

Product Data Sheet**IROGRAN® A 87 H 4615**

Polyester-based Thermoplastic Polyurethane

PRODUCT DESCRIPTION

IROGRAN® A 87 H 4615 is a polyester-based Thermoplastic Polyurethane (TPU) for injection molding applications. Key features are plasticizer-free, excellent wear performance, resistance to dynamic stress, high elasticity and robust processing.

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	85	Shore A
Hardness (after 3 sec.)	M	ISO 7619	35	Shore D
Density	M	ISO 1183-1	1,20	g/cm ³
Tensile strength	M	DIN 53504	45	MPa
Elongation @ break	M	DIN 53504	640	%
Tensile stress @ 100% elongation	M	DIN 53504	5,6	MPa
Tensile stress @ 300% elongation	M	DIN 53504	11,1	MPa
Tear strength	M	ISO 34-1	80	N/mm
Abrasion	M	ISO 4649	25	mm ³
Bayshore rebound resilience	M	ASTM D 2632	40	%
Compression set at 70h @ 23°C	M	ISO 815	25	%
Compression set at 24h @ 70°C	M	ISO 815	43	%
Mold shrinkage	M	ISO 294-4	1,1	%
Softening range low	E	Huntsman TMA	135	°C
Softening range high	E	Huntsman TMA	185	°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 87 H 4615 is supplied in bags, drums or octabins. Please contact your customer service to confirm this.

IROGRAN® A 87 H 4615 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 87 H 4615 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 / 21,6kg ISO 1133-1 = 50 cm³/10min

Processing Parameter: Injection Molding

Temperature Profile °C

Feed Zone: 25 - 40

Barrel: 175 - 190

Nozzle: 180 - 200

Mold: 20 - 50

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

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