

Generic TPU-PC

Thermoplastic Polyurethane Elastomer (PC Based)

Generic

Message:

This data represents typical values that have been calculated from all products classified as: Generic TPU-PC
This information is provided for comparative purposes only.

General Information			
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.15 - 1.25	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	6.0 - 7.5	g/10 min	ASTM D1238
Molding Shrinkage - Flow (23°C)	0.80 - 0.90	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (23°C)	55 - 95		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (23°C)	2.93 - 45.5	MPa	ASTM D638
Tensile Stress (23°C)	4.85 - 37.9	MPa	ASTM D1708
Tensile Elongation (Break, 23°C)	500 - 600	%	ASTM D638
Flexural Modulus (23°C)	4.14 - 552	MPa	ASTM D790
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
100% strain, 23°C	3.45 - 24.6	MPa	ASTM D412
300% strain, 23°C	8.27 - 31.7	MPa	ASTM D412
Tensile Strength (Break, 23°C)	33.8 - 51.7	MPa	ASTM D412
Tensile Elongation (Break, 23°C)	350 - 490	%	ASTM D412
Thermoset	Nominal Value	Unit	
Post Cure Time	8.0	hr	
Injection	Nominal Value	Unit	
Drying Temperature	54.4 - 82.2	°C	
Drying Time	3.5 - 4.0	hr	
Suggested Max Moisture	3.0E-3 - 0.050	%	
Injection instructions			

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Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	171	°C
Cylinder Zone 2 Temp.	182	°C
Cylinder Zone 3 Temp.	187 - 188	°C
Cylinder Zone 4 Temp.	193	°C
Melt Temperature	193 - 199	°C

Die Temperature	204	°C
Back Pressure	9.65 - 9.67	MPa
Extrusion instructions		

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