

IROGRAN® A 94 E 4900

Thermoplastic Polyurethane Elastomer (Polyester)

Huntsman Corporation

Message:

IROGRAN A 94 E 4900 is a thermoplastic polyester polyurethane for melt calendering.

IROGRAN is part of the HUNTSMAN technical extrusion/injection molding product range and offers a specially designed, flexible material with a broad processing window.

PERFORMANCE FEATURES

High oil resistance

High production rate

Good melt flow

Easy coloring

APPLICATIONS

Calendering

Technical molding

General Information			
Features	Good Colorability		
	Good Flexibility		
	Good Flow		
	Oil Resistant		
	Soft		
Forms	Pellets		
Processing Method	Calendering		
	Extrusion		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity ¹	1.22	g/cm ³	ASTM D792, DIN 53479
Melt Volume-Flow Rate (MVR) (190°C/21.6 kg)	60.0	cm ³ /10min	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240, DIN 53505
Shore A, Injection Molded	94		
Shore D, Injection Molded	44		
Mechanical	Nominal Value	Unit	Test Method
Abrasion ²			
--	33	mm ³	DIN 53516
--	33	mm ³	ASTM D395
TMA ³			Internal Method
High : 635.0 µm	221	°C	
Low : 635.0 µm	158	°C	
Calendar Temperature Profile ⁴			

Front Roll (29rpm)	168	°C	
Rear Roll (25rpm)	168	°C	
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ⁵			DIN 53504
100% Strain	11.0	MPa	
300% Strain	17.0	MPa	
Tensile Stress ⁶ (Break)	38.0	MPa	DIN 53504
Tensile Elongation ⁷ (Break)	550	%	DIN 53504
Tear Strength ⁸	100	kN/m	ISO 34-1
Extrusion	Nominal Value	Unit	
Drying Temperature	85.0 to 90.0	°C	
Drying Time	3.0	hr	
Cylinder Zone 1 Temp.	170	°C	
Cylinder Zone 2 Temp.	170	°C	
Cylinder Zone 3 Temp.	170	°C	
Cylinder Zone 4 Temp.	170	°C	
Cylinder Zone 5 Temp.	170	°C	
Adapter Temperature	180	°C	
Die Temperature	180	°C	
NOTE			
1.	Injection Molded		
2.	Injection Molded		
3.	Extruded Film		
4.	2 Roll Mill		
5.	Injection Molded		
6.	Injection Molded		
7.	Injection Molded		
8.	Injection Molded		

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