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# Pellethane® 8663-85A-B20

Type: Medical Grade Aromatic polyether-based thermoplastic polyurethane (TPU) with 20% loading of Barium Sulfate

Features: Good mechanical properties, good chemical resistance, radiopaque

Process: Extrusion or Injection Molding

Products & Properties	Value (Metric)	Unit	Test Method
Durometer Shore Hardness (5 sec)*	86	Shore A	ASTM D-2240
Specific Gravity	1.31	g/cm^3	ASTM D-792
Ultimate Tensile Strength*	26	MPa	ASTM D-412
Ultimate Elongation*	650	%	ASTM D-412
Tensile Modulus*			
at 100% Elongation	5.5	MPa	ASTM D-412
at 200% Elongation	6.5	MPa	ASTM D-412
at 300% Elongation	8.0	MPa	ASTM D-412

Note: 1. \*These test results are based on 3.0mm injection molded specimen, unannealed.

2. Listed values are "typical (average) values" and should/cannot be applied for specification purposes. This information should not be used for establishing engineering or manufacturing guidelines.

**Handling Conditions:** Properties of all thermoplastic polyurethane products in the molten state are adversely affected by moisture. For best results, always dry the material at least two hours at 85-95°C (200°F) in a machine mounted dehumidifying dryer (a desiccant dryer delivering air at 1 liter/sec/ kg at -40°C dew point (1 cfm/lb at -40°F dew point)). A dehumidifying dryer hopper or one shot loader is also recommended. Depending on the applied processing technique, the maximum moisture level should be 0.02%. Never exceed 500°F (260°C) melt temperature!

Processing Conditions: Pellethane® 8663-85A-B20 can be processed on any conventional extruder or molder.



IFE SCIENCE 9911 Brecksville Road, Cleveland, OH 44141-3201 USA

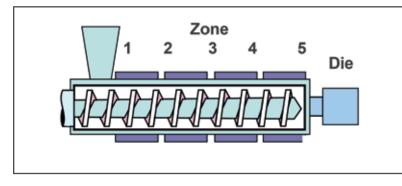
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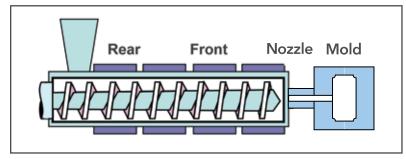
### **Recommended Starting Extrusion Temperature Profile:**



	°F/°C
Zone 1	375/191
Zone 2	385/196
Zone 3	395/202
Zone 4	400/204
Adapter 5	410/210
Die	410/210

Screen Pack Recommendation: 100/250/100 mesh

## **Recommended Starting Injection Molding Temperature Profile:**



	°F/°C	
Rear	365/185	
Front	375/191	
Nozzle	385/196	
Melt	<420/<215	
Mold	50-110/10-43	

Please refer to Lubrizol's processing guide(s) for more information regarding proper drying, equipment and process design.

Further guidance is available on the LLS Health Resource Hub or by contacting our technical solutions team.



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