## Quadraflex<sup>™</sup> ARE-72D

## Thermoplastic Polyurethane Elastomer (Polyether)

**Biomerics**, LLC

## Message:

Quadraflex<sup>™</sup> ARE-72D is high performance aromatic polyether thermoplastic polyurethane. The polymer is naturally clear and supplied in small pellets for ease of processing. The material exhibits excellent mechanical properties, oxidative stability, biocompatibility, elasticity, chemical resistance, high resliency and softening at body temperature. The resin has consistent melt flow properties making it ideal for extrusion.

Quadrathane<sup>™</sup>, Quadraflex<sup>™</sup>, Quadraban<sup>™</sup> and Quadraplast<sup>™</sup> performance polymers are primarily used in life science and medical applications including vascular access devices, surgical supplies, respiratory devices, tracheotomy devices, and other medical applications. Typical end products include tubing, catheter parts, balloons, and various medical device components. These performance polymers are available in a variety of durometers, radiopacifiers, colors, and custom formulations.

General Information			
Features	Aroma		
	High elasticity		
	Antioxidation		
	Workability, good		
	Good liquidity		
	Good chemical resistance		
	Biocompatibility		
	Elastic		
Uses	Pipe fittings		
	Surgical instruments		
	Medical/nursing supplies		
Appearance	Clear/transparent		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.18	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 - 0.80	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	72		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
100% strain	25.5	MPa	ASTM D412
300% strain	41.4	MPa	ASTM D412

Tanaila Strongth (Braak)		MDa		
Tensile Strength (Break)	55.2	МРа	ASTM D412	
Tensile Elongation (Break)	300	%	ASTM D412	
Thermoset	Nominal Value	Unit		
Post Cure Time (38°C)	6.0 - 10	hr		
Injection	Nominal Value	Unit		
Drying Temperature	54.4	°C		
Drying Time	4.0	hr		
Suggested Max Moisture	< 3.0E-3	%		
Rear Temperature	177	°C		
Front Temperature	191	°C		
Nozzle Temperature	196	°C		
Processing (Melt) Temp	204	°C		
Mold Temperature	4.44 - 32.2	°C		
Injection Rate	Slow			
Screw Compression Ratio	2.5:1.0 - 3.5:1.0			
Injection instructions				
Injection Speed: 10 g/secCooling/Hold TIme:	Long, at least 50% of cycle (20 to 60 se	ecs depending on thickness)		
Extrusion	Nominal Value	Linit		
		Onit		
Drying Temperature	54.4	°C		
Drying Temperature Drying Time	54.4 4.0	°C hr		
Drying Time Suggested Max Moisture	54.4 4.0 < 0.030	°C hr %		
Drying Temperature Drying Time Suggested Max Moisture Cylinder Zone 1 Temp.	54.4 4.0 < 0.030 171	°C hr %		
Drying Temperature Drying Time Suggested Max Moisture Cylinder Zone 1 Temp. Cylinder Zone 2 Temp.	54.4 4.0 < 0.030 171 182	°C hr °C °C		
Drying Temperature Drying Time Suggested Max Moisture Cylinder Zone 1 Temp. Cylinder Zone 2 Temp. Cylinder Zone 3 Temp.	54.4 4.0 < 0.030 171 182 188	°C /// *********************************		
Drying Temperature Drying Time Suggested Max Moisture Cylinder Zone 1 Temp. Cylinder Zone 2 Temp. Cylinder Zone 3 Temp. Cylinder Zone 4 Temp.	54.4         4.0         < 0.030	°C       hr       %       °C       °C       °C       °C		
Drying Temperature Drying Time Suggested Max Moisture Cylinder Zone 1 Temp. Cylinder Zone 2 Temp. Cylinder Zone 3 Temp. Cylinder Zone 4 Temp. Melt Temperature	54.4         4.0         < 0.030	°C °C °C °C °C °C °C °C °C		
Drying Temperature Drying Time Suggested Max Moisture Cylinder Zone 1 Temp. Cylinder Zone 2 Temp. Cylinder Zone 3 Temp. Cylinder Zone 4 Temp. Melt Temperature Die Temperature	54.4         4.0         < 0.030	°C °C °C °C °C °C °C °C °C °C		
Drying Temperature Drying Time Suggested Max Moisture Cylinder Zone 1 Temp. Cylinder Zone 2 Temp. Cylinder Zone 3 Temp. Cylinder Zone 4 Temp. Melt Temperature Die Temperature Back Pressure	54.4         4.0         < 0.030	°C       hr       %       °C       °C       °C       °C       °C       °C       MPa		

Screen Pack: 250 meshScrew Speed: Low sheer, 150 to 250 rpmWater Bath: 80 to 110°F

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