

Ecomass® 1850ZC84

Polyamide 6

Ecomass Technologies

Message:

Ecomass® 1850ZC84 is a polyamide 6 (nylon 6) material, which contains a stainless steel powder filler. This product is available in North America and is processed by injection molding.

Ecomass® The main features of 1850ZC84 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
Density	3.99	g/cm ³	Internal method
Molding Shrinkage	0.70 - 0.90	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	7500	MPa	ISO 527-2
Tensile Stress (Yield)	25.0	MPa	ISO 527-2
Tensile Strain (Break)	0.50	%	ISO 527-2
Flexural Modulus	6200	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	5.0	kJ/m ²	ISO 180/A
Injection	Nominal Value	Unit	
Drying Temperature - Desiccant Dryer	73.9 - 79.4	°C	
Drying Time - Desiccant Dryer	4.0 - 6.0	hr	
Processing (Melt) Temp	232 - 260	°C	
Mold Temperature	57.2 - 79.4	°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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