

# IROGRAN® A 75 P 4655 N

Thermoplastic Polyurethane Elastomer (Polyether)

Huntsman Corporation

## Message:

IROGRAN A 75 P 4655 N is a black colored polyether based thermoplastic polyurethane intended for injection moulding applications.

IROGRAN A 75 P 4655 N is a part of the HUNTSMAN injection moulding product range. It is processable at low temperatures and offers a specially designed, flexible material suitable for mouldings.

### PERFORMANCE FEATURES

Excellent ambient & low temperature flexibility

Short cycle times

Phthalate free

Good melt flow

Easy demoulding

Excellent hydrolysis & microbial resistance

General Information			
Additive	Plasticizer		
Features	Fast Molding Cycle		
	Good Flexibility		
	Good Flow		
	Good Mold Release		
	Hydrolysis Resistant		
	Low Temperature Flexibility		
	Microbe Resistant		
	Non-Phthalate Plasticizer		
Appearance	Black		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity <sup>1</sup>	1.12	g/cm <sup>3</sup>	ASTM D792
Melt Volume-Flow Rate (MVR) (190°C/10.0 kg)	50.0	cm <sup>3</sup> /10min	
Molding Shrinkage - Flow (Injection Molded)	0.80	%	Internal Method
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240, DIN 53505
Shore A, Injection Molded	73		
Shore D, Injection Molded	23		
Mechanical	Nominal Value	Unit	Test Method
Abrasion <sup>2</sup>	60	mm <sup>3</sup>	DIN 53516
TMA <sup>3</sup>			Internal Method
High : 635.0 µm	155	°C	
Low : 635.0 µm	122	°C	

Elastomers	Nominal Value	Unit	Test Method
Tensile Stress <sup>4</sup>			DIN 53504
100% Strain, 0.635 mm	5.80	MPa	
300% Strain, 0.635 mm	9.00	MPa	
Tensile Stress <sup>5</sup> (Break, 0.635 mm)	30.0	MPa	DIN 53504
Tensile Elongation <sup>6</sup> (Break, 0.635 mm)	820	%	DIN 53504
Tear Strength <sup>7</sup> (0.635 mm)	45	kN/m	DIN 53515
Compression Set <sup>8</sup>			ASTM D395, DIN 53517
23°C, 24 hr	23	%	
70°C, 24 hr	39	%	

Injection	Nominal Value	Unit
Drying Temperature		
--	100 to 110	°C
Hot Air Dryer	80.0 to 90.0	°C
Drying Time		
--	3.0	hr
Hot Air Dryer	3.0	hr
Rear Temperature	185	°C
Middle Temperature	185	°C
Front Temperature	185	°C
Nozzle Temperature	185	°C

NOTE	
1.	Injection Molded
2.	Injection Molded
3.	Extruded Film
4.	Extruded Film
5.	Extruded Film
6.	Extruded Film
7.	Extruded Film
8.	Injection Molded

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### Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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