

ISOTHANE® 8306

Thermoplastic Polyurethane Elastomer

Great Eastern Resins Industrial Co., Ltd. (GRECO)

Message:

ISOTHANE 8306 series products are engineering thermoplastic polyurethane resin. The product can be injection molded and extruded.

General Information			
Appearance	Clear/transparent		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	80		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1470	MPa	ASTM D638
Tensile Strength	68.0	MPa	ASTM D638
Tensile Elongation (Break)	190	%	ASTM D638
Flexural Modulus	2000	MPa	ASTM D790
Flexural Strength	73.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 6.35 mm)	110	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed)	61.0	°C	ASTM D648
Vicat Softening Temperature	77.0	°C	ASTM D1525
Injection	Nominal Value	Unit	
Drying Temperature - Desiccant Dryer	95	°C	
Drying Time - Desiccant Dryer	4.0 - 6.0	hr	
Dew Point - Desiccant Dryer	-40 - -30	°C	
Rear Temperature	190 - 200	°C	
Middle Temperature	205 - 215	°C	
Front Temperature	205 - 215	°C	
Nozzle Temperature	200 - 210	°C	
Processing (Melt) Temp	205 - 215	°C	
Mold Temperature	40 - 50	°C	

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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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