

# AVALON® 98 AB

Thermoplastic Polyurethane Elastomer (Polyester)

Huntsman Corporation

## Message:

AVALON 98 AB is a high performance polyester based thermoplastic polyurethane for injection moulding.  
AVALON 98 AB is part of the AVALON Perform Range and offers a premium soling material for sports footwear and top-pieces.  
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	Sporting goods		
	Footwear		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.23	g/cm <sup>3</sup>	ISO 2781
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ISO 868
Shaw A	98		ISO 868
Shaw D	56		ISO 868
Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus (23°C)	135	MPa	ISO 178
Ross Flex <sup>1</sup> (-10°C)	2.5E+5	Cycles	
Abrasion Resistance	35.0	mm <sup>3</sup>	ISO 4649
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ISO 37
100% strain	17.0	MPa	ISO 37
300% strain	29.0	MPa	ISO 37
Tensile Stress (Break)	40.0	MPa	ISO 37
Tensile Elongation (Break)	400	%	ISO 37
Tear Strength <sup>2</sup>	170	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	200 - 210	°C
Middle Temperature	205 - 215	°C
Front Temperature	210 - 220	°C
Nozzle Temperature	200 - 210	°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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#### Recommended distributors for this material

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