


Base Resin	NYLON 6/10 (Polyamide 6/10)
Compound Type	 Ecomass Compound 1900 Series - Medium and High Density
Processing Method	Injection Molding

Process Guidelines

Processing Conditions	Material Drying
<ul style="list-style-type: none"> Melt Temperature Range..... 440 - 480 °F Mold Temperature Range..... 135 - 175 °F Injection Pressure..... As required Pack (Hold) Pressure..... 65 - 75% of Inj. Psi Back Pressure..... 15 - 25 psi Injection Speed..... Medium - Fast Screw Speed..... 100 - 250 rpm Fill Time..... 1.0 - 2.0 in. / sec. Pack (Hold) Time²..... 10 - 15 sec. Cooling Time..... As required Cushion..... .25 - .50 in. 	<ul style="list-style-type: none"> Dryer Type(s)..... Dehumidifying Drying Temperature Range... 165 °F Typical Drying Time¹..... 4 - 6 hrs Do Not Exceed..... 200 °F Dryer Dew Point..... -20 to -40°F Minimum Air Flow..... 0.8 - 1.0 CFM Properly Functioning..... Desiccant Beds Filters Volatiles Trap
Molding Machine Requirements	Safety / Purging
<ul style="list-style-type: none"> Screw L/D..... 20:1 min. Screw Compression Ratio.... 2.5:1 min. Feed Throat..... Cooled Nozzle Type..... Reverse taper Check Ring Type..... Free flow Typical Clamp Tonnage..... 2.5 - 4.0 tons/in² 	<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. (Purge if extended residence time is anticipated) Use extreme caution at melt temp. > 600°F
Abrasion Resistant Screw, Barrel & Check Ring	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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