

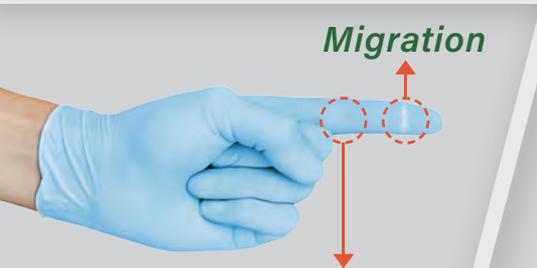


ICP DAS  
BMP

LOW MIGRATION

# Medical-grade TPU designed for thermal-setting process

## Polyether - type Low Migration TPU



Migration

Low Migration



10993-4 10993-10  
10993-5 10993-11  
10993-6 10993-23

Excellent Biocompatibility



Customized Color



### Model

- ARP-93A-B20 L
- ARP-95A-B20 L

# AROTHANE™ - ARP-B20 L Series



Arothane™ ARP-B20 L Series TPU pellets should be stored in cool and dry environment in their original containers until used. Storage temperature should not exceed 85°F/30°C.



If only a portion of TPU pellets was used, the container with the remaining TPU pellets should be tightly closed. Since aromatic-type TPU is light-sensitive, it may turn yellowish after light exposure but will not necessarily have adverse impact on the mechanical properties when stored properly.

## Products and Properties

Arothane™ ARP-B20 L Series	Durometer (Shore hardness)	Specific Gravity	Flexural Modulus (psi)	Ultimate Tensile (psi)	M100 (psi)	M300 (psi)	Ultimate Elongation (%)	Mold Shrinkage (mm/mm)
ASTM Test	D2240	D792	D790	D412				D955
ARP-93A-B20 L	93A	1.33	9,300	5,900	1,700	3,200	480	0.006-0.010
ARP-95A-B20 L	95A	1.33	13,000	5,300	2,050	4,300	420	0.006-0.010

Note: These test results are based on small samples of Arothane™ ARP-B20 L Series TPUs and do not represent the results from larger test samples. The manufacturing parameters should be adjusted according to users' actual conditions.

## Processing Information

Arothane™ ARP-B20 L Series pellets are hygroscopic and are **necessarily dried before processing**. Depending on the climate, the pellets absorb moisture rapidly when exposed to the atmosphere. The moisture might cause severe polymer degradation during processing and form bubbles or streaks in the molded and extruded and extruded parts.

To ensure the efficient and successful processing, the moisture content in TPU pellets is recommended to be **less than 0.05% (after 3 minutes at 145°C)**. A dehumidifying dryer is recommended for drying Arothane™ ARP-B20 L Series TPU. For the best drying results, the **dew point of the inlet air should not be higher than -40°F/-40°C**.

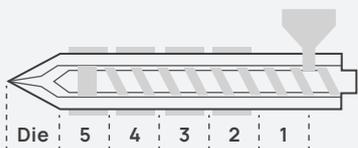
### ARP-B20 L Series products

Recommended Drying Temperature (°F) : 205 - 240

Recommended Drying Temperature (°C) : 95 - 115

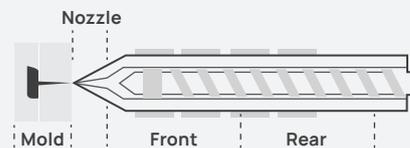
Note: Dry for a minimum of 5 hours at -40°F / -40°C dew point

## Recommended Extrusion Temperature Profile



Arothane™ ARP-B20 L Series	ARP-93A-B20 L / ARP-95A-B20 L °F / °C
Zone 1	390 / 220
Zone 2	400 / 205
Zone 3	400 / 205
Zone 4	410 / 210
Adapter 5	410 / 210
Die	400-420 / 205-215
Screen Pack Recommendation : 50 / 200 / 100	

## Recommended Injection Molding Temperature Profile



Arothane™ ARP-B20 L Series	ARP-93A-B20 L / ARP-95A-B20 L °F / °C
Rear	375 / 190
Front	385 / 195
Nozzle	390 / 200
Melt	430-445 / 220-230
Mold	75-105 / 20-40