


<b>Base Resin</b>	<b>Polyether Block Amide (PEBA)</b>
Compound Type	 Ecomass Compound 1002 Series - High Density
Processing Method	Injection Molding

## Process Guidelines

Processing Conditions	Material Drying
<ul style="list-style-type: none"> <li>● Melt Temperature Range..... 400 - 450 °F</li> <li>● Mold Temperature Range..... 80 - 140 °F</li>   <li>● Injection Pressure..... As required</li> <li>● Pack (Hold) Pressure..... 65 - 75% of Inj. Psi</li> <li>● Back Pressure..... 15 - 25 psi</li>   <li>● Injection Speed..... Medium - Fast</li> <li>● Screw Speed..... 100 - 250 rpm</li>   <li>● Fill Time..... 1.0 - 2.0 in. / sec.</li> <li>● Pack (Hold) Time<sup>2</sup>..... 10 - 15 sec.</li> <li>● Cooling Time..... As required</li>   <li>● Cushion..... .25 - .50 in.</li> </ul>	<ul style="list-style-type: none"> <li>● Dryer Type(s)..... Dehumidifying</li>   <li>● Drying Temperature Range... 150 °F</li>   <li>● Typical Drying Time<sup>1</sup>..... 4 - 6 hrs</li>   <li>● <b>Do Not Exceed</b>..... 180 °F</li>   <li>● Dryer Dew Point..... -20 to -40°F</li>   <li>● Minimum Air Flow..... 0.8 - 1.0 CFM</li>   <li>● Properly Functioning..... Desiccant Beds Filters Volatiles Trap</li> </ul>

Molding Machine Requirements	Safety / Purging
<ul style="list-style-type: none"> <li>● Screw L/D..... 20:1 min.</li> <li>● Screw Compression Ratio.... 2.5:1 min.</li>   <li>● Feed Throat..... Cooled</li>   <li>● Nozzle Type..... Reverse taper</li> <li>● Check Ring Type..... Free flow</li>   <li>● Typical Clamp Tonnage..... 2.5 - 4.0 tons/in<sup>2</sup></li> </ul>	<ul style="list-style-type: none"> <li>● Maintain adequate ventilation.</li>   <li>● Wear safety glasses &amp; protective clothing.</li>   <li>● Do not mix with other materials.</li>   <li>● Avoid excessive residence time in the barrel. <small>(Purge if extended residence time is anticipated)</small></li> <li>● <b>Use extreme caution at melt temp. &gt; 600°F</b></li> </ul>
Abrasion Resistant Screw, Barrel & Check Ring	Purge with high viscosity HDPE or high temperature commercial purge compound as recommended.

### Notes

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

<sup>2</sup> Pack time can depend on wall thickness and gate design

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