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| <b>Base Resin</b> | <b>High Density Polyethylene (HDPE)</b>  |
| Compound Type     |  Ecomass Compound 3600 Series - Medium and High Density |
| Processing Method | Injection and Compression Molding  |

**Process Guidelines**

| Processing Conditions  | Material Drying  |
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| <ul style="list-style-type: none"> <li>• Melt Temperature Range..... 350 - 440 °F *</li> <li>• Mold Temperature Range..... 70 - 150 °F<br/>* can be significantly less for compression molding</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)..... N/A</li> <li>• Drying Temperature Range... Drying Not Required</li> <li>• Typical Drying Time<sup>1</sup>..... N/A</li> <li>• <b>Do Not Exceed</b>.....</li> <li>• Dryer Dew Point.....</li> <li>• Minimum Air Flow.....</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/in2</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.<br/>(Purge if extended residence time is anticipated)</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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