

Elastollan® 685A10

Technical Bulletin

Polyester Type

Product Description

Elastollan® 685A10 is a polyester-based thermoplastic polyurethane (TPU). It is specifically formulated for extruded profile, sheet and film applications, and has exceptional adhesion characteristics. It is also transparent, which is unique for Elastollan® polyester products. Elastollan® 685A10 also exhibits the typical features of Elastollan® C85A: excellent abrasion resistance, toughness, oil/fuel resistance, and good hydrolytic stability.

Processing/Handling

As with all TPU products, Elastollan® 685A10 must be dried before processing. The drying step is required to both dry the granules and also maintain a low moisture content until the product enters the processing equipment. The water content must be less than 0.03% before processing. The typical drying conditions should be 2-4 hours @ 175°-195°F (80°-90°C).

Elastollan® 685A10 can be stored for up to 1 year in its original container. Containers should be stored in a cool and dry area.

Physical Properties	Units	ASTM Method	Typical Value	Suggested Starting Extrusion Temperatures	
Specific Gravity	gr/cc	D-792	1.21	Zone 1 (Feed)	355° F (180° C)
Hardness	Shore A	D-2240	85±2	Zone 2	365° F (185° C)
Tensile Strength	MPa psi	D-412	46 6670	Zone 3	375° F (190° C)
Tensile Stress @ 100% Elongation	MPa psi	D-412	5.8 840	Zone 4	385° F (195° C)
@ 300% Elongation	MPa psi		11 1600	Adapter	390° F (200° C)
Elongation @ Break	%	D-412	580	Die	385° F (195° C)
Tensile Set @ Break	%	D-412	35	Melt Temp.	380° - 390° F (195° - 200° C)
Tear Strength	kN/m pli	D-624 DIE C	103 590		
Abrasion Resistance	mg (Loss)	D-1044 (Taber)	25		

• The above values are shown as typical values and should not be used as specifications.

- *Molded plaques 0.080" thick were cured 20 hours @ 100° C before testing*

Caution:

Contact with product dusts from regrinding operations may cause temporary irritation of the eyes and the respiratory tract.

Use with local exhaust. Under hot melt processing conditions (170-230°C), wear personal protective equipment to prevent thermal burns.

First aid:*Eyes*

Flush eyes with flowing water at least 15 minutes. If irritation develops, consult a physician.

Skin

Skin contact with hot melt may cause thermal burns. Call a physician immediately.

Inhalation

If vapors generated from the hot melt process are inhaled, move to fresh air. Aid in breathing. If breathing difficulties develop, see a physician immediately.

In case of fire

Use water fog, foam, CO₂, or dry chemical extinguishing media. Fire-fighters should be equipped with self-contained breathing apparatus and turnout gear.

Disposal

Waste material, unused contents and empty containers must be disposed of in accordance with applicable local, state or federal regulations. Refer to our Material Safety Data sheet for specific disposal instructions.

In case of chemical emergency

Call CHEMTREC day or night for assistance and information concerning spilled material, fire, exposure and other chemical accidents. 800-424-9300

Attention: This product is sold solely for use by industrial institutions.

Refer to our Material Safety Data sheet regarding safety, usage, applications, hazards, procedures and disposal of this product. Consult your supervisor for additional information.

Important: While the descriptions, designs, data and information contained herein are presented in good faith and for believed to be accurate, it is provided your guidance only. Because many factors may affect processing or application/use, we recommend that you make tests to determine the suitability of a product for your particular purpose prior to use.

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