

Technical Data Sheet

Type: Pearlthane® 11H94 is a polycaprolactone copolyester-based thermoplastic polyurethane.

Main application: Injection Moulding

Physical Properties	Value (Metric)	Unit	Test Method
Hardness	A/1: 95	Shore A/D	ISO 868
Specific Gravity	1.18	g/cm ³	ISO 2781
Tensile Strength	42	MPa	ISO 527-2/5A/500
Ultimate Elongation	515	%	ISO 527-2/5A/500
Tensile Stress at:			
- 50 % Elongation	10	MPa	ISO 527-2/5A/500
- 100 % Elongation	12	MPa	ISO 527-2/5A/500
- 300 % Elongation	23	MPa	ISO 527-2/5A/500
Compression Set:			
- 22 h / 70°C	32	%	ASTM 395B
- 70h / 70°C	40	%	ASTM 395B
Tear Strength nicked	135	kN/m	ISO 34-1B
Abrasion Resistance	35	mm ³	ISO 4649-A
Vicat Softening Point	127	°C	ISO 306 (A50)

See reverse side for processing information

* Based on extruded strips

Listed values are “typical (average) values” and should /cannot be applied for specification purposes

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Material Preparation

Prior to processing, **Pearlthane® 11H94** be dried at **100°C** for 3-4 hours.
It is recommended to dry the material in a dehumidifying type dryer.
Target dew point should be **-40°C**.

Recommended Starting INJECTION MOULDING Temperature Profile:

	°C
Feed zone	40
Zone 1	210
Zone 2	215
Zone 3	225
Zone 4	225
Nozzle	225

For further information refer to Lubrizol Advanced Materials processing guides.

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