

## Datasheet of ECOPLAN-DURA

Properties	Condition	Measuring Method	Unit	Value
<b>Physical</b>				
Specific Gravity		ASTM D792		1.3
Melt index	2160g@190°C	ASTM D1238	g/10min	5
<b>Mechanical</b>				
Tensile Strength	50mm/min	ASTM D638	MPa	42
Tensile Elongation @ break	50mm/min	ASTM D638	%	8
Izod Impact Strength(Notched)	23°C	ASTM D256	J/m	40
<b>Thermal</b>				
Heat Deflection Temperature(HDT)	4.6kg	ASTM D648	°C	100

### **Headquarter / R&D center**

686 Sampyung-Dong, Bundang-Gu, Seongnam-Si,  
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### **Ulsan Plant**

600 Hwangseong-Dong, Nam-Gu,  
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## Injection Molding Guide

	Unit	Value
<b>Drying Conditions</b>		
(Recommend)	<b>80°C for 4~5 hrs by dehumidifying dryer</b>	
<b>Barrel Temperature</b>		
Feeding		160
Metering	°C	200
Nozzle		190
Mold temperature		110
<b>Injection conditions</b>		
Injection pressure	psi	1200~2000
Injection speed		Slow
Hold pressure	psi	800~1400
Back pressure	psi	50~150
Injection time	S	10~15
Screw speed	rpm	50~100
Cooling time	s	30 ~ 60

**< Test machine >**

- 1) Manufacturer: Engel (Model: ES240/75P)
- 3) Screw diameter: 35mm
- 5) Cavity dimension: 125 ×125 ×2 mm

- 2) Clamping Force: 75 ton
- 4) Screw stroke: 160mm

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