

Product Data Sheet**IROGRAN® A 65 P 4324N**

Polyether-based Thermoplastic Polyurethane

PRODUCT DESCRIPTION

IROGRAN® A 65 P 4324N is a polyether-based Thermoplastic Polyurethane (TPU) for injection molding applications. Key features are phthalate-free, excellent surface definition, excellent wear performance, good low temperature performance and high elasticity.

APPLICATIONS

Thick wall technical parts and thin wall technical parts.

TYPICAL PHYSICAL PROPERTIES

Properties	Key	NORM	Value	Unit
Hardness (after 3 sec.)	M	ISO 7619	71	Shore A
Hardness (after 3 sec.)	M	ISO 7619	22	Shore D
Density	M	ISO 1183-1	1,12	g/cm ³
Tensile strength	M	DIN 53504	30	MPa
Elongation @ break	M	DIN 53504	800	%
Tensile stress @ 100% elongation	M	DIN 53504	3,9	MPa
Tensile stress @ 300% elongation	M	DIN 53504	9,8	MPa
Tear strength	M	ISO 34-1	35	N/mm
Abrasion	M	ISO 4649	60	mm ³
Bayshore rebound resilience	M	ASTM D 2632	58	%
Compression set at 70h @ 23°C	M	ISO 815	25	%
Compression set at 24h @ 70°C	M	ISO 815	48	%
Mold shrinkage	M	ISO 294-4	1,2	%
Softening range low	E	Huntsman TMA	110	°C
Softening range high	E	Huntsman TMA	165	°C

M = Injection molded parts to meet DIN & ASTM requirements. Parts tempered for 20 hrs @ 100 °C prior to testing

E = Extruded film cut to ASTM requirements. Parts at room temperature aged prior to testing.



HEALTH & SAFETY ADVICE

Before undertaking any trials with this product it is essential that all personnel are aware of the necessary precautions that must be taken. These are detailed in the relevant Material Safety Data Sheet (MSDS), which will be provided by Huntsman.

SUPPLY & STORAGE

IROGRAN® A 65 P 4324N is supplied in bags, drums or octabins. Please contact your customer service to confirm this.

IROGRAN® A 65 P 4324N has a minimum expected shelf life of 12 months after shipment date. The product should be stored in a dry and cool place in the manufacturer's original packaging.

MATERIAL PREPARATION

IROGRAN® A 65 P 4324N is supplied pre-dried, however to ensure trouble-free processing it is preferable to dry before use. The recommended drying conditions are:

- 3 hours at 80-90°C in circulating air
- 3 hours at 70-80°C in dehumidified air
- Dew point: -30°C

PHYSICAL FORM

Type: Transparent pellets

PROCESSING PARAMETERS

Melt Volume Rate 190°C / 10kg ISO 1133-1 = 60 cm³/10min

Processing Parameter: Injection Molding

Temperature Profile °C

Feed Zone: 25 - 40

Barrel: 170 - 180

Nozzle: 175 - 185

Mold: 20 - 50

For further information, please contact your nearest sales office: http://www.huntsman.com/PU_customer_service

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