

Ecomass® 1080ZC86

Polyamide

Ecomass Technologies

Message:

Ecomass®1080ZC86 is a polyamide material, and the filler is stainless steel powder filler. This product is available in North America and is processed by injection molding.

Ecomass®The main features of 1080ZC86 are:

Good toughness

non-toxic

General Information			
Filler / Reinforcement	Stainless steel powder filler		
Features	Good toughness		
	Non-toxic		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Molding Shrinkage	0.80 - 1.0	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	7000	MPa	ISO 527-2
Tensile Stress (Yield)	28.0	MPa	ISO 527-2
Tensile Strain (Break)	2.0	%	ISO 527-2
Flexural Modulus	6000	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	6.0	kJ/m²	ISO 180/A
Injection	Nominal Value	Unit	
Drying Temperature - Desiccant Dryer	73.9	°C	
Drying Time - Desiccant Dryer	4.0	hr	
Processing (Melt) Temp	204 - 249	°C	
Mold Temperature	54.4 - 76.7	°C	
Injection Rate	Moderate-Fast		
Back Pressure	0.103 - 0.172	MPa	
Screw Speed	100 - 250	rpm	
Clamp Tonnage	3.4 - 5.5	kN/cm²	
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

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

