



Lubrizol LifeSciences

Carbothane® TPU – Clear Aliphatic

Type: Medical Grade Aliphatic Polycarbonate-based Thermoplastic Polyurethanes (TPUs)

Features: Variety of hardnesses, offers an inherent ultraviolet (UV) stability that resists yellowing by aging and sterilization, good mechanical properties excellent oxidative stability and biocompatibility properties and can be color-matched

Process: Extrusion and Injection Molding

Products & Properties	ASTM Test	PC-3575A	PC-3585A	PC-3595A	PC-3555D	PC-3572D
Durometer (Shore Hardness)	D2240	70A	80A	90A	50D	69D
Specific Gravity	D792	1.15	1.15	1.15	1.15	1.15
Ultimate Tensile (psi)	D412	7200	8300	9600	9700	9600
Ultimate Elongation (%)	D412	600	425	400	325	325
Tensile Modulus (psi)	D412					
at 100% Elongation		350	600	1050	1750	3500
at 200% Elongation		500	1100	2250	3100	5400
at 300% Elongation		2000	4000	6400	6800	9200
Flexural Modulus (psi)	D790	1600	1470	6400	19300	134000
Vicat Temperature (°C)	D1525	46	58	62	51	63
Mold Shrinkage (in/in) (1"x.25"x6" bar)	D955	0.010	0.010	0.010	0.008	0.008
Glass Transition Temperature	DSC	-29	-27	-25	-25	NA

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.

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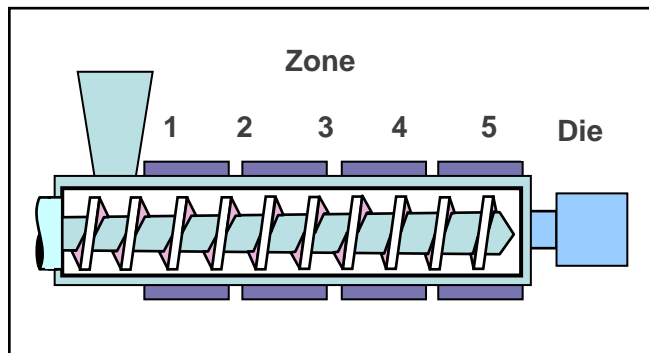
Handling Conditions:

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 four 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 temperature.

Processing Conditions:

Carbothane® Aliphatic TPU's can be processed on any conventional extruder or molder.

Recommended Starting Extrusion Temperature Profile:

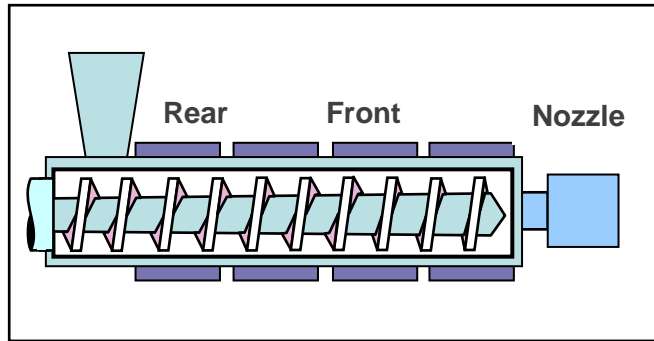


Screen Pack Recommendation: 100/500/250

	PC-3575A	PC-3585A	PC-3595A	PC-3555D	PC-3572D
	°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

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Recommended Starting Injection Molding Temperature Profile:



	PC-3575A	PC-3585A	PC-3595A	PC-3555D	PC-3572D
	°F/°C	°F/°C	°F/°C	°F/°C	°F/°C
Rear	365/185	365/185	375/190	375/190	375/190
Front	375/190	375/190	385/196	385/196	385/196
Nozzle	385/196	385/196	395/202	395/202	395/202
Melt	385/196	385/196	395/202	395/202	395/202
Mold	50-80/10-27	50-80/10-27	50-80/10-27	50-100/10-38	60-110/16-43

For Further information, refer to Lubrizol Advanced Materials processing guides.

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