 kg	1.3	g/10 min	D 1238
MECHANICAL *			
Impact Strength, Izod			
notched 1/8 in (3.2 mm) section	0.94	ft-lbs/in	D 256
unnotched 1/8 in (3.2 mm) section	8.13	ft-lbs/in	D 256
Tensile Strength	7,990	psi	D 638
Tensile Elongation	2.85	%	D 638
Tensile Modulus	454,000	psi	D 638
Flexural Strength	14,100	psi	D 790
Flexural Modulus	457,000	psi	D 790
THERMAL *			
Deflection Temperature			
@ 264 psi (1820 kPa)	135	°F	D 648

* Above values per Interfacial Solutions laboratory testing of injection molded samples

GENERAL EXTRUSION PROCESSING CONDITIONS

	English	Units
Melt Temperature	330 – 370	°F
Die Temperature	360 - 390	°F
Drying	2 - 4 hrs @ 120 °F	
Target Moisture Level	< .04%	

PROCESSING NOTES

This information is intended to be used only as a guideline for designers and processors of modified thermoplastics. Because design and processing is complex, a set solution will not solve all problems. Observation on a “trial and error” basis may be required to achieve desired results.

Data are obtained from specimens molded under carefully controlled conditions from representative samples of the compound described herein. Properties may be materially affected by molding techniques applied and by the size and shape of the item molded. No assurance can be implied that all molded articles will have the same properties as those listed.

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**949 Antler Court
River Falls, WI 54022**

www.interfacialsolutions.com