



Ecomass® Compounds

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... 165 °F Typical Drying Time¹..... 4 - 8 hrs Do Not Exceed..... 170 °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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