

PEARLCOAT[®] Activa D118K

Thermoplastic Polyurethane Elastomer

PROVISIONAL TECHNICAL DATA SHEET

PEARLCOAT[®] Activa D118K is a special copolyester based thermoplastic polyurethane of low hardness, supplied in form of natural pellets. This product gives an inherent "low gloss aspect" on the final product surface after extrusion processing. Featuring low gel content as well as low-temperature flexibility, it is ideally suited for extrusion or co-extrusion onto polar substrates.

TYPICAL PHYSICAL PROPERTIES

Physical Property	Test Method	Typical Values *
Specific gravity	ASTM D-792	1.05
Shore Hardness	ASTM D-2240	70 A
Tensile Strength	ASTM D-412	3632 psi
Modulus @ 100% Elongation	ASTM D-412	436 psi
Modulus @ 300% Elongation	ASTM D-412	872 psi
Elongation @ Break	ASTM D-412	580 %
Abrasion Loss	DIN 53.516	60 mm ³
Melting Range (MFI=10)	MQSA 111	320-338 °F
Tg. (DSC, 10°C / min.)	DIN 51.007	- 45 °F

* These are typical values & should not be used for establishing specifications.

** Temperature at which MFI = 10 g/10 min @ 21.6 kg.

APPLICATIONS

PEARLCOAT[®] Activa D118K is ideally used for extrusion, co-extrusion onto polar substrates applications where low gloss aspect is required.

WORKING INSTRUCTIONS

In accordance with our experience, the characteristics of the extruder that are suitable for processing **PEARLCOAT[®] Activa D118K** are the following:

1. L/D ratio between 25:1 and 30:1
2. The extruder screw must have 3 zones and a compression ratio in between 2:1 and 3:1 (usually, the screws that are used for Polyethylene extrusion give good results).
3. The extruder screw should have a continuous regulation device and a working power higher than for processing other plastics.
4. The speed of the extruder should be low (12 to 60 rpm, depending on its diameter), so as to avoid material degradation due to shearing.
5. The filters used should be disks with holes of $\frac{1}{16}$ to $\frac{3}{16}$ in. (depending on the screw and the die), and screen packs (the nr. of meshes /cm² will depend on the end product which is processed), so as to create a pressure built-up.

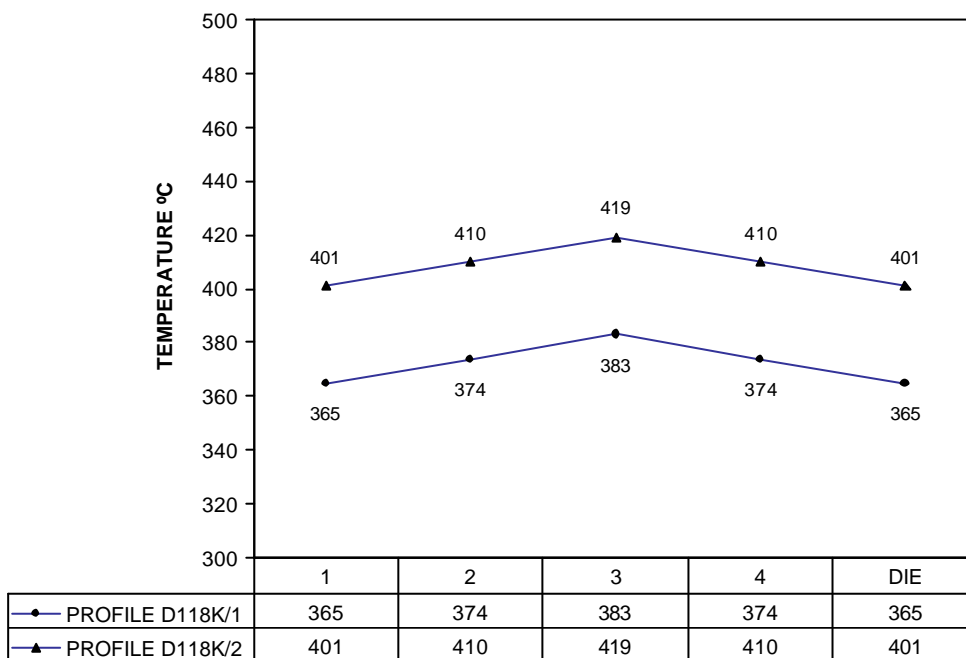
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For optimum results, previous drying of the product during 2 hours at 194-212° F is advisable, in a hot air circulatory, vacuum or desiccant-air dryer.

The suggested processing-temperature profiles for film extrusion (flat film) are depicted in the figure below.



EXTRUDER & CONDITIONS
 TYPE.- 30/25D (L/D=25:1), COOLING.- Air, SCREW.- 3:1, SPEED.- 50 rpm
 BREAKER PLATE.- ---. FILTER PACK.- ---. THICKNESS DIE.- 0.2 mm. PRE-DRYING.- 1h @221 °F

HEALTH AND SAFETY

A safety data sheet on **PEARLCOAT[®] Activa D118K** is available, with all information related to safety.

Merquinsa's Products are sold subject to Merquinsa's General Sales Conditions printed on the back of invoices and other shipping documents (available upon request). This is correct information based on our experience, and is given in good faith and without compromise. Each purchaser bears full responsibility for the application, use and processing of Merquinsa's products described herein, as well as their suitability to the purchaser's specific application, as this is beyond Merquinsa's control



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PACKAGING

PEARLCOAT® Activa D118K is packaged in heat-sealed, moisture proof multi-layer bags of 25 kg net weight made of PE/Aluminium/PE. Bags are shipped on pallets of 750 kg. Additionally; PE-lined cardboard gaylords of 700 kg net weight are available.

STORAGE

Material received from Merquinsa should be inspected to assure containers are not damaged during transportation before being stored prior to use. PEARLCOAT® Activa D118K should be kept in a cool (60-75 °F) and dry environment prior to being processed. Standard practice of consuming resin on first-in first-out basis should be employed.

For more information, please feel free to contact us at www.merquinsa.com