



# Ecomass Compounds

<b>Base Resin</b>	<b>SEBS</b> (Styrene Ethylene Butylene Styrene Block Copolymer)
Compound Type	Ecomass Compound - 5100 Series - Moderate Density
Processing Method	Injection Molding

## Process Guidelines

Processing Conditions	Material Drying
<ul style="list-style-type: none"> <li>Melt Temperature Range..... 105C (220F) Zone 1</li> <li>Melt Temperature Range..... 190C (375F) Zone 4</li> <li>Mold Temperature Range..... 23 - 43C (70 - 110F)</li> <li>Injection Pressure..... As required</li> <li>Pack (Hold) Pressure..... 65 - 75% of IP</li> <li>Back Pressure..... 3 -7 bar (50 - 100 psi)</li> <li>Injection Speed..... Medium - Fast</li> <li>Screw Speed..... 50 - 100 rpm</li> <li>Fill Time..... 2.5-5 cm/s (1.0 - 2.0"/s)</li> <li>Pack (Hold) Time<sup>2</sup>..... 10 - 15 sec.</li> <li>Cooling Time..... As required</li> <li>Cushion..... 6 - 12mm (0.25 - 0.50")</li> </ul>	<ul style="list-style-type: none"> <li>Dryer Type(s)..... Dehumidifying</li> <li>Drying Temperature Range... 23C (73F)</li> <li>Typical Drying Time<sup>1</sup>..... 2 hours</li> <li><b>Do Not Exceed</b>..... 4 hours</li> <li>Dryer Dew Point..... -20 to -40C</li> <li>Minimum Air Flow..... 0.8 - 1.0 CFM</li> <li>Properly Functioning..... Dessicant 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. (Purge if extended residence time is anticipated)</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> Drying required only if surface moisture is present

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

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