

Ecomass® 4703BI71

Polyurethane

Ecomass Technologies

Message:

Ecomass®4703BI71 is a polyurethane material that contains fillers. This product is available in North America and is processed by injection molding.

Ecomass®The main features of 4703BI71 are:

Good flexibility

non-toxic

General Information			
Filler / Reinforcement	Filler		
Features	Good flexibility		
	Non-toxic		
	Medium density		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	2.49	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.60 - 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	552	MPa	ASTM D638
Tensile Strength	20.0	MPa	ASTM D638
Tensile Elongation (Break)	220	%	ASTM D638
Flexural Modulus	169	MPa	ASTM D790
Flexural Strength	44.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	250	J/m	ASTM D256
Injection	Nominal Value	Unit	
Drying Temperature - Desiccant Dryer	82.2	°C	
Drying Time - Desiccant Dryer	2.0	hr	
Drying Time, Maximum	4.0	hr	
Processing (Melt) Temp	204 - 221	°C	
Mold Temperature	10.0 - 26.7	°C	
Injection Rate	Moderate-Fast		
Back Pressure	0.103 - 0.172	MPa	
Screw Speed	100 - 250	rpm	
Clamp Tonnage	3.4 - 5.5	kN/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 Dryer Dew Point: -20 to -40 °F Minimum Air Flow: 0.8 to 1.0 CFM Injection Pressure: As Required

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