

Wanthane® WHT-1164IC

Thermoplastic Polyurethane Elastomer (Polyester)

Wanhua Chemical Group Co., Ltd.

Message:

TYPE: Polyester-based grade Extrusion and injection molding grade
FEATURES: Excellent mechanical properties, high abrasion resistance, good wear resistance, short cycle times
Applications: Shoe heels, Injection-molded engineering components, wire & cable, etc

General Information			
Features	Fast molding cycle		
	Good wear resistance		
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Uses	Wire and cable applications		
	Engineering accessories		
	Footwear		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	64		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
DIN Abrasion	45.0	mm ³	ISO 4649
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
100% strain	26.0	MPa	ASTM D412
300% strain	40.0	MPa	ASTM D412
Tensile Strength (Break)	45.0	MPa	ASTM D412
Tensile Elongation (Break)	340	%	ASTM D412
Tear Strength	225	kN/m	ASTM D624
Compression Set			ASTM D395
23°C, 24 hr	25	%	ASTM D395
70°C, 22 hr	68	%	ASTM D395
Thermal	Nominal Value	Unit	Test Method
Glass Transition Temperature	-9.00	°C	ASTM D3418
Vicat Softening Temperature	120	°C	ASTM D1525
Injection	Nominal Value	Unit	

Drying Temperature	100 - 110	°C
Drying Time	2.0 - 3.0	hr
Suggested Max Moisture	0.030	%
Rear Temperature	205	°C
Middle Temperature	210	°C
Front Temperature	215	°C
Nozzle Temperature	220	°C
Mold Temperature	23	°C
Screw L/D Ratio	25.0:1.0 to 30.0:1.0	
Screw Compression Ratio	2.0 : 1.0 - 3.0 : 1.0	

Extrusion	Nominal Value	Unit
Drying Temperature	100 - 110	°C
Drying Time	2.0 - 3.0	hr
Suggested Max Moisture	0.030	%
Cylinder Zone 1 Temp.	185	°C
Cylinder Zone 2 Temp.	190	°C
Cylinder Zone 3 Temp.	195	°C
Cylinder Zone 4 Temp.	200	°C
Adapter Temperature	205	°C
Die Temperature	195 - 200	°C

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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

