

» PROCESSING GUIDE

ECCOH™ LSFOH

LOW SMOKE AND FUME, NON-HALOGEN

General Extrusion Guidelines

ECCOH™ compounds are thermoplastic polyolefin-based low smoke and fume, non-halogenated systems. Designated systems can be cross-linked with use of dry silane or E-beam irradiation.

EXTRUDER	
Screw	3/4" to 6" Polyethylene type—Single flight, no mixing section, 1.5–2:1 compression ratio
Tooling	Semi-Pressure type: 30°–40° angle
Die	On size with 1/8" or less land
L/D	24:1 recommended
Screen Pack	No screen pack (Optional depending on pressure)
Cooling Trough	120–150°F (50–65°C) recommended
Feeder	Gravimetric type preferred—3 compartment for cross-linked
Dryer	Desiccant type, 4 hours at 160°F (70°C) For ECCOH™ compound only; never put Dry Silane in Dryers

PROCESSING		
Temperature	ECCOH 5000 Series	ECCOH 6000 Series
Wire Preheat	180–250°F (80–120°C)	180–250°F (80–120°C)
Feed Zones	200°F (93°C)	275°F (135°C)
Transition	275°F (135°C)	325°F (163°C)
Metering	300°F (150°C)	375°F (190°C)
Head/Die	330°F (165°C)	420°F (215°C)
Target Melt	330–340°F (165–170°C)	420–440°F (215–225°C)
Flame at Die Tip	Yes—as needed	
Line Speed	Shear sensitive: Observe Melt Temperature, Motor Amperage, and Pressure	
Purge Compound	HDPE	

ADDITIONAL INFORMATION

See respective data sheets for specific temperature recommendations.

Cross-linked products only: Dry Silane cannot be dried, has a 6 month shelf life when stored unopened in a cool dry location and must be used within a few days after opening. Dry Silane products will crosslink in the barrel if left hot without bleeding. Bleed constantly when possible.

To learn more about ECCOH wire and cable solutions, contact us at +1.844.4AVIENT (1-844.428.4368) www.avient.com



Copyright © 2020, Avient Corporation. Avient makes no representations, guarantees, or warranties of any kind with respect to the information contained in this document about its accuracy, suitability for particular applications, or the results obtained or obtainable using the information. Some of the information arises from laboratory work with small-scale equipment which may not provide a reliable indication of performance or properties obtained or obtainable on larger-scale equipment. Values reported as "typical" or stated without a range do not state minimum or maximum properties; consult your sales representative for property ranges and min/max specifications. Processing conditions can cause material properties to shift from the values stated in the information. Avient makes no warranties or guarantees respecting suitability of either Avient's products or the information for your process or end-use application. You have the responsibility to conduct full-scale end-product performance testing to determine suitability in your application, and you assume all risk and liability arising from your use of the information and/or use or handling of any product. AVIENT MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, either with respect to the information or products reflected by the information. This literature shall NOT operate as permission, recommendation, or inducement to practice any patented invention without permission of the patent owner.