

IROGRAN® A 92 H 4656

Thermoplastic Polyurethane Elastomer (Polyester)

Huntsman Corporation

Message:

IROGRAN A 92 H 4656 is a thermoplastic polyester-polyurethane for injection moulding applications.

Additional characteristics of the product are short cycle times, good melt flow and easy demolding.

PERFORMANCE FEATURES

Good melt flow

Easy demolding

Short cycle times

Easy coloring

recyclable

APPLICATIONS

For the production of technical parts, wheels and rollers, cover plates, coupling halves, conveyor rollers.

General Information			
Features	Fast Molding Cycle		
	Good Colorability		
	Good Flow		
	Good Mold Release		
	Recyclable Material		
Uses	Conveyor Parts		
	Engineering Parts		
	Rollers		
	Wheels		
RoHS Compliance	Contact Manufacturer		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	
Molding Shrinkage			
Flow : Injection Molded	0.60	%	ASTM D955
-- ¹	0.40	%	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			
Shore A, Injection Molded	85		ASTM D2240
Shore D, Injection Molded	34		ASTM D2240
Shore A, Injection Molded	92		ISO 868
Shore D, Injection Molded	40		ISO 868
Mechanical	Nominal Value	Unit	Test Method
Abrasion ²	30	mm ³	ISO 4649

Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ³			
100% Strain	4.90	MPa	ASTM D412
100% Strain	9.00	MPa	DIN 53504
300% Strain	11.0	MPa	ASTM D412
300% Strain	21.0	MPa	DIN 53504
Tensile Strength ⁴			
Break	36.0	MPa	ASTM D412
Break	45.0	MPa	DIN 53504
Tensile Elongation ⁵			
Break	750	%	ASTM D412
Break	550	%	DIN 53504
Tear Strength ⁶			
--	99.8	kN/m	ASTM D624
--	120	kN/m	ISO 34-1
Compression Set ⁷			
23°C, 24 hr	25	%	ASTM D395, ISO 815
70°C, 24 hr	40	%	ASTM D395
73°C, 24 hr	40	%	ISO 815
Injection	Nominal Value	Unit	
Drying Temperature			
--	100 to 110	°C	
Hot Air Dryer	80.0 to 90.0	°C	
Drying Time			
--	3.0	hr	
Hot Air Dryer	3.0	hr	
Dew Point	-30.0	°C	
Rear Temperature	175 to 195	°C	
Middle Temperature	175 to 195	°C	
Front Temperature	175 to 195	°C	
Nozzle Temperature	180 to 200	°C	
Processing (Melt) Temp	170 to 195	°C	
Mold Temperature	20.0 to 70.0	°C	
Extrusion	Nominal Value	Unit	
Drying Temperature	100 to 110	°C	
Drying Time	3.0	hr	
Hopper Temperature	25.0 to 40.0	°C	
Cylinder Zone 1 Temp.	165 to 190	°C	
Cylinder Zone 2 Temp.	165 to 190	°C	
Cylinder Zone 3 Temp.	165 to 190	°C	
Cylinder Zone 4 Temp.	165 to 190	°C	
Cylinder Zone 5 Temp.	165 to 190	°C	

Adapter Temperature	175 to 195	°C
Die Temperature	175 to 200	°C

NOTE

1.	Injection Molded
2.	Injection Molded
3.	Injection Molded
4.	Injection Molded
5.	Injection Molded
6.	Injection Molded
7.	Injection Molded

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