

Ecomass® 1080CO94

Polyamide

Ecomass Technologies

Message:

Ecomass®1080CO94 is a polyamide material that contains a copper filler. This product is available in North America and is processed by injection molding.

Ecomass®The main features of 1080CO94 are:

Good toughness

non-toxic

General Information			
Filler / Reinforcement	Copper filler		
Features	Good toughness		
	Non-toxic		
	Medium density		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	5.99	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.60 - 0.90	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	9100	MPa	ASTM D638
Tensile Strength	31.7	MPa	ASTM D638
Tensile Elongation (Break)	8.0	%	ASTM D638
Flexural Modulus	5240	MPa	ASTM D790
Flexural Strength	46.9	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	80	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	135	°C	ASTM D648
1.8 MPa, not annealed	121	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature - Desiccant Dryer	73.9	°C	
Drying Time - Desiccant Dryer	4.0	hr	
Processing (Melt) Temp	204 - 254	°C	
Mold Temperature	57.2 - 85.0	°C	
Injection Rate	Moderate-Fast		
Back Pressure	0.103 - 0.172	MPa	
Screw Speed	100 - 250	rpm	

Clamp Tonnage	3.4 - 5.5	kN/cm ²
Cushion	6.35 - 12.7	mm
Screw L/D Ratio	20.0:1.0	
Screw Compression Ratio	2.5:1.0	

Injection instructions

Pack (Hold) Pressure: 65 to 75% of Injection Pressure
Fill Time: 1.0 to 2.0 in/sec
Pack (Hold) Time: 10 to 15 sec
Cooling Time: As required
Feed Throat: Cooled
Nozzle Type: Reverse Taper
Check Type: Free Flow
Maximum Drying Temp: 200 °F
Dryer Dew Point: -20 to -40 °F
Minimum Air Flow: 0.8 to 1.0 CFM
Injection Pressure: As Required

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Recommended distributors for this material

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