


Base Resin	Polyether Block Amide (PEBA)
Compound Type	 Ecomass Compound 1002 Series - Medium and High Density
Processing Method	Extrusion

Process Guidelines

Processing Conditions	Material Drying
<ul style="list-style-type: none"> • Process Temperature Range.. 325 - 365 °F • Die Temperature Range..... 330 - 345 °F • Chill Roll Temp. Range..... 110 - 125 °F 	<ul style="list-style-type: none"> • Dryer Type(s)..... Dehumidifying • Drying Temperature Range... 140 °F • Typical Drying Time¹..... 4 - 8 hrs • Do Not Exceed..... 160 °F • Dryer Dew Point..... -20 to -40°F • Minimum Air Flow..... 0.8 - 1.0 CFM • Properly Functioning..... Desiccant Beds Filters Volatiles Trap
Machine Requirements	Safety / Purging
<ul style="list-style-type: none"> • No special requirements 	<ul style="list-style-type: none"> • Maintain adequate ventilation. • Wear safety glasses & protective clothing. • Do not mix with other materials. • Avoid excessive residence time in the barrel. <small>(Purge if extended residence time is anticipated)</small> • Use extreme caution at melt temp. > 600°F
	Purge with high viscosity HDPE or high temperature commercial purge compound as recommended.

Notes

¹ Typical Drying time assumes unopened packaging and utilization of a dehumidifying dryer with a dew point of -40° with sufficient air flow.

² Pack time can depend on wall thickness and gate design

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