



Aliphatic Carbothane™ PC Series TPU

20% Barium Sulfate Filled Thermoplastic Polyurethane

Type: Radiopaque (20% BaSO₄ filled) medical grade polycarbonate-based aliphatic Thermoplastic Polyurethanes (TPUs)

Features: This series exhibits excellent oxidative stability in blood contact, inherently resists yellowing by aging and sterilization, and provides good mechanical performance. The inclusion of 20% (by weight) barium sulfate (BaSO₄) in the material provides radiopaque properties.

Process: Extrusion and injection molding

Products & Properties	ASTM Test	PC-3575A-B20	PC-3585A-B20	PC-3595A-B20	PC-3555D-B20	PC-3572D-B20
Durometer (Shore Hardness)	D2240	75A	80A	92A	52D	71D
Specific Gravity	D792	1.35	1.35	1.35	1.35	1.35
Ultimate Tensile (psi)	D412	7200	8700	9400	9400	9200
Ultimate Elongation (%)	D412	530	410	400	375	300
Tensile Modulus (psi)	D412					
at 100% Elongation		300	800	1200	375	3800
at 200% Elongation		625	1500	1200	1975	3800
at 300% Elongation		1450	4100	4900	6400	8800
Flexural Modulus (psi)	D790	2000	2200	6,800	22,000	135,000
Vicat Temperature (°C)	D1525	47	56	53	57	63
Mold Shrinkage (in/in) (1"x.25"x6" bar)	D955	0.010	0.010	0.010	0.008	0.008

Note: These test results are based on small samples of Carbothane™ polyurethanes and do not necessarily represent average results from larger test samples. This information should not be used for establishing engineering or manufacturing guidelines or specifications.



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

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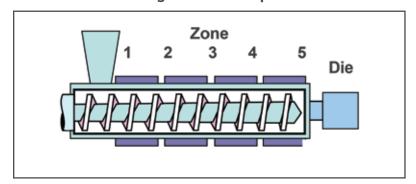




Handling Conditions: Properties of all thermoplastic polyurethane products in the molten state are adversely affected by moisture. For the best results, always dry the material at least two hours at 65°C (150°F) or overnight at 57°C (135°F) in a machine mounted dehumidifying dryer (a desiccant dryer 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 0.05%**. Never to exceed 500°F (260°C) melt.

Processing Conditions: Aliphatic Carbothane™ TPUs can be processed on any conventional extruder or molder. Please refer to Lubrizol's <u>processing guides</u> for medical TPUs for further recommendations regarding equipment and process design.

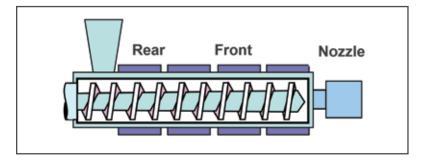
Recommended Starting Extrusion Temperature Profile:



	PC- 3575A-B20	PC- 3585A-B20	PC- 3595A-B20	PC- 3555D-B20	PC- 3572D-B20
	°F/°C	°F/°C	°F/°C	°F/°C	°F/°C
Zone 1	360/182	360/182	360/182	380/193	380/193
Zone 2	370/188	370/188	370/188	390/199	390/199
Zone 3	380/193	380/193	380/193	400/204	400/204
Zone 4	390/199	390/199	390/199	410/210	410/210
Adapter 5	400/204	400/204	400/204	420/216	420/216
Die	400/204	400/204	400/204	420/216	420/216

Screen Pack Recommendation: 100/250/100 mesh

Recommended Starting Injection Molding Temperature Profile:



	PC- 3575A-B20	PC- 3585A-B20	PC- 3595A-B20	PC- 3555D-B20	PC- 3572D-B20
	°F/°C	°F/°C	°F/°C	°F/°C	°F/°C
Rear	392/200	392/200	392/200	410/210	428/220
Front	410/210	410/210	410/210	428/220	446/230
Nozzle	428/220	428/220	428/220	446/230	464/240
Melt	410/210	410/210	410/210	428/220	446/230
Mold	50-80/10-27	50-80/10-27	50-80/10-27	50-100/10-38	60-110/16-43

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



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