

AVALON® 65 AE

Thermoplastic Polyurethane Elastomer (Polyester)

Huntsman Corporation

Message:

AVALON 65 AE is a general purpose polyester based thermoplastic polyurethane for injection moulding.

AVALON 65 AE is part of the AVALON Soft Range and offers a premium soling material for casual, sport and protective footwear.

The features offered include:

Durability

Excellent surface definition

Abrasion resistance

Slip resistance

General Information			
Features	Good wear resistance Durability General Excellent appearance		
Uses	Sporting goods Footwear		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.18	g/cm ³	ISO 2781
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	65		ISO 868
Mechanical	Nominal Value	Unit	Test Method
Ross Flex ¹ (-10°C)	2.5E+5	Cycles	
Abrasion Resistance		mm ³	ISO 4649
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ISO 37
100% strain	2.50	MPa	ISO 37
300% strain	4.00	MPa	ISO 37
Tensile Stress (Break)	20.0	MPa	ISO 37
Tensile Elongation (Break)	700	%	ISO 37
Tear Strength ²	50	kN/m	ISO 34-1
Compression Set (23°C)	20	%	ISO 815
Additional Information			
Test plates conditioned 20 hours at 100°C before testing			
Injection	Nominal Value	Unit	
Drying Temperature - Desiccant Dryer	80.0 - 90.0	°C	

Drying Time - Desiccant Dryer	2.0	hr
Hopper Temperature	25.0 - 35.0	°C
Rear Temperature	175 - 185	°C
Middle Temperature	180 - 190	°C
Front Temperature	185 - 195	°C
Nozzle Temperature	180 - 190	°C
Mold Temperature	25.0 - 50.0	°C
Injection Pressure	2.00 - 10.0	MPa
Injection Rate	Slow	
Holding Pressure	1.00 - 5.00	MPa
Back Pressure	0.0300 - 0.300	MPa
Screw Speed	20 - 80	rpm
Screw L/D Ratio	20.0:1.0 to 25.0:1.0	
Screw Compression Ratio	2.0 : 1.0 - 3.0 : 1.0	

Injection instructions

Typical Screw Diameter : 40 - 120 mm³ Stage Design
 Feed Zone : 0.4L
 Compression Zone : 0.3L
 Metering Zone : 0.3L

NOTE

1. BS 5131
2. Method B, right-angle specimen (without cut)

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