

Ecomass® 1002TU96

Polyether Block Amide

Ecomass Technologies

Message:

Ecomass® 1002TU96 is a polyether block amide (PEBA-ether) material containing a tungsten filler. This product is available in North America and is processed by injection molding. Ecomass® The main characteristics of 1002TU96 are: non-toxic.

General Information			
Filler / Reinforcement	Tungsten packing		
Features	Radiaton Shielding		
	High density		
	Non-toxic		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	11.0	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.50 - 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2070	MPa	ASTM D638
Tensile Strength	19.0	MPa	ASTM D638
Tensile Elongation (Break)	12	%	ASTM D638
Flexural Modulus	758	MPa	ASTM D790
Flexural Strength	34.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	270	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed)	51.7	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	0.20	ohms	ASTM D257
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 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: 180 °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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