

# Ecomass® 1002ZB92

Polyether Block Amide

Ecomass Technologies

## Message:

Nontoxic alternative to Lead (Pb), weighting, balancing and radiation shielding applications.

General Information			
Features	High density		
	Good toughness		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	
Density	6.90	g/cm <sup>3</sup>	
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	9.00	MPa	ISO 527-2
Tensile Strain (Break)	500	%	ISO 527-2
Flexural Modulus	200	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	No Break		ISO 180/A
Injection	Nominal Value	Unit	
Drying Temperature - Desiccant Dryer	65.6	°C	
Drying Time - Desiccant Dryer	4.0 - 6.0	hr	
Processing (Melt) Temp	204 - 232	°C	
Mold Temperature	26.7 - 60.0	°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 <sup>2</sup>	
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 PressureFill Time: 1.0 to 2.0 in/secPack (Hold) Time: 10 to 15 secCooling Time: As requiredFeed Throat: CooledNozzle Type: Reverse TaperCheck Type: Free FlowMaximum Drying Temp: 180 °FDryer Dew Point: -20 to -40 °FMinimum Air Flow: 0.8 to 1.0 CFMInjection Pressure: As Required			
Extrusion	Nominal Value	Unit	
Drying Temperature	70.0	°C	
Drying Time	2.0 - 4.0	hr	

Melt Temperature

200 - 230

°C

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#### Recommended distributors for this material

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