

AVALON® 60 DE

Thermoplastic Polyurethane Elastomer (Polyester)

Huntsman Corporation

Message:

AVALON 60 DE is a high performance polyester based thermoplastic polyurethane for injection moulding.
AVALON 60 DE is part of the AVALON Perform Range and offers a premium soling material for sports footwear and top-pieces.
The features offered include:
Durability
Excellent surface definition
Abrasion resistance
Flex resistance
Phthalate free TPU

General Information			
Features	Good wear resistance		
	Durability		
	Excellent appearance		
Uses	Sporting goods		
	Footwear		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.25	g/cm ³	ISO 2781
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	60		ISO 868
Mechanical	Nominal Value	Unit	Test Method
Abrasion Resistance	40.0	mm ³	ISO 4649
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ISO 37
100% strain	17.0	MPa	ISO 37
300% strain	27.0	MPa	ISO 37
Tensile Stress (Break)	42.0	MPa	ISO 37
Tensile Elongation (Break)	350	%	ISO 37
Tear Strength ¹	190	kN/m	ISO 34-1
Compression Set (23°C)	25	%	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	190 - 210	°C
Middle Temperature	195 - 215	°C
Front Temperature	200 - 220	°C
Nozzle Temperature	195 - 210	°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. Method B, right-angle specimen
(without cut)

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