PROCESSING GUIDE

ECCOH™ LSFOH

LOW SMOKE AND FUME, NON-HALOGEN

AVIENT™

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)
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