

# IROGRAN® A 98 E 4066

Thermoplastic Polyurethane Elastomer (Polyester)

Huntsman Corporation

Message:

IROGRAN A 98 E 4066 is a thermoplastic polyester-polyurethane for injection molding applications. Additional characteristics of the product are very short cycle times and high dimensional stability.

PERFORMANCE FEATURES

- Short cycle times
- High demolding stability
- High production rates
- High wear resistance
- High hydrolysis resistance

APPLICATIONS

For the production of technical parts, wheels and rollers, coupling halves, sprocket wheels, buffers.

General Information			
Features	Fast Molding Cycle		
	Good Dimensional Stability		
	Good Mold Release		
	Good Wear Resistance		
	Warp Resistant		
Uses	Engineering Parts		
	Rollers		
	Wheels		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity <sup>1</sup>	1.22	g/cm <sup>3</sup>	
Melt Volume-Flow Rate (MVR) (190°C/21.6 kg)	15.0	cm <sup>3</sup> /10min	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			
Shore A, Injection Molded	97		ASTM D2240, ISO 868
Shore D, Injection Molded	49		ASTM D2240
Shore D, Injection Molded	59		ISO 868
Mechanical	Nominal Value	Unit	Test Method
Abrasion <sup>2</sup>	30	mm <sup>3</sup>	ISO 4649
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress <sup>3</sup>			DIN 53504
100% Strain	14.0	MPa	
300% Strain	25.0	MPa	

Tensile Stress <sup>4</sup> (Break)	50.0	MPa	DIN 53504
Tensile Elongation <sup>5</sup> (Break)	530	%	DIN 53504
Tear Strength <sup>6</sup>	140	kN/m	ISO 34-1
Compression Set <sup>7</sup>			ASTM D395, ISO 815
23°C, 24 hr	30	%	
70°C, 24 hr	45	%	
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 195	°C	
Cylinder Zone 2 Temp.	165 to 195	°C	
Cylinder Zone 3 Temp.	165 to 195	°C	
Cylinder Zone 4 Temp.	165 to 195	°C	
Cylinder Zone 5 Temp.	165 to 195	°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		

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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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