

Estane® 58206 TPU

Thermoplastic Polyurethane Elastomer (Polyester)

Lubrizol Advanced Materials, Inc.

Message:

Type: Estane® 58206 is an 85A aromatic Polyester-Based Thermoplastic Polyurethane (TPU).
Features: Good Flexibility at Low Temperatures and Improved Weathering Performance.
Uses: Flat Die/Cast Film Extrusion and Hose/Profile Extrusion, Injection Molding.

General Information	
Features	Flexibility at low temperatures
	Aroma
	Good weather resistance
Uses	Blown Film
	Pipe
	cast film
	Profile
RoHS Compliance	RoHS compliance
Forms	Particle
Processing Method	Extrusion
	cast film
	Profile extrusion molding
	Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Molding Shrinkage - Across Flow	1.4	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 5 sec)	82 - 88		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Taber Abrasion Resistance (1000 Cycles, 1000 g, H-18 Wheel)	20.0	mg	ASTM D3389
Elastomers	Nominal Value	Unit	Test Method
Tensile Set (200% Strain)	10	%	ASTM D412
Tensile Stress			ASTM D412
100% strain, 0.762mm	5.50	MPa	ASTM D412
300% strain, 0.762mm	10.4	MPa	ASTM D412
Tensile Strength (Break, 0.762 mm)	48.3	MPa	ASTM D412
Tensile Elongation (Break, 0.762 mm)	550	%	ASTM D412
Tear Strength			

0.762 mm ¹	88.3	kN/m	ASTM D624
Cracking	23	kN/m	ASTM D470
Aging	Nominal Value	Unit	Test Method
Change in Volume (in Jet Fuel JP8)	7.7	%	ASTM D471
Thermal	Nominal Value	Unit	Test Method
Glass Transition Temperature	-32.0	°C	DSC
Melting Temperature	160	°C	DSC
Kofler Melting Temperature	155	°C	Internal method
Injection	Nominal Value	Unit	
Drying Temperature	104	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	177	°C	
Middle Temperature	188	°C	
Front Temperature	193	°C	
Nozzle Temperature	199	°C	
Processing (Melt) Temp	199	°C	
Injection Pressure	21.0 - 48.0	MPa	
Injection Rate	Slow-Moderate		
Holding Pressure	14.0 - 28.0	MPa	
Back Pressure	0.345	MPa	
Screw Speed	20 - 50	rpm	
Injection instructions			
Air Dew Point: -40°C			
Extrusion	Nominal Value	Unit	
Drying Temperature	104	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.020	%	
Cylinder Zone 1 Temp.	177	°C	
Cylinder Zone 2 Temp.	183	°C	
Cylinder Zone 3 Temp.	188	°C	
Cylinder Zone 4 Temp.	194	°C	
Adapter Temperature	194	°C	
Melt Temperature	191	°C	
Die Temperature	194	°C	
Extrusion instructions			
Dew Point: -40°C Screen Pack Recommendation: 20/40/80			
NOTE			
1.	C mould		

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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