

IROGRAN® A 87 H 4615

Thermoplastic Polyurethane Elastomer (Polyester)

Huntsman Corporation

Message:

IROGRAN A 87 H 4615 is a thermoplastic polyester-polyurethane for injection moulding applications.

Additional characteristics of the product are very short cycle times and high dimensional stability.

PERFORMANCE FEATURES

Easy demolding

Good melt flow

High wear resistance

High elasticity

Dynamically highly loadable

APPLICATIONS

For the production of mining screens, coupling halves, technical parts, cylinders, buffers.

General Information			
Features	Fast Molding Cycle		
	Good Dimensional Stability		
	Good Flow		
	Good Mold Release		
	Good Wear Resistance		
	High Elasticity		
Uses	Engineering Parts		
	Mining Applications		
RoHS Compliance	Contact Manufacturer		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity ¹	1.20	g/cm ³	
Melt Volume-Flow Rate (MVR) (190°C/21.6 kg)	50.0	cm ³ /10min	
Molding Shrinkage			
Flow : Injection Molded	0.80	%	ASTM D955
-- ²	0.50	%	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			
Shore A, Injection Molded	80		ASTM D2240
Shore D, Injection Molded	30		ASTM D2240
Shore A, Injection Molded	85		ISO 868
Shore D, Injection Molded	35		ISO 868
Mechanical	Nominal Value	Unit	Test Method

Abrasion ³	25	mm ³	ISO 4649
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ⁴			
100% Strain	4.48	MPa	ASTM D412
100% Strain	6.00	MPa	DIN 53504
300% Strain	10.6	MPa	ASTM D412
300% Strain	14.0	MPa	DIN 53504
Tensile Strength ⁵			
Break	38.6	MPa	ASTM D412
Break	45.0	MPa	DIN 53504
Tensile Elongation ⁶			
Break	650	%	ASTM D412
Break	640	%	DIN 53504
Tear Strength ⁷			
--	89.3	kN/m	ASTM D624
--	80	kN/m	ISO 34-1
Compression Set ⁸			
23°C, 24 hr	25	%	ASTM D395, ISO 815
70°C, 24 hr	38	%	ASTM D395
70°C, 24 hr	40	%	ISO 815
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	
Dew Point	-30.0	°C	
Rear Temperature	175 to 195	°C	
Middle Temperature	175 to 195	°C	
Front Temperature	175 to 195	°C	
Nozzle Temperature	180 to 200	°C	
Processing (Melt) Temp	170 to 195	°C	
Mold Temperature	20.0 to 70.0	°C	
Extrusion	Nominal Value	Unit	
Drying Temperature	100 to 110	°C	
Drying Time	3.0	hr	
Hopper Temperature	25.0 to 40.0	°C	
Cylinder Zone 1 Temp.	165 to 190	°C	
Cylinder Zone 2 Temp.	165 to 190	°C	
Cylinder Zone 3 Temp.	165 to 190	°C	
Cylinder Zone 4 Temp.	165 to 190	°C	

Cylinder Zone 5 Temp.	165 to 190	°C
Adapter Temperature	175 to 195	°C
Die Temperature	175 to 200	°C

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

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