

IROGRAN® A 85 D 4968

Thermoplastic Polyurethane Elastomer (Polyester)

Huntsman Corporation

Message:

IROGRAN A 85 D 4968 is a polyester based thermoplastic polyurethane intended for extrusion applications and injection moulding.

IROGRAN A 85 D 4968 is part of the HUNTSMAN technical extrusion product range and offers a specially designed, flexible material with a broad processing window particularly suitable in flat die, cast die extrusion processes.

PERFORMANCE FEATURES

Excellent wear performance

Good processability

Good melt flow

High elasticity

General Information			
Features	Good Flexibility		
	Good Flow		
	Good Processability		
	Good Wear Resistance		
	High Elasticity		
Forms	Pellets		
Processing Method	Extrusion		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity ¹	1.20	g/cm ³	ASTM D792, DIN 53479
Melt Volume-Flow Rate (MVR) (190°C/21.6 kg)	28.0	cm ³ /10min	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240, DIN 53505
Shore A, Injection Molded	86		
Shore D, Injection Molded	35		
Mechanical	Nominal Value	Unit	Test Method
Abrasion ²			
--	25	mm ³	DIN 53516
--	34	mm ³	ASTM D395
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ³			
100% Strain	6.21	MPa	ASTM D412
100% Strain	5.00	MPa	DIN 53504
300% Strain	14.5	MPa	ASTM D412
300% Strain	15.0	MPa	DIN 53504
Tensile Strength ⁴			

Break	36.5	MPa	ASTM D412
Break	49.0	MPa	DIN 53504
Tensile Elongation ⁵			
Break	650	%	ASTM D412
Break	620	%	DIN 53504
Tear Strength ⁶			
--	105	kN/m	ASTM D624
--	85	kN/m	ISO 34-1
Bayshore Resilience ⁷	38	%	ASTM D2632
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	
Hopper Temperature	25.0 to 45.0	°C	
Rear Temperature	190 to 210	°C	
Middle Temperature	190 to 210	°C	
Front Temperature	190 to 210	°C	
Nozzle Temperature	185 to 210	°C	
Mold Temperature	20.0 to 50.0	°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.	180 to 205	°C	
Cylinder Zone 2 Temp.	180 to 205	°C	
Cylinder Zone 3 Temp.	180 to 205	°C	
Cylinder Zone 4 Temp.	180 to 205	°C	
Cylinder Zone 5 Temp.	180 to 205	°C	
Adapter Temperature	180 to 205	°C	
Die Temperature	185 to 205	°C	
NOTE			
1.	Injection Molded		
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5.	Injection Molded		
6.	Injection Molded		
7.	Injection Molded		

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