

Ecomass® 3620BX60

High Density Polyethylene

Ecomass Technologies

Message:

18% Borated Polyethylene (HDPE)

General Information			
Forms	Particle		
Processing Method	Compression molding Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.35	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.60 - 1.0	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2070	MPa	ASTM D638
Tensile Strength	10.0	MPa	ASTM D638
Tensile Elongation (Break)	8.0	%	ASTM D638
Flexural Modulus	1930	MPa	ASTM D790
Flexural Strength	13.8	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	110	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	76.7	°C	ASTM D648
1.8 MPa, not annealed	65.6	°C	ASTM D648
Injection	Nominal Value	Unit	
Processing (Melt) Temp	177 - 227	°C	
Mold Temperature	21.1 - 65.6	°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
Injection Pressure: As Required

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