

## Wanthane® WHT-1585

**TYPE** Polyester-based grade, Injection molding and Extrusion grade

**FEATURES** Excellent mechanical properties, Good abrasion resistance and wear resistance, Short cycle times

**Applications** Shoe heels, Injection-molded engineering components, Compounding, wire & cable, etc

Typical Properties*		Test Method	Units	Values
Specific Gravity		ASTM D 792	g/cm <sup>3</sup>	1.19
Shore Hardness		ASTM D 2240	Shore A	86
Tensile Strength at 100% Elongation		ASTM D 412	MPa	> 4.5
Tensile Strength at 300% Elongation		ASTM D 412	MPa	> 8
Tensile Strength		ASTM D 412	MPa	> 30
Ultimate Elongation		ASTM D 412	%	> 650
Tear Strength		ASTM D 624	N/mm	> 90
DIN Abrasion		ISO 4649	mm <sup>3</sup>	< 75
Compression	25°C/24 h	ASTM D 395	%	< 20
Set	70°C/22 h	ASTM D 395	%	< 40

\*All these physical properties are based on injection molded samples, which are conditioned at 23 °C / 50% for 24h. Above values are typical values and should not be used as specifications.

### Disclaimer

The information provided here is for reference only. The specification will be provided in the quality certificate or in the contract. It is the user's responsibility to test the material and its suitability for a process. We have no control over what another party's action. Nor will we be responsible for any indirect damages while using our products. The user is welcome to contact our customer and technical service center with question on our products.

## Wanthane® 1585

### DRYING

Wanthane® materials are supplied pre-dried in moisture guarded bags. Dry Wanthane® will rapidly absorb moisture when exposed to atmosphere. For trouble free products, Wanthane® 1585 must be dried before processing. It is recommended to dry the material at 80-100 °C for 3-4h in a circulating air or dehumidified air dryer. The moisture content must be lower than 0.03% before and during processing.

### PACKAGING

Wanthane® 1585 is packaged in the form of uncolored transparent pellets in PE-lined bags of 25 Kg net weight (1000 Kg/pallet).

### STORAGE

Wanthane® should be inspected to assure containers are not broken during transportation. Containers should be stored in a cool and dry environment, and should be brought to room temperature before opening in order to prevent condensation. Once being used, containers with residual materials should be sealed. It is necessary to cover the feed hopper of the processing machine.

### PROCESSING RECOMMENDATIONS

Based on our experience, the features of recommended screw are the following:

1. L/D ratio between 25 and 30.
2. The appropriate compression ratio is from 1:2 to 1:3.
3. The screw extruder should have three sections which have continued constant pitch. The distance between screw and barrel should be 0.1 to 0.2 mm. Depending on the size and type of the screw and die, the breaker plates used should have holes of 1.5 to 5 mm.
4. TPU is shear sensitive, for this reason, the extruder's

speed should be low in case of degradation during processing.

### TYPICAL PROCESSING CONDITIONS

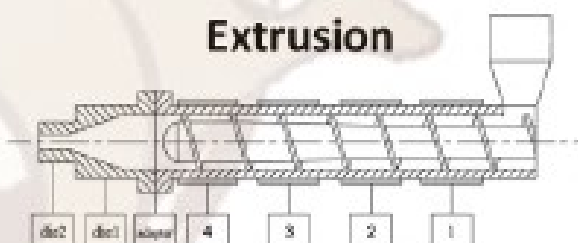
Wanthane® 1585 can be both extruded and injection molded. Typical processing conditions are listed in the following tables and figures. You can contact our [TECHNICAL SERVICE](#) for further inquiries about products or troubleshooting.

### Injection molding



	Mold	Nozzle	Zone3	Zone2	Zone1
°C	23	200	195	190	185

### Extrusion



Type: screw: 45mm, L/D: 30, compression ratio 3:1

	Die2	Die1	Adaptor	Zone4	Zone3	Zone2	Zone1
°C	190	195	200	195	190	190	185

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## HEALTH AND SAFETY

Wanthane® materials have no hazardous reactions observed. Waste can be discarded to public garbage cans. When contacting or processing this product, it is recommended that all personnel wear eye/face protection and suitable protective clothing. Any further safety information about this product is available in our [TECHNICAL SERVICE](#) centre.



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