

IROGRAN® A 80 P 4699 L

Thermoplastic Polyurethane Elastomer (Polyether)

Huntsman Corporation

Message:

IROGRAN A 80 P 4699 L is a high performance polyether based thermoplastic polyurethane intended for extrusion and injection mold applications. IROGRAN A 80 P 4699 L is part of the HUNTSMAN extrusion / injection mold product range.

PERFORMANCE FEATURES

Good melt flow
Low adhesion surface
High flexibility
Good processability
Soft

General Information			
Features	Good Flexibility Good Flow Good Processability Soft		
Forms	Pellets		
Processing Method	Extrusion Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity ¹	1.09	g/cm ³	ASTM D792
Melt Volume-Flow Rate (MVR) (190°C/21.6 kg)	140	cm ³ /10min	
Molding Shrinkage - Flow (Injection Molded)	11	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, Injection Molded)	81		ASTM D2240, DIN 53505
Mechanical	Nominal Value	Unit	Test Method
Abrasion ²			
--	54	mm ³	
--	50	mm ³	DIN 53515
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ³			
100% Strain, 0.635 mm	5.93	MPa	ASTM D412
100% Strain, 0.635 mm	5.70	MPa	DIN 53504
300% Strain, 0.635 mm	8.27	MPa	ASTM D412
300% Strain, 0.635 mm	8.40	MPa	DIN 53504
Tensile Strength ⁴			

Break, 0.635 mm	21.0	MPa	ASTM D412
Break, 0.635 mm	30.0	MPa	DIN 53504
Tensile Elongation ⁵			
Break, 0.635 mm	810	%	ASTM D412
Break, 0.635 mm	750	%	DIN 53504
Tear Strength ⁶			
0.635 mm	89.3	kN/m	ASTM D624
0.635 mm	45	kN/m	DIN 53515
Compression Set ⁷			
23°C, 22 hr	24	%	ASTM D395, DIN 53517
70°C, 22 hr	46	%	
Thermal	Nominal Value	Unit	Test Method
Melting Temperature ⁸	126 to 150	°C	TMA
Extrusion	Nominal Value	Unit	
Drying Temperature	85.0 to 90.0	°C	
Drying Time	4.0	hr	
Hopper Temperature	175	°C	
Cylinder Zone 1 Temp.	180	°C	
Cylinder Zone 2 Temp.	180	°C	
Cylinder Zone 3 Temp.	180	°C	
Cylinder Zone 4 Temp.	180	°C	
Cylinder Zone 5 Temp.	180	°C	
Adapter Temperature	180	°C	
Die Temperature	175	°C	
NOTE			
1.	Injection Molded		
2.	Injection Molded		
3.	Extruded Film		
4.	Extruded Film		
5.	Extruded Film		
6.	Extruded Film		
7.	Injection Molded		
8.	Extruded Film, 0.025 in		

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