

AVALON® 85 AE

Thermoplastic Polyurethane Elastomer (Polyester)

Huntsman Corporation

Message:

AVALON 85 AE is a high performance polyester based thermoplastic polyurethane for injection moulding. AVALON 85 AE is part of the AVALON Perform Range and offers a premium soling material for kipper soles. 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	Footwear		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.22	g/cm ³	ISO 2781
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ISO 868
Shaw A	85		ISO 868
Shaw D	37		ISO 868
Mechanical	Nominal Value	Unit	Test Method
Ross Flex ¹ (-10°C)	2.5E+5	Cycles	
Abrasion Resistance	35.0	mm ³	ISO 4649
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ISO 37
100% strain	6.00	MPa	ISO 37
300% strain	10.0	MPa	ISO 37
Tensile Stress (Break)	28.0	MPa	ISO 37
Tensile Elongation (Break)	500	%	ISO 37
Tear Strength ²	90	kN/m	ISO 34-1
Compression Set (23°C)	20	%	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	185 - 195	°C
Middle Temperature	190 - 200	°C
Front Temperature	195 - 205	°C
Nozzle Temperature	180 - 190	°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. BS 5131
2. Method B, right-angle specimen
(without cut)

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