

Wanthane® WHT-1198F

Thermoplastic Polyurethane Elastomer (Polyester)

Wanhua Chemical Group Co., Ltd.

Message:

TYPE: Polyester-based grade Extrusion and injection molding grade
FEATURES: Excellent mechanical properties, high abrasion resistance, wear resistance, short cycle times
Applications: Wire & Cable, tubes, conveyor belt, shoes, seals, screenpacks, engineering parts, etc

General Information			
Features	Fast molding cycle		
	Good wear resistance		
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Uses	Conveyor		
	Wire and cable applications		
	Engineering accessories		
	Pipe fittings		
	Seals		
	Footwear		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A	96		ASTM D2240
Shaw D	57		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
DIN Abrasion	49.0	mm ³	ISO 4649
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
100% strain	19.0	MPa	ASTM D412
300% strain	37.0	MPa	ASTM D412
Tensile Strength (Break)	45.0	MPa	ASTM D412
Tensile Elongation (Break)	380	%	ASTM D412
Tear Strength	180	kN/m	ASTM D624
Compression Set			ASTM D395
23°C, 24 hr	23	%	ASTM D395

70°C, 22 hr	60	%	ASTM D395
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	130	°C	ASTM D1525
Injection	Nominal Value	Unit	
Drying Temperature	100 - 110	°C	
Drying Time	2.0 - 3.0	hr	
Suggested Max Moisture	0.030	%	
Rear Temperature	205	°C	
Middle Temperature	210	°C	
Front Temperature	215	°C	
Nozzle Temperature	220	°C	
Mold Temperature	23	°C	
Screw L/D Ratio	25.0:1.0 to 30.0:1.0		
Screw Compression Ratio	2.0 : 1.0 - 3.0 : 1.0		
Extrusion	Nominal Value	Unit	
Drying Temperature	100 - 110	°C	
Drying Time	2.0 - 3.0	hr	
Suggested Max Moisture	0.030	%	
Cylinder Zone 1 Temp.	180	°C	
Cylinder Zone 2 Temp.	185	°C	
Cylinder Zone 3 Temp.	190	°C	
Cylinder Zone 4 Temp.	195	°C	
Adapter Temperature	200	°C	
Die Temperature	190 - 195	°C	

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