

Estaloc® 60204 RETPU

Thermoplastic Polyurethane Elastomer (Polyester)

Lubrizol Advanced Materials, Inc.

Message:

Type: Estaloc® 60204 Alloy is a Polyester-Type Reinforced Engineered Thermoplastic Polyurethane (RETPU).
Features: Fast Cycling, Dimensional Stability, Durability, Aesthetics, Low Temperature Impact
Uses: Injection Molding

General Information			
Filler / Reinforcement	Filler		
Features	Good dimensional stability		
	Fast molding cycle		
	Low temperature impact resistance		
	Durability		
	Excellent appearance		
RoHS Compliance	RoHS compliance		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.31	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow ¹	0.060	%	ASTM D955
Flow ²	0.30	%	ASTM D955
Transverse flow ³	0.30	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D, 5 sec)	71 - 77		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (0.762 mm)	1900	MPa	ASTM D638
Tensile Strength (0.762 mm)	32.0	MPa	ASTM D638
Tensile Elongation (Break, 0.762 mm)	39	%	ASTM D638
Flexural Modulus (0.762 mm)	1380	MPa	ASTM D790
Flexural Strength (0.762 mm)	41.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C, 0.762 mm	37	J/m	ASTM D256
23°C, 0.762 mm	210	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	73.0	°C	ASTM D648
1.8 MPa, not annealed	50.0	°C	ASTM D648

Injection	Nominal Value	Unit
Drying Temperature	104	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	199	°C
Middle Temperature	210	°C
Front Temperature	221	°C
Nozzle Temperature	227	°C
Processing (Melt) Temp	227	°C
Injection Pressure	69.0 - 103	MPa
Injection Rate	Slow-Moderate	
Holding Pressure	35.0 - 69.0	MPa
Back Pressure	0.345	MPa
Screw Speed	30 - 80	rpm

Injection instructions

Air Dew Point: -40°C

NOTE

1. Flex Bar
2. Disc
3. Disc

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Recommended distributors for this material

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