

## Technical Data Sheet

**Type:** ESTANE® ECO 16T85 is a 85 shore A bio-based Thermoplastic Polyurethane (TPU).

**Features:** Good transparency and UV stabilized clear TPU.

**Uses:** Injection molding.

Physical Properties	Value (Metric)	Unit	Test Method
Hardness (5 sec)	85 +/-3	Shore A	ISO868
Specific Gravity	1.14	-	ASTM D-792
Tensile Strength	32	Mpa	ASTM D-412
Ultimate Elongation	614	%	ASTM D-412
Tensile Stress at:			
- 100 % Elongation	6	Mpa	ASTM D-412
- 300 % Elongation	10	Mpa	ASTM D-412
Tear Strength			
Graves	101	KN/m	ASTM D-624
Abrasion	70	Ccloss	ISO4649

**Remark:**

- Based on 2mm injection part.
- Prior to testing samples were conditioned at 23°C for 48 hours.
- Listed values are "typical (average) values" and should/cannot be applied for specification purposes.

## Supply Form and Standard Packaging

- ESTANE® ECO 16T85 is supplied in pellet form and packaged in 25 Kgs bags.

## Material Preparation

- Prior to processing, ESTANE® ECO 16T85 must be dried at 100°C for 4-6 hours.
- It is recommended to dry the material in a desiccant type dryer. Target dew point should be -40°C.
- The maximum appropriate moisture rate for injection molding is 0.05% (500ppm).

## Material Preparation

- ESTANE® ECO 16T85 can be used in a normal injection molding machine.

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**Recommended Starting injection Temperature Profile:**

	°C
<b>Zone 1</b>	<b>190</b>
<b>Zone 2</b>	<b>195</b>
<b>Zone 3</b>	<b>200</b>
<b>Zone 4</b>	<b>200</b>
<b>Adapter</b>	<b>205</b>
<b>Die Zone 1</b>	<b>205</b>
<b>Die Zone 2</b>	<b>205</b>

For further information refer to Lubrizol Advanced Materials processing guides.

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