

**EPAMOULD 69.A1.** is a polyester based thermoplastic polyurethane, particularly suitable for the injection moulding of shoe soles and engineered parts

### **Typical properties**

Density	ISO 1183	1.19 Kg/dm <sup>3</sup>
Hardness	ISO 868	92 Shore A 41 Shore D
Tensile strength	EN 12803	40 MPa
Stress @ 100% elongation	EN 12803	7.0 MPa
Stress @ 300% elongation	EN 12803	10 MPa
Elongation at break	EN 12803	400 %
Tear strength	ISO 34	80 KN/m
Abrasion resistance	EN 12770	3.0 mm <sup>3</sup>

Alfa Polymer Kimia

The values quoted have been measured using standard test specimens at room temperature. The figures should be considered as indicative values only and not as binding minimum values.

Actual properties of TPU parts can be affected to a considerable extent by the design of the mould, the processing conditions and the additives used. For these reasons they have to be determined on the actual TPU articles on a statistical bases. Full-scale testing and end product performance are full responsibility of the user.

### **Packaging and storage**

EPAMOULD 69.A1. is supplied in 20 kg PE bags. Depending on actual transport conditions pallets can be composed by 30 or 40 bags (870 or 1000 Kg). Epamould TPUs may be stored for 12 months from the date of shipment, sealed in the original package.

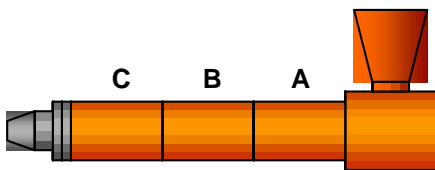
### **Material preparation**

To ensure trouble free processing and high quality injection moulded parts it is preferable to dry EPAMOULD 69.A1 before use. The recommended drying conditions are 4 hours at 90°C in a desiccant dryer.

### **Equipment**

Standard injection moulding machines with general purpose screws of 40 to 60 mm diameter and an L/D ratio of 20 : 1 to 30 : 1 are normally suitable for the injection moulding of EPAMOULD 69.A1.

### **Recommended injection moulding parameters**

INJECTION TEMPERATURES			
	ZONE A	°C	200 - 210
	ZONE B	°C	200 - 220
	ZONE C	°C	200 - 210
	NOZZLE	°C	190 - 210
BACK PRESSURE		bar	20 - 60
MOULD TEMPERATURE		°C	20 - 30

### **Health and safety advice**

People handling this product must be informed of all the necessary precautions that must be taken. These are detailed in the relevant Material Safety Data Sheet which will be provided by Epaflex Polyurethanes srl.

The information contained herein is believed to be reliable but, no representations, guarantees of any kind are made as to its accuracy, suitability for particular applications or the results to be obtained therefrom. It is imperative that the users test our products, technical assistance and information, to determine to their own satisfaction whether they are suitable for their intended use and applications. All information, technical assistance and advice are provided without warranty or guarantee, and is subject to change without notice. Nothing herein shall be construed as a recommendation or permission to practice any patented invention without permission of the patent owner

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