

PEARLTHANE® D12C75

Thermoplastic Polyurethane Elastomer

PROVISIONAL TECHNICAL DATA SHEET

PEARLTHANE® D12C75 is a polyester based TPU supplied in form of translucent, colorless pellets, specially designed for compounds in which TPU is used as an additive. Features include low softness without plasticizer and a low melting point.

TYPICAL PROPERTIES

Property	Test Method	Typical Values *
Specific gravity	ASTM D-792	1.20
Shore Hardness	ASTM D-2240	78 A
Tensile Strength	ASTM D-412	2905 psi
Elongation @ Break	ASTM D-412	745 %
Modulus @ 100% Elongation	ASTM D-412	581 psi
Modulus @ 300% Elongation	ASTM D-412	800 psi
Tear Strength	ASTM D-624 (Die C)	400 lb/in
Abrasion Loss	DIN 53.516	25 mm ³
Moisture Content	MQSA 44	< 0.1 %
Melting Range (MFI=10)**	MQSA 114	257 – 275 °F
Tg (DSC, 50°F / min.)	DIN 51.007	-26° F

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

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

WORKING INSTRUCTIONS

In accordance with our experience, the characteristics of the extruder that are suitable for processing **PEARLTHANE® D12C75** 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 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 no. of meshes /in² will depend on the end product which is processed), so as to create a pressure built-up.

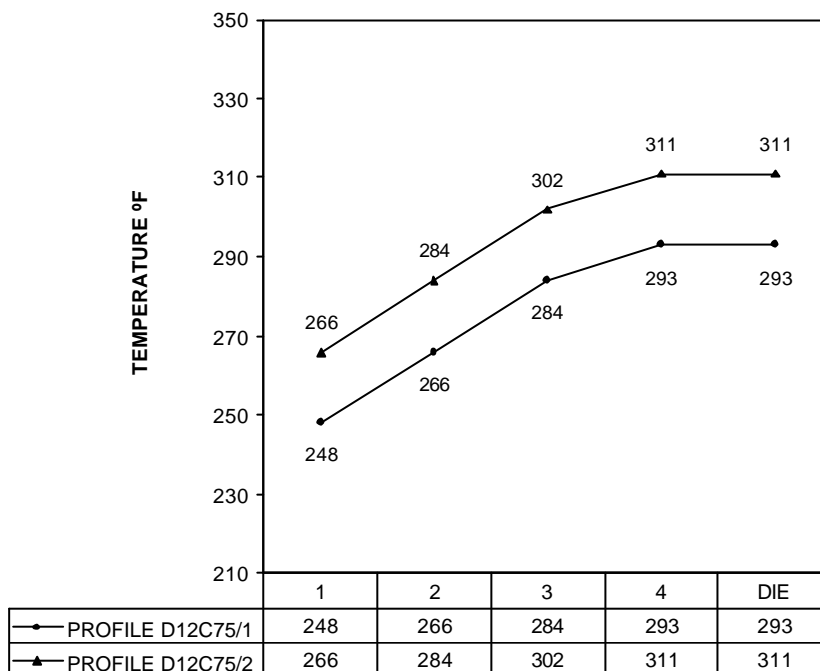
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For optimum results, previous drying of the product during 1-2 hours at 210 - 230 °F is advisable, in a hot air circulatory, vacuum or desiccant-air dryer.

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 @220 °F

APPLICATIONS

PEARLTHANE® D12C75 is intended for compounding applications of a variety engineering plastic. Please contact our technical service department for detailed information.

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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HEALTH AND SAFETY

A safety data sheet on **PEARLTHANE® D12C75** is available, with all information related to safety.

PACKAGING

PEARLTHANE® D12C75 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. **PEARLTHANE® D12C75** should be kept in a cool (60-77°F) and dry environment prior to being processed. Standard practice of consuming resin on first-in first-out basis should be employed.

Our **TECHNICAL SERVICE** will answer any inquiries about our product and its applications.