

## Technical Data Sheet

**Type:** Aliphatic polycaprolactone based Thermoplastic Polyurethane (TPU) with a 90 Shore A Hardness.

**Features:** Clear resin with excellent colour stability upon UV exposure.

**Uses:** Cast film extrusion, profile extrusion.

Physical Properties	Value (Metric)	Unit	Test Method
Hardness (3 sec)	A/3: 90	Shore A	ISO 868
Specific Gravity	1.13	g/cm <sup>3</sup>	ISO 2781
Tensile Strength	40-45	MPa	ISO 527-2
Ultimate Elongation	500-550	%	ISO 527-2
Tensile Stress at:			ISO 527-2
- 100 % Elongation	7-9	MPa	ISO 527-2
- 300 % Elongation	18-21	MPa	ISO 527-2
Abrasion Loss	35	mm <sup>3</sup>	ISO 4649
Moisture Content	< 0.1	%	MQSA 44

- Based on extruded films
- Prior to testing samples were conditioned at 23°C for 24 hours

## Supply Form and Standard Packaging

- **ESTANE® 91F88 EXP** is supplied in pellet form and packaged in 25 kg (x lb) bags or 700-800 kg boxes (x-y lbs).

## Material Preparation

- Prior to processing, **ESTANE® 91F88 EXP** must be dried at 60°C for 4 hours.
- It is recommended to dry the material in a vacuum or dehumidifying type dryer. Target dew point should be -40°C.
- Depending on the applied processing technique, the maximum moisture level should be 0.02%.

## Material Preparation

- **ESTANE® 91F88 EXP** can be processed on any conventional extruder:

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**Recommended EXTRUSION Temperature Profile:**

	°C
<b>Zone 1</b>	<b>165-175</b>
<b>Zone 2</b>	<b>175-185</b>
<b>Zone 3</b>	<b>175-185</b>
<b>Zone 4</b>	<b>185-195</b>
<b>Adapter (5)</b>	<b>185-195</b>
<b>Die Zone 1 (6)</b>	<b>190-200</b>
<b>Die Zone 2</b>	<b>190-200</b>

**For further information refer to Lubrizol Advanced Materials processing guides.**

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